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-025525
Date Inspected: 21-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

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 1

This QA inspector observed ZPMC QC personnel performing MT inspection on the following member(s) is/are identified as OBG Barrier Rails assembly: E2-SB1-038, E2-SB1-051, E2-SB1-026, E2-SB1-044, E2-SB2-010, E2-SB1D-033, E2-SB1D-047, E2-SB1D-043, E2-SB1D-027, & E2-SB5-039.

Bay Number 2

This inspector observed set-up and initial heating of the component identified as AP3032-001 for dehydrogenization of welds.

Bay Number 3

FCAW welding of complete join penetration welds located on Side Plate component identified as SP3071-001 for weld no. 103, 105, 113, & 115. 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-T-2133-ESAB.

SMAW welding of fillet welds located on Side Plate component identified as SP3071-001 for weld no. 179 & 180. Welder is identified as welder no. 208035. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2213-TC-U4b.

FCAW welding of complete join penetration welds located on Architectural Housing component identified as AH3150 for weld no. 004, 005, & 006. Welder is identified as welder no. 037996. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2133-ESAB.

SMAW welding of fillet welds located on Side Plate component identified as SP3071-001 for weld no. 077 & 078. Welder is identified as welder no. 050977. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2213-TC-U4b.

Bay Number 6

SMAW welding of fillet welds located on Deck Plate component identified as DP3179-001 for weld no. 005 & 006. Welder is identified as welder no. 048669. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2114-FCM.

SMAW welding of fillet welds located on Deck Plate component identified as DP3179-001 for weld no. 013 & 014. Welder is identified as welder no. 049769. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2114-FCM.

SMAW welding of fillet welds located on Deck Plate component identified as DP3179-001 for weld no. 021 & 022. Welder is identified as welder no. 054467. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2114-FCM.

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

Summary of Conversations:

WELDING INSPECTION REPORT

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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