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 #: 69.28

WELDING INSPECTION REPORT

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

Report No: WIR-023309
Date Inspected: 09-Apr-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: 1500
OSM Departure Time: 300
Location: Shanghai, China

CWI Name:	Mr. Geng 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 Segment Assembly

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

OBG Segment 13BE / Bay 14

This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated MT report for this date. The member is identified as OBG Segment 13BE welds as per ZPMC notification # 08781.

The weld designations reviewed are as follows:

SEG3009B-006, 007
SEG3009D-006, 007

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:
Flux Core Arc Welding (FCAW) in the 2G position of weld # SEG3019V-005. The welder is identified as 067079. Quality Control (QC) is identified as Lv Li Qing. The welding variables recorded by QC appeared to comply with WPS- B-T-2232-ESAB.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:
Sub Arc Welding (SAW) in the 1G position of Deck Panel weld # SEG3011-008. The welder is identified as 215993. Quality Control (QC) is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

OBG Segment 13BE / Bay 14

This QA Inspector observed the following work in progress:
Shielded Metal Arc Welding (SMAW) in the 3G position of sp 'I' rib to FB weld # SEG3011H-110. The welder is identified as 051359. Quality Control (QC) is identified as Lv Li Qing. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-TC-U4b-FCM-1.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:
Flux Core Arc Welding (FCAW) in the 2G position of weld # SEG3019G-019. The welder is identified as 055491. Quality Control (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS- B-T-2232-ESAB.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:
Shielded Metal Arc Welding (SMAW) in the 3G position of weld # SEG3019V-011. The welder is identified as 044772. Quality Control (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-B-U3b-FCM-1.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:
Shielded Metal Arc Welding (SMAW) in the 3G position of weld # SEG3019R-011. The welder is identified as 050102. Quality Control (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-B-U3b-FCM-1.

OBG Segment 13CE / Bay 14

This QA Inspector observed the following work in progress:
Sub Arc Welding (SAW) in the 1G position of Deck Panel weld # SEG3019*-004. The welder is identified as 215993. Quality Control (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with. See attached photograph Pic_001.

WELDING INSPECTION REPORT

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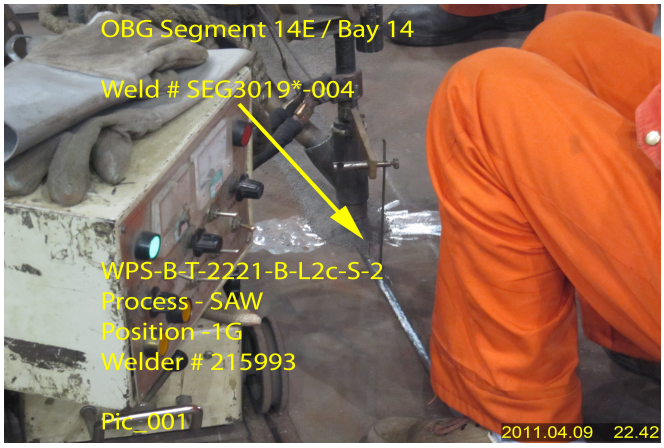

Summary of Conversations:

No relevant conversations reported on this date.

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 (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Gade,Ramesh	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer