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-023842
Date Inspected: 19-Jan-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	**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 3

SMAW welding of complete join penetration welds located on Edge Plate component identified as EP3018-001 for weld no. 005 & 008. Welder is identified as welder no. 058102. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-P-2213-B-U2.

SMAW welding of complete join penetration welds located on Side Plate component identified as SP3081B-001 for weld no. 068 & 069. Welder is identified as welder no. 058102. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-P-2213-TC-U4b.

This inspector observed ZPMC QC personnel performing UT testing and inspection on the following components: 20TR2-32 weld no.(s) 009, 011, 013, & 015.

Bay Number 8

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC

Quality Control personnel. This QA Inspector generated an MT report for this date. All components were as listed on NWIT notification no. 08226 & 08227. The member(s) is/are identified as OBG Bike Path identified as components BK004A1-062, BK004A6-064, & BK004A8-064 with the following weld no.(s):

1. BK004A1-062-044, 043, 005, 006, 018, & 021.
2. BK004A6-064-001, 002, 007, 165
3. BK004A8-064-001, 002, 007, 130.

SMAW welding of complete join penetration welds located on Bike Path component identified as BK4SDI-059 for weld no.(s) 015, 016, 017, & 025. Welder is identified as welder no. 066155. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-P-2112 & WPS-B-P-2113.

SMAW welding of complete join penetration welds located on Bike Path component identified as BK4-064 for weld identified as lifting lugs. Welder is identified as welder no. 500405. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-P-2112.

Bay Number 10

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. All components were as listed on NWIT notification no. 08225. The member(s) is/are identified as OBG Traveler Rails identified as components listed below with the following weld no.(s):

1. 36TR1-001/012.
2. 37TR2-001/012.
3. 26TR1-001/012.
4. 27TR1-001/012.
5. 26TR2-017/028.
6. 31TR1-001/021.
7. 31TR1-001/021.
8. 31TR3-033/044.
9. 28TR1-001/002.
10. 29TR1-001/012.
11. 36TR1-004/005/015/016.
12. 37TR2-004/005/015/016.
13. 26TR1-004/005/015/016.
14. 27TR1-004/005/015/016.
15. 26TR2-019/021/031/032.
16. 31TR1-003/005/014/015.
17. 31TR3-036/037/047/048.

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

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