DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-025528
Date Inspected: 24-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

Inspected CWI report:	☐ Yes	☑ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A

CWI Present:	☑ Yes	☐ No	
Rod Oven in Use:	☑ Yes	☐ No	☐ N/A
Weld Procedures Followed:	☑ 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:

Bay Number 1

Performed verification VT for the component(s) identified as OBG Barrier Rails for components listed as E2-SB1-044, E2-SB1-050, E2-SB1-053, E2-SB1-058, E2-SB1D-027, E2-SB1D-047, E2-SB5-038, E2-SB5-039, E2-SB1C-009, & E2-SB2-011, This QA inspector signed green tag #15098.

Performed verification VT for the component(s) identified as OBG Barrier Rails for components listed as E2-SB1-018, E2-SB1-082, E2-SB1-048, E2-SB1-020, E2-SB1-039, E2-SB2-008, E2-SB4-006, E2-SB3-002, E2-SB1D-022, E2-SB1D-031, E2-SB1D-051 & E2-SB1D-050, This QA inspector signed green tag #15099.

Bay Number 2

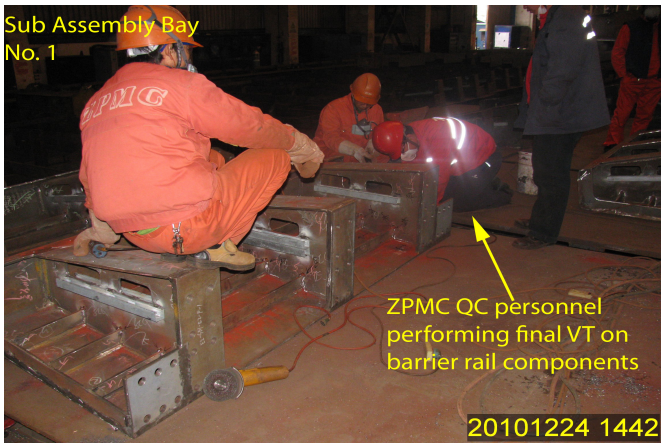
ZPMC personnel heat straightening Orthotropic Box Girder (OBG) sub assembly components identified as SA3415-001-002, SA3415-002-002, SA3415-001-001, SA3415-001-003, SA3415-003-003, SA3415-002-003. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Tian Lei was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat

Straightening Report (HSR) no. HSR1-9974.

Bay Number 3

SMAW welding of complete join penetration welds located on Side Plate component identified as SP3071-001 for weld no. 237. 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-P-2213-TC-U4b.

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



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.

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