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-023566
Date Inspected: 22-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

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

This inspector observed ZPMC personnel attaching base plates to the following Bike Path Handrail components identified as BKR-NS-3-001~010 and BKR-NS-2-001~012 along south west side of bay no.1. all components are being aligned prior to welding of base plates.

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

Bay Number 4

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.

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

3025TR1-001 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.
Bay Number7

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

Bay Number 8

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) sub assembly member identified as SA7047 for weld(s) 001~011. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Liu Fa Wen was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) no. HSR(B)-10201.

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) sub assembly member identified as SA7535 for weld(s) 001~011. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Liu Fa Wen was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) no. HSR(B)-10202.

Bay Number 9

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. 08887. The member(s) is/are identified as OBG Traveler Rail components identified below with the following identifying weld no.(s):

1 3012TR7-001-013/014.

FCAW welding of complete joint penetration welds located on Traveler Rail sub assembly component identified as SA7502A-001 weld no.(s) 001. Welder is identified as welder no. 059418. 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 sub assembly component identified as SA7502D-001 weld no.(s) 001. Welder is identified as welder no. 059443. The welding variables recorded by ZPMC QC identified as Chen Shigang appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

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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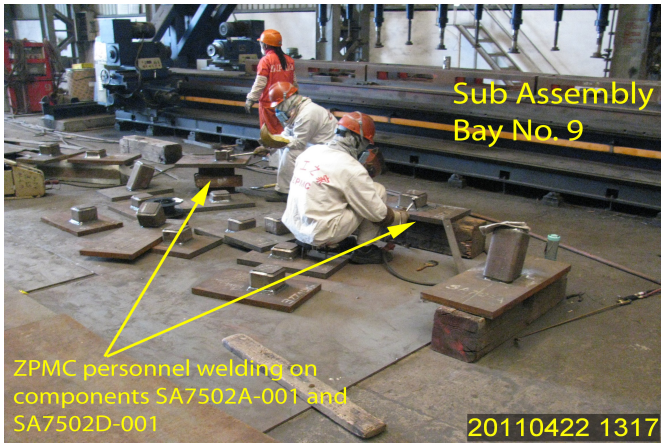

Summary of Conversations:

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