

**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-019759**Date Inspected:** 08-Dec-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:** See Below**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:**

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

OBG Segment Name: 12CE / Bay 14

This Caltrans QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) of Complete Joint Penetration (CJP) weld identified as SEG3003A-005. The welder is identified as #050988 and welding procedure WPS-B-T-2231-B-U2-F. ZPMC QC inspectors are identified as Mr. Zhong Guo Hui and certified welding inspector (CWI), Mr. Lv Li Qing. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 11EW / Bay 14

This Caltrans QA Inspector observed ZPMC welding personnel performing FCAW of CJP weld identified as CA92-004. The welders are identified as #058245 and 045240, and welding procedure WPS-B-T-2231-TC-U4b-F. ZPMC QC inspectors are identified as Mr. Xu Tao and CWI, Mr. Liu Hua Jie. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 11BW / Bay 13

This Caltrans QA inspector observed ZPMC welding personnel performing FCAW of CJP weld, identified as SSD12A-PP100-236. Welder is identified as #258551, welding in the 2G position using WPS-B-T-2232-Tc-U4b-F. ZPMC QC inspectors are identified as Mr. Guo Xing Hui and CWI, Mr. Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with the WPS.

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

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# WELDING INSPECTION REPORT

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documents.

**Summary of Conversations:**

“As noted within the contents of this report.”

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

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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
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<b>Reviewed By:</b>	Riley, Ken	QA Reviewer
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