**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-025520
**Date Inspected:** 06-Dec-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

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|---|---|---|---|---|---|---|---|
| **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

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel, by the lot method testing procedure. This QA Inspector generated an MT report for this date. All components were as listed on NWIT notification no. 07651. The member(s) is/are identified as OBG Barrier Rails identified as component. The weld designations reviewed are as follows:

1. E2-SB1D-034-126, 128, 130, 036, 040, 042, 044, 055, & 051.
2. E2-SB5-032-126, 128, 130, 036, 040, 042, 044, 055, & 051.
3. E2-SB5-027-126, 128, 130, 065, 069, 073, 075, 092, & 051.
4. E2-SB5-028-126, 128, 130, 036, 040, 042, 044, 055, &019.
5. E2-SB5-019-126, 128, 130, 065, 069, 073, 075, 082, & 051.
6. E2-SB1D-046-126, 128, 130, 065, 069, 073, 075, 082, & 019.
7. E2-SB1-054-126, 128, 130, 036, 040, 042, 044, 055, & 051.
8. E2-SB1-042-126, 128, 130, 036, 040, 042, 044, 055, & 051.
9. E2-SB1-027-126, 128, 130, 065, 069, 073, 075, 092, & 051.

10. E2-SB20-001-126, 128, 130, 065, 069, 073, 075, 092, & 051.
11. E2-SB1D-037-126, 128, 130, 065, 069, 073, 075, 092, & 051.

Bay Number 2

SMAW welding of complete join penetration welds located on Anchorage Plate component identified as AP3032-001 as identified on critical weld repair data sheet B-CWR-2314 for weld no. 980. Welder is identified as welder no. 066074. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-345-SMAW-2G(2F)-repair. During this inspection, inspector also monitored ABF QA technicians performing MT examination on base metal repairs prior to completing fillet welding.

SMAW welding of complete join penetration welds located on Anchorage Plate component identified as AP3032-001 as identified on critical weld repair data sheet B-CWR-2314 for weld no. 551 & 417. Welder is identified as welder no. 066261. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-345-SMAW-2G(2F)-repair. During this inspection, inspector also monitored ABF QA technicians performing MT examination on base metal repairs prior to completing fillet welding.

SMAW welding of complete join penetration welds located on Anchorage Plate component identified as AP3032-001 as identified on critical weld repair data sheet B-CWR-2314 for weld no. 506, 283 & 281. Welder is identified as welder no. 066673. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-345-SMAW-2G(2F)-repair. During this inspection, inspector also monitored ABF QA technicians performing MT examination on base metal repairs prior to completing fillet welding.

SMAW welding of complete join penetration welds located on Anchorage Plate component identified as AP3032-001 as identified on critical weld repair data sheet B-CWR-2314 for weld no. 978. Welder is identified as welder no. 066674. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-345-SMAW-2G(2F)-repair. During this inspection, inspector also monitored ABF QA technicians performing MT examination on base metal repairs prior to completing fillet welding.

SMAW welding of complete join penetration welds located on Anchorage Plate component identified as AP3032-001 as identified on critical weld repair data sheet B-CWR-2314 for weld no. 371 & 461. Welder is identified as welder no. 037997. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-345-SMAW-2G(2F)-repair. During this inspection, inspector also monitored ABF QA technicians performing MT examination on base metal repairs prior to completing fillet welding.

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

# WELDING INSPECTION REPORT

*( Continued Page 3 of 3 )*

**Summary of Conversations:**

**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.

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|---|---|---|
| **Inspected By:** | Hernandez,Rene | Quality Assurance Inspector |
| **Reviewed By:** | Hall,Steven | QA Reviewer |