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: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-026406
Date Inspected: 20-Sep-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island

OSM Arrival Time: 1200
OSM Departure Time: 2200
Location: Shanghai, China

CWI Name:	Chen Shi Gang			**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: Traveler & Hand Rail

Summary of Items Observed:
On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

Bay 9

This QA Inspector observed the following work in progress for Bay 9.
ZPMC was using the Flux Cored Arc Welding(FCAW) process.
ZPMC QC is identified as Zhu Zhung Jie.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Component: Traveler Rail
PCMK: 3018TR1-001
Weld Number: 026, 027
Welder: 059443
WPS-B-T-2232-ESAB

Component: Traveler Rail
PCMK: 3017TR2-001
Weld Number: 024, 025

Welder: 059443
WPS-B-T-2232-ESAB

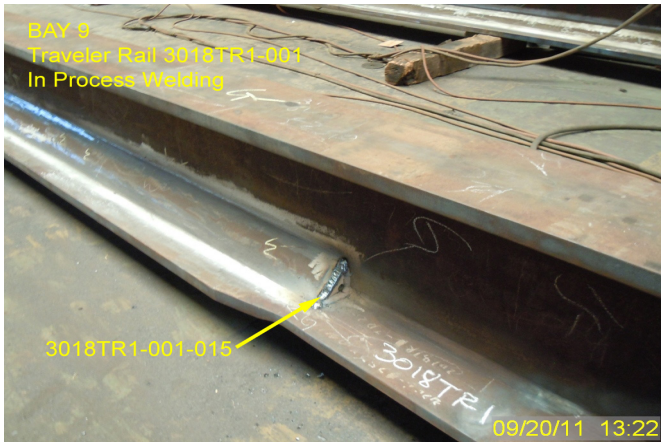
Component: Traveler Rail
PCMK: 3018TR1-001
Weld Number: 015, 016
Welder: 201840
WPS-B-T-2232-ESAB

Component: Traveler Rail
PCMK: 3018TR2-001
Weld Number: 015, 016
Welder: 201840
WPS-B-T-2232-ESAB

Bay 16

Heat straightening of Hand Rail BKR-FS-38-001, BKR-FS-39-001, BKR-FS-40-001, and BKR-FS-41-001 under approved Heat Straightening procedure HSR 10418. The in process temperature was observed as 250°C. The ZPMC QC was identified as Ma Qian Li. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 5 mm.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Summary of Conversations:

No relevant 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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Combs,Dennis	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer