

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025329**Date Inspected:** 23-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**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:**

CWI Inspector: Mr. Li Ping

This QA Inspector observed ZPMC welder Mr. Lv Feng Yin, stencil 215676 used flux cored welding procedure WPS-B-T-2132-ESAB to make welds DP3154-001-001~009. This QA Inspector observed a Mr. Lv Feng Yin appeared to be certified to make these welds. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Xu Naisheng, stencil 044541 used flux cored welding procedure WPS-B-T-2132-ESAB to make segment 13W welds SA3231D-001-085 and 086. This QA Inspector observed a Mr. Xu Naisheng appeared to be certified to make these welds. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Yu Hui Ye, stencil 045143 used flux cored welding procedure specification WPS-B-T-2132-ESAB to make segment 13W welds SA3231D-001-081 and 082. This QA Inspector observed that Mr. Yu Hui Ye appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Zang Yan Bu, stencil 045196 used shielded metal arc welding procedure WPS-B-P-2212-TC-U4B-FCM-1 to make segment 13W weld SEG3014D-141 and 139. This QA Inspector observed Mr. Zang Yan Bu appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

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This QA Inspector observed ZPMC welder Mr. Tian Zhaoquan, stencil 045246 used shielded metal arc welding procedure WPS-B-P-2211-TC-U4B-FCM-1 to make segment 13W weld SEG3014S-090. This QA Inspector observed Mr. Tian Zhaoquan appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

See Above.

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 phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
