

**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-021260**Date Inspected:** 11-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:** Liu Hua Jie**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 9CE-9DE

Shielded Metal Arc Welding (SMAW) in the 4G position of Bottom Panel Splice weld joint, weld # OBE9C-003. The welders are identified as 067765, 066179 and 037932. ZPMC CWI is identified as Liu Huajie. The welding variables recorded by QC appeared to comply with WPS – B-P-2214B-U2-FCM-1.

OBG Segment 9BE-9CE

During in process visual inspection of 9BE-9CE, This QA Inspector observed ABF Quality Assurance personnel performing Magnetic Particle Testing (MT) on Deck Panel temporary attachment removed area from inside.

OBG Segment 9AW-9BW

During in process visual inspection of 9AW-9BW, This QA Inspector observed ZPMC NDT personnel performing Ultrasonic Testing (UT) on Bottom panel weld repaired area.

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## WELDING INSPECTION REPORT

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### OBG Segment 9BE-9CE

Shielded Metal Arc Welding (SMAW) in the 3G position of Cross Beam side Edge Panel Splice weld joint as per repair report # B-CWR-1701, weld # OBE9-006. The welder is identified as 048659. ZPMC Quality Control (QC) is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS – 345-SMAW-3G(3F)-FCM-Repair-1.

### OBG Segment 9BE

During in process visual inspection of 9BE- FL3 area, This QA Inspector observed ZPMC NDT personnel performing Ultrasonic Testing (UT) and Magnetic Particle Testing (MT) on Half Diaphragm weld joints.

### OBG Segment 9CE-9DE

Flux Core Arc Welding (FCAW) in the 3G position of Side Panel 'I' Rib Splice weld joint at Bike Path side, weld # SP708-001-032. The welder is identified as 066443. ZPMC Quality Control (QC) is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS - B-T-2233T.

### OBG Segment 9BE-9CE

Shielded Metal Arc Welding (SMAW) in the 3G position of Cross Beam side Edge Panel Splice weld joint as per repair report # B-CWR-1701, weld # OBE9-010. The welder is identified as 048659. ZPMC Quality Control (QC) is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS – 345-SMAW-3G(3F)-FCM-Repair-1.

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

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