

**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-020186**Date Inspected:** 28-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:** 9AE / North of Blast Shop

This Caltrans QA inspector observed shielded metal arc welding (SMAW) in progress. Welder is identified as 066179 welding complete joint penetration (CJP) in the 4G position using welding procedure specification WPS-B-P-2214-B-FCM-1. The weld is identified as SEG050-007. ZPMC QC inspectors are identified as Mr. Wang Wei Ming and certified welding inspector (CWI), Mr. Li Yan Hua. The welding variables recorded by QC appeared to comply with the WPS.

**OBG Segment Name:** 11AW / Bay 13

This Caltrans QA inspector observed flux cored arc welding (FCAW) in progress. Welders are identified as #055491 & 051356 welding fillet weld (FW), identified as #SSD13A-PP97-005 in the 1F position using WPS-B-T-2212. ZPMC QC inspectors are identified as Mr. Lv Li Qin and CWI, Mr. Tang Ya Jun. The welding variables recorded by QC appeared to comply with the WPS.

**OBG Segment Name:** 11BW / Bay 13

This Caltrans QA inspector observed FCAW in progress. Welder is identified as #050242 CJP weld, identified as #SSD11-PP100-005 in the 1G position using WPS-B-T-2213-B-U2-F. ZPMC QC inspectors are identified as Mr. Lv Li Qin and CWI, Mr. Tang Ya Jun. The welding variables recorded by QC appeared to comply with the WPS.

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## WELDING INSPECTION REPORT

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OBG Segment Name: 11EE / Bay 14

This Caltrans QA inspector observed submerged arc welding (SAW) in progress. Welder operator is identified as #058100 welding CJP weld in the 1G position using WPS-B-T-223(2) IT-2. The weld is identified as SEG074\*-006. ZPMC QC inspectors are identified as Mr. Zhong Guo Hui and CWI, Mr. Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 11DE / Bay 19

This Caltrans QA inspector observed plate distortion after welding. The plate assembly is identified as bottom plate sub-assembly BP-026A-13. ZPMC QC inspector is identified as Mr. Zhou Chang. Mr. Zhou Chang stated that the plate assembly would be straightened prior to assembly in accordance with Heat Straighten Procedure HSR1-(B) 8006, Revision. The following digital picture illustrates plate distortion. See SharedDocs on 'Team China Server (P12.168.0.2Y) (Z:), folder B293 for photo viewing.

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
<b>Reviewed By:</b>	Riley, Ken	QA Reviewer

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