

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-019285**Date Inspected:** 11-Jan-2011**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:** Sha Zhi**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 14

This QA Inspector observed the following work in progress for Bay 14.

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

ZPMC QC is identified as Zhang Lin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Segment 13AW

PCMK: SEG3013AU-012

Welder: 068445, 066421

WPS-B-T-2233-ESAB

PCMK: SEG3013AU-047

Welder: 067103, 066239

WPS-B-T-2233-ESAB

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shield Metal Arc Welding (SMAW) process.

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## WELDING INSPECTION REPORT

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ZPMC QC is identified as Zhang 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: Segment 13AW

PCMK: SEG3013R-138/139

Welder: 637780

WPS-B-P-2112-FCM-1

Components: Segment 14W

PCMK: DP3175-301

Welder: 067611

WPS-B-T-2132-TC-P4

PCMK: SEG3020AA

Welder: 066398

Report: B-CWR 2657

WPS-345-SMAW-2G (2F)-FCM-repair

PCMK: SEG3020K-022

Welder: 201215

Report: B-WR 19029

WPS-345-SMAW-2G (2F)-FCM-repair

PCMK: SEG3020K-021

Welder: 067520

Report: B-WR 19831

WPS-345-SMAW-2G (2F)-FCM-repair

PCMK: SEG3020W-036

Welder: 066734

Report: B-CWR 2623

WPS-345-SMAW-3G (3F)-FCM-repair

PCMK: SEG3020Q-058

Welder: 047864

Report: B-CWR 2620

WPS-345-SMAW-3G (3F)-FCM-repair

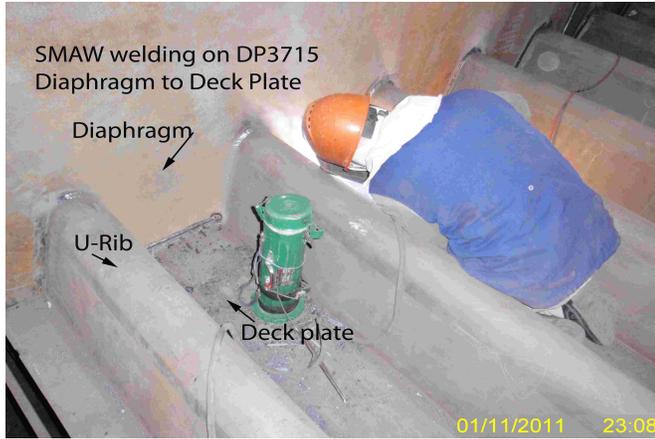
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

No relevant 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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<b>Inspected By:</b>	Shin,DJ	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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