

**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 #: 04-0120F4Cty: 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-019878**Date Inspected:** 13-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: 7BW / Blast Shop

This Caltrans QA Inspector performed a preliminary random visual inspection after the grit blast of the internal components of the bottom floor plates, side plates, lower floor beam and longitudinal beam. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

OBG Segment Name: Bay 19 / Lift 12

This Caltrans QA inspector observed Submerged Arc Welding (SAW) in progress. Welder operator is identified as #062816 welding complete joint penetration (CJP) weld in the 1G position using WPS-B-2221-B-L2c-S-2. The weld is identified as SEG071\*-006. ZPMC QC inspectors are identified as Mr. Zhou Chen and CWI inspector, Mr. Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 11DW / Bay 14

This Caltrans QA inspector verified weld prep after back gouging and grinding, prior to welding. The weld joint was ground to bright metal and fit-up/alignment in accordance with WPS-B-T-2231-B-U2-F. The weld joint is identified as SEG071\*-006. ZPMC QC inspectors are identified as Mr. Xu Tao and CWI, Mr. Liu Hua Jie.

OBG Segment Name: 10AW / Bay 14

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

This Caltrans QA inspector observed Flux Cored Arc Welding (FCAW) in progress. Welder is identified as #047866 welding complete joint penetration (CJP) weld in the 1G position using WPS-B-2231-TC-U4b-F. The weld is identified as SEG059C-034. ZPMC QC inspectors are identified as Mr. Mr. Xu Tao and CWI, Mr. Liu Hua Jie. 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 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.

---

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

---