

**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-021186**Date Inspected:** 17-Jul-2010**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:** Zhu Zhong Hai  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** Yes No N/A  
**Approved WPS:** Yes No N/A  
**Delayed / Cancelled:** Yes No N/A

**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

**OBG Segment 9BW-9CW**

Shielded Metal Arc Welding (SMAW) in the 4G position of 9BW-9CW Cross beam side Edge Panel splice weld joint, Weld # OBW9-010. The welder is identified as 066326. ZPMC Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1. See attached photograph Pic\_001.

**OBG Segment 9BW-9CW**

Shielded Metal Arc Welding (SMAW) in the 4G position of 9BW-9CW Counter weight side Edge Panel splice weld joint, Weld # OBW9-006. The welder is identified as 045196. ZPMC Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1. See attached photograph Pic\_002.

**OBG Segment 9BW-FL3**

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During in process visual inspection of 9BW-FL3 area, This QA Inspector observed ZPMC personnel performing fit up of half diaphragm bottom stiffener between PP075 & PP076. The welder is identified as 205098.ZPMC Quality Control (QC) is identified as Xu Jin Long.

### OBG Segment 9BW-FL3

Flux Core Arc Welding (FCAW) in the 2G position of 9BW-FL3 Half diaphragm web to bottom weld. Weld # SSD25-PP075-44. The welder is identified as 207465. ZPMC Quality Control (QC) is identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

### OBG Segment 9BW-9CW

Flux Core Arc Welding (FCAW) in the 3G position of 9BW-9CW Side Panel Splice weld at Counterweight side, weld # OBW9-007. The welder is identified as 45240. ZPMC Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS-B-T-2233T-1.

### OBG Segment 9BW-9CW

Flux Core Arc Welding (FCAW) in the 3G position of 9BW-9CW Side Panel Splice weld at Cross Beam side, weld # OBW9B-009. The welder is identified as 069683. ZPMC Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS-B-T-2233T-1.

### OBG Segment 9DE-9EE

Submerge Arc Welding (SAW) in the 1G position of 9DE-9EE Deck Panel Splice weld, weld # OBE9A-008. The welder is identified as 054458. ZPMC CWI is identified as Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with WPS-B-T-223(2)1T-2.

### OBG Segment 9DE-9EE

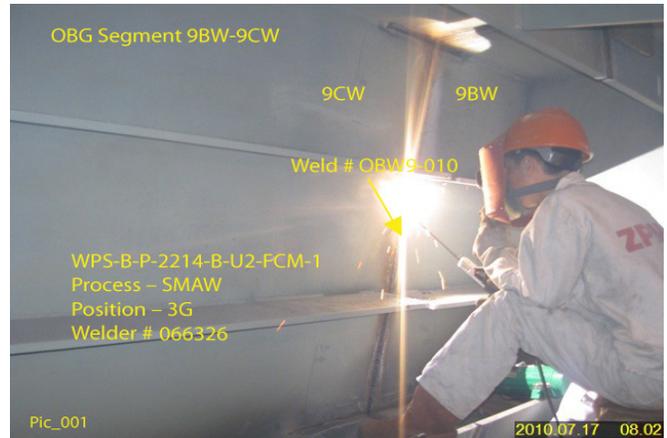
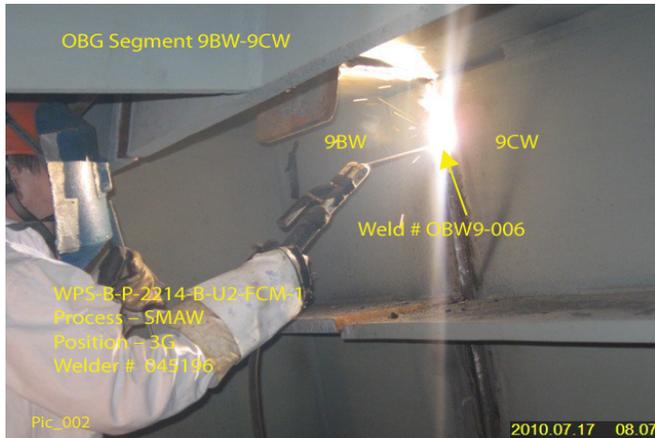
Shielded Metal Arc Welding (SMAW) in the 4F position of 9DE-9EE Deck Panel 'I' rib hold back weld, weld # DP700-001-011. The welder is identified as 067765. ZPMC CWI is identified as Liu Huajie. The welding variables recorded by QC appeared to comply with WPS-B-T-4114-1.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

No relevant conversations 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 (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Gade,Ramesh	Quality Assurance Inspector
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<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer
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