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-024191
Date Inspected: 27-May-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: Zhu Zhong Hai

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ 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:

Trial Assembly Segments 14AE @ CB19E & 14AW @ CB19W

This QA inspector observed the ZPMC personnel performing drilling of floor beams to receive high strength bolting holes at CB19E @ 14AE exterior at bottom plate, also observed match drilling of bolt holes at CB19W @ 14W.

Trial Assembly Segments 13AW @ CB18W

SMAW welding of complete joint penetration welds located on CB18W component identified as CB3002A-018 weld no.(s) 001. Welder is identified as welder no. 215248. The welding variables recorded by ZPMC QC identified as Zhou Zhong Hai appeared to comply with applicable WPS(s) WPS-B-P-2212-TC-U-4b-FCM-1.

SMAW welding of complete joint penetration welds located on CB18W component identified as CB3013D-018 weld no.(s) 021. Welder is identified as welder no. 215248. The welding variables recorded by ZPMC QC identified as Zhou Zhong Hai appeared to comply with applicable WPS(s) WPS-B-P-2212-TC-U-4b-FCM-1.

Trial Assembly 13AE @ CB18E

This QA inspector observed ZPMC personnel installing alignment pins into bottom plate at CB18E between PP118 & PP120. This inspector conducted visual inspection of hole alignment at FB3108A, FB3122A, FB3109A, FB3125A, & FB3121A.

Trial Assembly 13AW

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. 09271. The member(s) is/are identified as OBG Segment assembly components identified below with the following identifying weld no.(s):

1. SEG3013R-219, 221, 229, 223, 224, 227, & 228.

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