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-025154
Date Inspected: 21-Nov-2010

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			**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

FCAW welding of buttering welds located on Traveler Rails components identified as 20TR2-037 as identified on critical weld repair data sheet B-CWR-1568. Welder is identified as welder no. 069896. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-345-FCAW-1G(1F)-repair-1.

FCAW welding of fillet welds located on Barrier Rails components identified as E2-SB5-035 weld number(s) , 032~043, 063~074, & 126~131. Welder is identified as welder no. 062493. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2133-3.

FCAW welding of fillet welds located on Barrier Rails components identified as E2-SB1D-047 weld number(s) , 032~043, 063~074, & 126~131. Welder is identified as welder no. 067550. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2133-3.

FCAW welding of fillet welds located on Barrier Rails components identified as E2-SB1D-030 weld number(s) ,

032~043, 063~074, & 001~012. Welder is identified as welder no. 068916. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2132-3.

Bay Number 2

FCAW welding of fillet weld joint(s) located on lift 14 OBG sub assembly component identified as SA3446-001 weld number(s) 017, 022, & 023. Welder(s) are identified as welder no.(s) 207465. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2132-3.

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) Anchorage Plate component identified as AP3032-001. 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. HSR1(B)-9855.

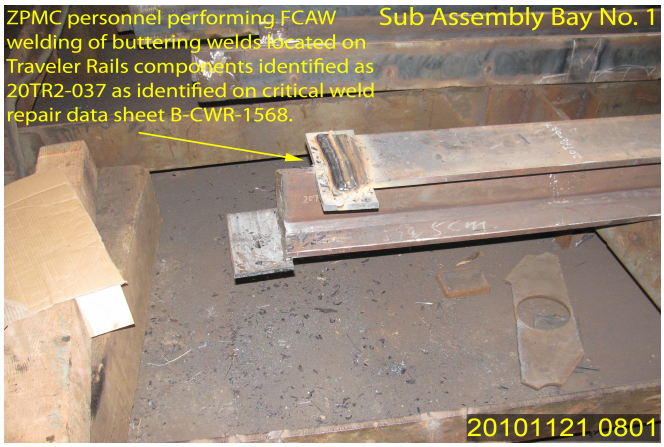
Bay Number 3

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG longitudinal diaphragm component identified as LD3040-001 weld number(s) 045. Welder(s) are identified as welder no.(s) 206623. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U4b-F and WPS-B-T-2232-TC-U5-F.

Bay Number 4

This inspector did not observe any welding or contract work in this bay today.

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