

**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-016604**Date Inspected:** 29-Aug-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:** Wang Jie/Xu Tao**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:**

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

In process Inspection

Bay #14

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 13CW Side Panel, weld No: SEG3015A-010. The welder is identified as #045270. ZPMC CWI is identified as Mr. Wang Jie. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2C-S-2. Please see the attached picture.

This QA Inspector observed the following work in progress:

FCAW in the 1G position for the OBG Segment 13CW Side Panel, weld No: SEG3015A-007. The welder is identified as #201981. ZPMC CWI is identified as Mr. Wang Jie. The welding variables recorded by QC appear to comply with WPS-B-T-2231-B-U2-F. Please see the attached picture.

This QA inspector observed the following work in progress:

SMAW welding of weld joint No: DP3054-001-011 located on OBG Segment 12BW. Welder is identified as #045133. ZPMC QC is identified as Mr. Wang wei ming. Welding was performed with the temporary weld repair report. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G(3F)-Repair.

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## WELDING INSPECTION REPORT

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Bay #19

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG Segment Suspender Bracket, weld No: SB017-084-26. The welder is identified as #062755. ZPMC CWI is identified as Mr.Xu Tao. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG Segment Suspender Bracket, weld No: SB016-078-32. The welder is identified as #062808. ZPMC CWI is identified as Mr.Xu Tao. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

Magnetic Particle Testing:-

Trail Assembly area

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Segment 9DW&9EW I-Ribs and T-Ribs Hold pack welds. The weld designation reviewed is as follows:

SP135-001-033,034,035,036

SP162-001-025,026

SP136-001-001,002

BP100-001-047,048,049,050

BP101-001-029,030,031,032

DP673-001-015,016

EP114-001-011,012

SP658-001-025,026

DP674-001-009,010

EP115-001-007,008

SP659-001-015,016

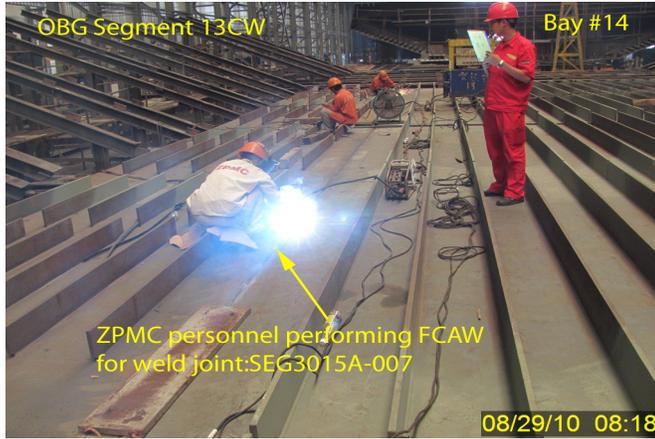
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

No Relevant Conversation.

## 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 150-0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Pillai,Pandaram

Quality Assurance Inspector

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**Reviewed By:** McClendon,Timothy

QA Reviewer