

**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-021188**Date Inspected:** 15-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**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 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 9BE-9CE

During in process visual inspection of 9BE-9CE, This QA Inspector observed ABF Quality Assurance (QA) personnel performing Ultrasonic Testing (UT) on Bike Path side BP to SP hold back weld. See attached photograph Pic\_001

OBG Segment 9CE-9DE

During in process visual inspection of 9CE-9DE, This QA Inspector observed ZPMC NDT personnel performing Magnetic Particle Testing (MT) Bottom Panel temporary attachment removed area. See attached photograph Pic\_002

OBG Segment 9BW-FL3

During in process visual inspection of 9BW-FL3, This QA Inspector observed ZPMC personnel performing fit up of half diaphragm vertical stiffener attached to PP76. . The welder is identified as 705089. ZPMC Quality Control

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(QC) is identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with WPS-B-P-2113-FCM-1.

## OBG Segment 9BE-FL3

During in process visual inspection of 9BE-FL3, This QA Inspector observed ZPMC NDT personnel performing Ultrasonic Testing (UT) on repaired area of half diaphragm bottom flange weld attached to PP76.

## OBG Segment 9DE-9EE

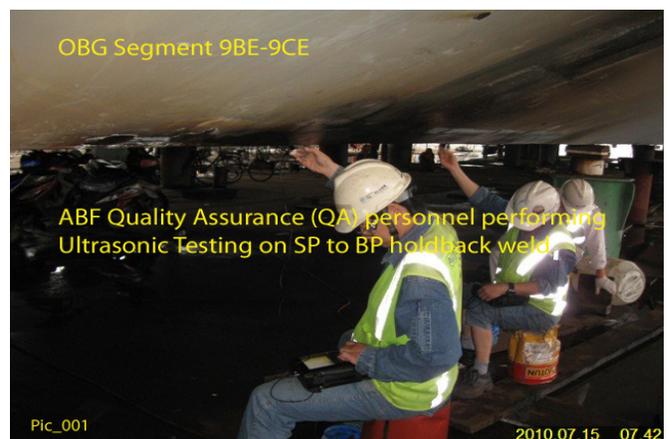
Flux Core Arc Welding (FCAW) in the 1G position of 9DE-9EE Deck Panel splice weld joint. Weld # OBE9A-009. The welder is identified as 067942. ZPMC Quality Control (QC) is identified as Liu Huajie. The welding variables recorded by QC appeared to comply with WPS-B-T-2231T.

## OBG Segment 9BW-9CW

Flux Core Arc Welding (FCAW) in the 1G position of 9BW-9CW Deck Panel splice weld joint. Weld # OBE9-008. The welder is identified as 066746. ZPMC Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS-B-T-223(2)1T-1.

## OBG Segment 9BW-9CW

Flux Core Arc Welding (FCAW) in the 1G position of 9BW-9CW Bottom Panel splice weld joint. Weld # OBE9B-008. The welder is identified as 066443. ZPMC Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS-B-T-2231T-1.



## Summary of Conversations:

No relevant conversations reported on this date.

## Comments

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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
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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