

**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-019873**Date Inspected:** 19-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: 7CW / North of Blast Shop

This Caltrans QA Inspector observed base metal repairs being performed during the Quality Assurance random in-process visual inspection of Segment 7CW, without the prior approval of the engineer. The plate identification under repair are identified as SP99A, Plate number-PL531A and SP431A, Plate Number-PL1210A. This QA inspector generated a Quality Assurance-Incident Report for the welding violation. See Quality Assurance-Incident Report, dated 12-19-09 for additional information. ZPMC QC inspector/ Certified Welding Inspector (CWI), is identified as Mr. Wang Wei Ming.

OBG Segment Name: 11DE / Bay 14

This Caltrans QA inspector observed Submerged Arc Welding (SAW) in progress. Welder operator is identified as #215993 welding CJP weld in the 1G position using WPS-B-T-2221-B-L2c-S-2. The weld is identified as SEG072\*-001. ZPMC QC inspectors are identified as Mr. Geng Wei and certified welding inspector (CWI), Mr. Lv Li Qing. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 8AE / Blast Shop

This QA Inspector performed This QA Inspector performed a preliminary random visual inspection after the grit blast of the internal components of the bottom plate and side plate, between panel points PP061 and PP062 of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is

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# WELDING INSPECTION REPORT

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applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

## Bay 19

This Caltrans QA inspector performed Magnetic Particle (MT) inspection of approximately 15% of the area previously tested and accepted by ZPMC per NDT Notification 04893. The components are identified as bottom plate BP025-013-001, BP025-013-002, BP025-013-003, BP026-013-001, BP026-013-002 and BP026-013-003, splice welds. See Caltrans Magnetic Particle Test Report (TL-6028), date 12-19-2010 for additional information.

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