

**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-023398**Date Inspected:** 20-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lu Li Qing**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 Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath. Math. was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG ASSMEBLY # BAY 13

Welding In progress -Process FCAW:

Welding of weld joint – 101/102; 106/107; and 114/115 located on PCMK SEG No. SEG 038. Welder is identified as 050988. ZPMC (QC) CWI is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

Welding of weld joint – DP 467-001-100; DP 467-001-105 and DP 467-001-110 located on PCMK SEG No. SEG 038. Welder is identified as 050988. ZPMC (QC) CWI is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

Welding In progress -Process SMAW:

Welding of PCMK SEG No. LD001-021 between 7CW PP 53 and 7CW P 54. Welder is identified as 067610. ZPMC (QC) CWI is identified as Mr. Shen Fu You. The welding variables recorded by QC appeared to comply

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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with the WPS-B-P-2214-TC-U4b-FCM.

SEGMENT ASSEMBLY # BAY 19

Grinding and Welding Rectification

Noticed Grinding and Welding for Visual imperfection being rectified for BP-26A-008 and Bike Path BK-4A-003.  
Grinding work in progress for Transverse stiffeners.

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

**Summary of Conversations:**

No relevant conversations were reported on this date.

**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 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Math,Manjunath	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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