DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-019644
Date Inspected: 26-Jan-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name:	Qiu Wen			**CWI Present:**	☑ Yes	☐ No	
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG Components

Summary of Items Observed:
On this day CALTRANS OSM Quality Assurance (QA) Inspector, Anand Upadhye was present during the times noted above for observations relative to the work being performed.

NDT
BAY 19

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted notification number 08295.
Magnetic Particle Testing (MT).

This QA inspector performed MT of approximately 15 % of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated MT report for this date. The member is identified as OBG Suspender Bracket. The weld designations reviewed are as follows:

SB024-108-001, 014, 022, 101, 021, 013, 020.

WELDING
This QA Inspector observed the following work in progress:

BAY 14
This QA Inspector observed ZPMC qualified welding personnel identified as 045270 perform welding by

Submerged Arc Welding (SAW), on OBG Segment 13BW. Weld joint is identified as SEG3014- 009. ZPMC Quality Control (QC) Inspector identified as Sun Tian Liang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-223(2)1T-ESAB-1. See attached picture.

This QA Inspector observed ZPMC qualified welding personnel identified as 037840 perform welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 13CW. Weld joint is identified as DP3148-001- 256. ZPMC Quality Control (QC) Inspector identified as Sun Tian Liang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM. See attached picture.

This QA Inspector observed ZPMC qualified welding personnel identified as 037932 perform repair welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 13CW. Weld joint is identified as SEG3015F- 293. ZPMC Quality Control (QC) Inspector identified as Sun Tian Liang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and welding repair report B-WR20190.

This QA Inspector observed ZPMC qualified welding personnel identified as 066236 perform welding by Flux Cored Arc Welding (FCAW), on OBG Segment 14W. Weld joint is identified as SEG3020W- 186. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2231-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 067609 perform welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 14W. Weld joint is identified as SEG3020AY-041, 045. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM.

This QA Inspector observed ZPMC qualified welding personnel identified as 067942 perform repair welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 14W. Weld joint is identified as SEG3020BB-001. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and welding repair report B-WR20146.

This QA Inspector observed ZPMC qualified welding personnel identified as 037779 perform welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 14W. Weld joint is identified as DP3169-001-118. ABF Quality Assurance (QA) Inspector identified as Shao Jian Yuan was present to monitor the welding process. The welding variables recorded by ABF QA appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM.

This QA Inspector observed ZPMC qualified welding personnel identified as 069493 perform welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 14W. Weld joint is identified as DP3171-001-412. ABF Quality Assurance (QA) Inspector identified as Shao Jian Yuan was present to monitor the welding process. The welding variables recorded by ABF QA appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, phone: 15000422372 , who represents the Office of Structural Materials for your project.

Inspected By:	Upadhye,Anand	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer