

**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-017936**Date Inspected:** 08-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China**CWI Name:** Chen Xi**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, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 2

This QA Inspector observed the following work in progress for Bay 2.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Wang Lin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components: Floor Beam

PCMK: FB3328-001-001,018,002,019

Welder: 215676

WPS-B-T-2232-TC-U4b-F

PCMK: FB3328-001-015,025,014,024

Welder: 202122

WPS-B-T-2232-TC-U4b-F

PCMK: FB3328-001-025,008,007,010

Welder: 045175

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WPS-B-T-2232-TC-U4b-F

PCMK: FB3328-001-052, 053, 046,047

Welder: 047866

WPS-B-T-2232-TC-U4b-F

PCMK: FB3327-001-002, 019, 001, 018

Welder: 455227

WPS-B-T-2232-TC-U4b-F

PCMK: FB3327-001-014,015,061,067

Welder: 203871

WPS-B-T-2232-TC-U4b-F

PCMK: FB3327-001-005, 007, 008, 009

Welder: 045227

WPS-B-T-2232-TC-U4b-F

PCMK: FB3327-001-054, 046

Welder: 045221

WPS-B-T-2232-TC-U4b-F

Bay 3

This QA Inspector observed the following work in progress for Bay 3.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhu Jun.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components: Floor Beam

PCMK: FB3266-001-008, 010, 005, 006

Welder: 217805

WPS-B-T-2132-3

Components: Bulk Head

PCMK: SA3325-001-016

Welder: 044830

WPS-B-T-2232-TC-U4b-F

PCMK: SA3325-001-017

Welder: 206623

WPS-B-T-2232-TC-U4b-F

PCMK: SA3363-001-001

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Welder: 208035

WPS-B-T-2231-B-U2-F-1

Bay 4

This QA Inspector observed the following work in progress for Bay 4.

ZPMC was using the Submerged Arc Welding (SAW) process.

ZPMC QC is identified as Zhu Jun.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components: Bulk Head

PCMK: SA3363-001-001

Welder: 050502

WPS-B-T-2231-B-L2C-S-2

PCMK: SA3363-001-001

Welder: 207288

WPS-B-T-2231-B-L2C-S-2

Bay 19

This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) 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(s) is/are identified as follows; BK004A5-010, BK005A5-001, BK006A5-001 for item number 1 on NWIT tracker document # 06894.

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

### Summary of Conversations:

No relevant conversations

### 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 15000422372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Shin,DJ

Quality Assurance Inspector

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**Reviewed By:** Carreon,Albert

QA Reviewer