

**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-018023**Date Inspected:** 07-Nov-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

<b>CWI Name:</b>	An Qing Xing	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG COMPONENT	

**Summary of Items Observed:**

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

In process Inspection

Outside Yard

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG segment 11DW to 11EW, weld No.OBW11A-006.The welder is identified as #040611. ZPMC QC is identified as Mr.Zhu Yuan Yuan. The welding variables recorded by QC appear to comply with WPS-B-P-2213-B-U2-FCM-1.

SMAW in the 4G position for the OBG segment 11DW to 11EW, weld No.SP170-001-054.The welder is identified as #057333. ZPMC QC is identified as Mr.Zhu Yuan Yuan. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1.

SMAW in the 4G position for the OBG segment 11DW to 11EW, weld No.OBW11A-010.The welder is identified as #044551. ZPMC QC is identified as Mr.Zhu Yuan Yuan. The welding variables recorded by QC appear to comply with WPS-B-P-2213-B-U2-FCM-1.

SMAW in the 4G position for the OBG segment 11DW to 11EW, weld No.EP121-001-013.The welder is identified as #046709. ZPMC QC is identified as Mr.Zhu Yuan Yuan. The welding variables recorded by QC

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appear to comply with WPS-B-P-2214-B-U2-FCM-1.

FCAW in the 2F position for the OBG segment 11EE, weld No.SP560-001-004.The welder is identified as #040458. ZPMC QC is identified as Mr. Wang Li Yang . The welding variables recorded by QC appear to comply with WPS-B-T-2132.

FCAW in the 2F position for the OBG segment 11EE, weld No.BP082-001-006.The welder is identified as #040367. ZPMC QC is identified as Mr. Wang Li Yang . The welding variables recorded by QC appear to comply with WPS-B-T-2132.

SMAW in the 2G position for the OBG Crossbeam CB17, UT repair weld No.CB3001A-017-023.The welder is identified as #067904. ZPMC QC is identified as Mr. Feng Ya Jun . The welding variables recorded by QC appear to comply with WPS-345-SMAW-2G(2F)-FCM-REPAIR. The weld repair report is identified as WR16620. Green Tagging for service platform component at bay#9

This QA inspector performed Visual Inspection for Green Tagging which were previously tested and accepted by ZPMC Quality Control personnel and ABF QA personnel. The members are identified as service platform component SP4, SP7 and SP8.

Service platform No.            Green Tag No.

SP4, SP7&SP8 (Stairs and Hand Rail)    15063

Ultrasonic Testing (A,B,C and D-Scan )

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as splice joint joining between edge Plate to edge Plate for OBG segment 11BW to 11CW at counter weight side. This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

OBW11-006

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

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ZPMC personnel performing SMAW for weld joint OBW11A-010 at 3G position on 11DW to 11EW edge plate splice joint at crossbeam side



ZPMC personnel performing FCAW for weld joint BP082-001-006 at 2F position on segment 11EE



ZPMC personnel performing SMAW for UT repair weld joint CB3001A-017-023 at 2G position on OBG crossbeam CB17



Visual Inspection performed for Green Tagging at service platform component Stairs and Hand Rail at bay#9



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

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**Inspected By:** Bera,Subhasis

Quality Assurance Inspector

**Reviewed By:** McClendon,Timothy

QA Reviewer

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