

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020247**Date Inspected:** 01-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wei**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 COMPONENT**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Subhasis Bera was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

In process Inspection

Bay#14

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG Segment 14W ,weld No.DP3169-001-018. The welder is identified as #067888. ABF QC is identified as Mr. Shao Jian Yuan. The welding variables recorded by QC appear to comply with WPS-B-T-2232-ESAB. The welding variables were recorded at, Amperage 270, volts 25.2 .The In-process FCAW appears to be progressing in compliance with approved contract documents.

FCAW in the 2G position for the OBG Segment 13BW ,weld No.SEG3014H. The welder is identified as #201583. ABF QC is identified as Mr. Shao Jian Yuan. The welding variables recorded by QC appear to comply with WPS-B-T-2232-ESAB. The welding variables were recorded at, Amperage 267, volts 24.6 .The In-process FCAW appears to be progressing in compliance with approved contract documents.

SMAW in the 2G position for the OBG Segment 14W, UT repair weld No.SEG3020D-052. The welder is identified as #066398. ABF QC is identified as Mr. Wang Jian Hua. The welding variables recorded by QC appear

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to comply with WPS-345-SMAW-2G(2F)-FCM-REPAIR-1. The weld repair report is identified as CWR2734. The welding variables were recorded at, Amperage 234, volts 23.6 .The In-process SMAW appears to be progressing in compliance with approved contract documents.

FCAW in the 2G position for the OBG Segment 14W ,weld No.DP3169-001-266. The welder is identified as #203781. ABF QC is identified as Mr. Shao Jian Yuan. The welding variables recorded by QC appear to comply with WPS-B-T-2232-ESAB. The welding variables were recorded at, Amperage 280, volts 24.6 .The In-process FCAW appears to be progressing in compliance with approved contract documents.

FCAW in the 2G position for the OBG Segment 14W ,weld No.DP3170-001-165. The welder is identified as #066239. ABF QC is identified as Mr. Sen Jian. The welding variables recorded by QC appear to comply with WPS-B-T-2232-ESAB. The welding variables were recorded at, Amperage 287, volts 24.5 .The In-process FCAW appears to be progressing in compliance with approved contract documents.

SMAW in the 2G position for the OBG Segment 14W ,weld No.DP3173-001-287. The welder is identified as #067707. ABF QC is identified as Mr. Sen Jian. The welding variables recorded by QC appear to comply with WPS-B-P-2212-Tc-U4b-FCM-1. The welding variables were recorded at, Amperage 227, volts 23.1 .The In-process FCAW appears to be progressing in compliance with approved contract documents.

SMAW in the 2G position for the OBG Segment 14W ,weld No.DP3174-001-252. The welder is identified as #069493. ABF QC is identified as Mr. Sen Jian. The welding variables recorded by QC appear to comply with WPS-B-P-2212-Tc-U4b-FCM-1. The welding variables were recorded at, Amperage 225, volts 22.5.The In-process FCAW appears to be progressing in compliance with approved contract documents.

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 150-0042-2372, who represents the Office of Structural Materials for

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your project.

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<b>Inspected By:</b>	Bera,Subhasis	Quality Assurance Inspector
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<b>Reviewed By:</b>	Dsouza,Christopher	QA Reviewer
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