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

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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-023435
Date Inspected: 29-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: 700
OSM Departure Time: 1900
Location: Shanghai

CWI Name: Tian Lei, Liu Fa Wen, Chen Shigang

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

CWI Present: ☑ Yes ☐ No

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

This inspector observed ZPMC personnel welding of components identified as Lift 13 & 14 lifting frame beam.

This inspector generated an incident report for ZPMC personnel applying excessive heat to Bike Path Handrail component identified as BKR-NS-3-PP88.

Bay Number 5

FCAW welding of complete joint penetration welds located on Traveler Rails component identified as 3023TR1-002 as identified on weld repair data sheet B-WR-20869 for repaired complete joint penetration welds identified as weld no.(s): 011. Welder is identified as welder no. 219414. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-345-FCAW-3G(3F)-repair-ESAB.

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) traveler rail member identified as

3023TR1-002 for weld(s) 001~016. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Tian Lei was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) no. HSR(B)-10291.

This inspector observed ABF QA personnel performing MT testing and inspection of traveler rail member identified as 3025TR1-003 for weld(s) 001~016.

Bay Number7

This inspector did not observe any work being performed in this bay today.

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Bay Number 8

This inspector did not observe any work being performed in this bay today.

Bay Number 9

This QA inspector performed VT of approximately 100% of the area previously visually inspected and accepted by ZPMC Quality Control personnel. All components were as listed on NWIT notification no. 08976. The member(s) is/are identified as OBG Bike Path Handrail components identified below with the following identifying weld no.(s):

1. BKR-NS-13 (PP127~PP128).
2. BKR-NS-15 (PP115~PP117).
3. BKR-NS-04 (PP9~PP11).
4. BKR-NS-14 (PP123~PP125).
5. BKR-NS-25 (PP5.5~PP7.5).
6. BKR-NS-20 (PP109~PP111).

FCAW welding of complete joint penetration welds located on Traveler Rail component identified as 3003TR2-001 weld no.(s) 026. Welder is identified as welder no. 059421. The welding variables recorded by ZPMC QC identified as Chen Shigang appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

FCAW welding of complete joint penetration welds located on Traveler Rail component identified as 3003TR2-001 weld no.(s) 025. Welder is identified as welder no. 203805. The welding variables recorded by ZPMC QC identified as Chen Shigang appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

This inspector observed ZPMC personnel performing UT inspection and trsting of complete joint penetration welds located on Traveler Rail 3013TR1-002.

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

WELDING INSPECTION REPORT

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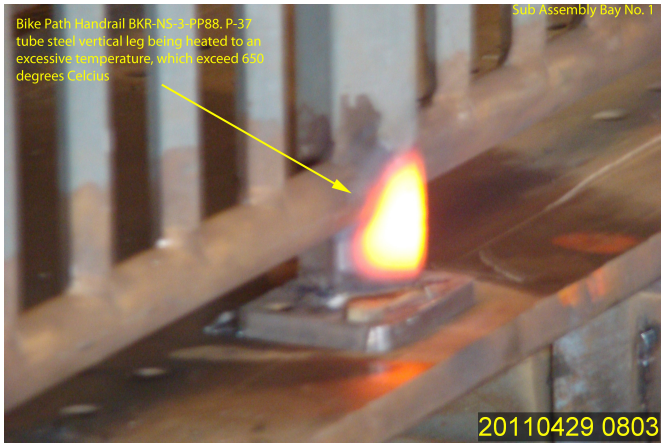

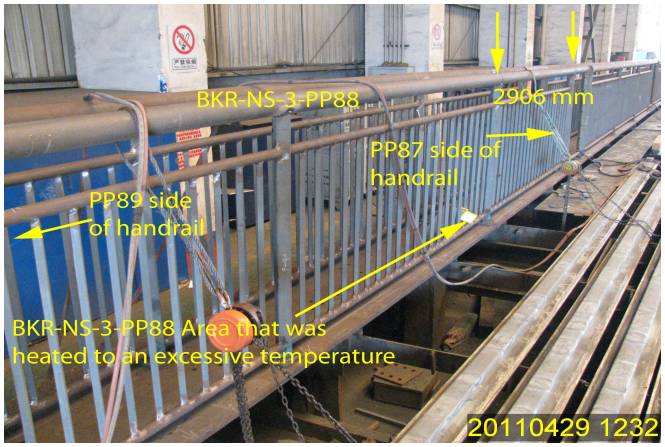

Summary of Conversations:

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.

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