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

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 99.28

# WELDING INSPECTION REPORT

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

**Report No:** WIR-021686
**Date Inspected:** 11-Mar-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

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|---|---|---|---|---|---|---|---|
| **CWI Name:** | Tian Lei, Liu Fa 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

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

Bay Number 1

FCAW welding of complete joint penetration welds located on Traveler Rails component identified as 20TR2-044 as identified on weld repair data sheet B-WR-20365 for repaired complete joint penetration welds identified as weld no.(s): 011 & 013. Welder is identified as welder no. 054467. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-345-SMAW-1G(1F)-Repair.

FCAW welding of complete joint penetration welds located on Traveler Rails component identified as 20TR2-044 as identified on weld repair data sheet B-WR-20365 for repaired complete joint penetration welds identified as weld no.(s): 019. Welder is identified as welder no. 049769. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-345-SMAW-1G(1F)-Repair.

SMAW welding of complete joint penetration welds located on Traveler Rails component identified as 20TR2-037 as identified on weld repair data sheet B-WR-20367 for repaired complete joint penetration welds identified as weld no.(s): 011. Welder is identified as welder no. 057795. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-345-SMAW-1G(1F)-Repair.

FCAW welding of complete joint penetration welds located on Traveler Rails component identified as 20TR2-036 as identified on weld repair data sheet B-WR-20368 for repaired complete joint penetration welds identified as weld no.(s): 011. Welder is identified as welder no. 054467. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-345-SMAW-1G(1F)-Repair.

FCAW welding of complete joint penetration welds located on Traveler Rails component identified as 20TR2-036 as identified on weld repair data sheet B-WR-20368 for repaired complete joint penetration welds identified as weld no.(s): 017. Welder is identified as welder no. 049769. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-345-SMAW-1G(1F)-Repair.

Bay Number 3

FCAW welding of complete joint penetration welds located on Architectural Housing component identified as AH3152 weld no.(s) 001 & 002. Welder is identified as welder no. 067601. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

Bay Number 8

FCAW welding of complete joint penetration welds located on Bike Path component identified as BK004A6-062 weld no.(s) 070, 078, 088, & 098. Welder is identified as welder no. 500405. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2232-ESAB.

FCAW welding of complete joint penetration welds located on Bike Path component identified as BK004A8-062 weld no.(s) 070, 078, 088, & 098. Welder is identified as welder no. 046706. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2232-ESAB.

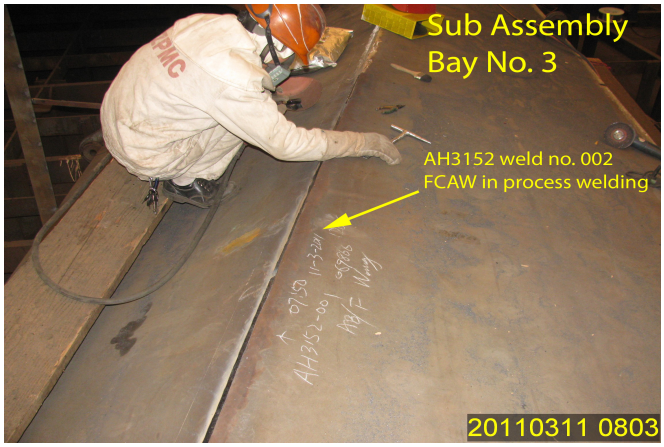
This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. All components were as listed on NWIT notification no. 08511. The member(s) is/are identified as Tower Skirt identified as component WDH-0-1.2 with the following weld no.(s):

1. WDH-0-1.2-001, 002, 003, & 004.

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents

# WELDING INSPECTION REPORT

*( Continued Page 3 of 3 )*



**Summary of Conversations:**

Pertinent conversations are included in the body of the report.

**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 1500-0042-02372, who represents the Office of Structural Materials for your project.

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|---|---|---|
| **Inspected By:** | Hernandez,Rene | Quality Assurance Inspector |
| **Reviewed By:** | Hall,Steven | QA Reviewer |