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-023310
Date Inspected: 08-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 13CE / 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 13CE welds as per ZPMC notification # 08774.

The weld designations reviewed are as follows:

SEG3011C-004, 005
SEG3011J-004, 005

OBG Segment 13BE / Bay 14

This QA Inspector observed the following work in progress:
Shielded Metal Arc Welding (SMAW) in the 3G position of repair weld # SEG3009B-002, as per B-WR # 20492. The welder is identified as 051359. Quality Control (QC) is identified as Wang Xu. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3g(3F)-FCM-Repair.

OBG Segment 14E / Bay 14

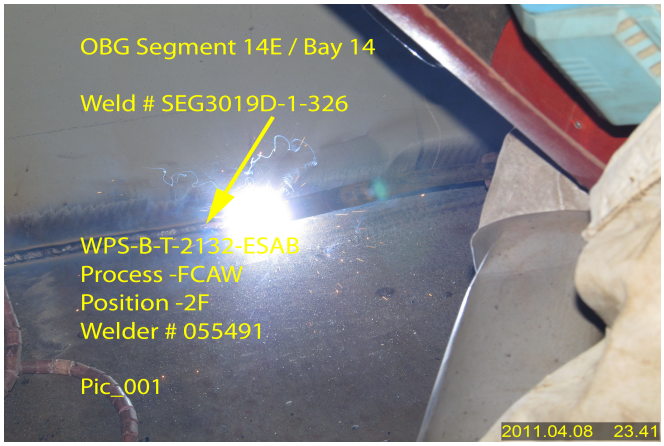
This QA Inspector observed the following work in progress:
Flux Core Arc Welding (FCAW) in the 2F position of weld # SEG3019D-1-326. The welder is identified as 055491. Quality Control (QC) is identified as Lv Li Qing. The welding variables recorded by QC appeared to comply with WPS- B-T-2132-ESAB. See attached photograph Pic_001.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:
Shielded Metal Arc Welding (SMAW) in the 4G position of repair weld # SEG3019BB-045, as per B-CWR # 2917. The welder is identified as 216086. Quality Control (QC) is identified as Lv Li Qing. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-FCM-repair.

OBG Segment 13BE / Bay 14

This QA Inspector observed the following work in progress:
Shielded Metal Arc Welding (SMAW) in the 2G position of repair weld # SEG3019Q-1-105, as per B-WR # 20602. The welder is identified as 058102. Quality Control (QC) is identified as Lv Li Qing. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G(2F)-FCM-Repair.



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

WELDING INSPECTION REPORT

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Reviewed By: McClendon,Timothy QA Reviewer