

**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-020605**Date Inspected:** 27-Feb-2011**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:** Mr. Geng Wei  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** Yes No N/A  
**Approved WPS:** Yes No N/A  
**Delayed / Cancelled:** Yes No N/A

**Bridge No:** 34-0006**Component:** BAY 14 OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A. DeArmond was present during the time noted above and conducted observations relative to the work being performed.

**Magnetic Particle Testing (MT)**

This QA inspector performed 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. All components were as listed on NWIT notification no. 07516. The member(s) is/are identified as Corner Assembly. The weld designations reviewed are as follows:

CA3013B-111, 112, 113, 114, 115, 116, 141, 142, 143, 145, 146, 119, 120, 121, 122, 123, 124, 125, 126, 127,

CA3013C-022, 023, 024, 025, 026, 027, 028, 029, 030, 031,

CA3013C-145, 146, 143, 144, 141, 142

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# WELDING INSPECTION REPORT

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OBG BAY 14

This QA Inspector observed the following work in progress:

FCAW welding of complete joint penetration weld joint(s) located on Segment Assembly identified as 3019A2 weld number(s) 015. Welder is identified as welder no. 062782. The welding variables recorded by ZPMC QC identified as Mr. Wang XU appeared to comply with applicable WPS(s) WPS-B-T-2231-T-C-U4b-F.

FCAW welding of fillet weld joint(s) located on U-Rib to Diaphragm plate identified as DP3119-001 weld number(s) 425, 426, 083, and 084. Welder is identified as welder no. 067103. The welding variables recorded by ZPMC QC identified as Mr. Wanh Xu appeared to comply with applicable WPS(s) WPS-B-T-2132.

FCAW welding of fillet weld joint(s) located on U-Rib to Diaphragm plate identified as DP3117-001 weld number(s) 193 and 194. Welder is identified as welder no. 201215. The welding variables recorded by ZPMC QC identified as Mr. Wanh Xu appeared to comply with applicable WPS(s) WPS-B-T-2132.

FCAW welding of fillet weld joint(s) located on U-Rib to Diaphragm plate identified as DP3117-001 weld number(s) 026, 027, 196, and 197. Welder is identified as welder no. 069089. The welding variables recorded by ZPMC QC identified as Mr. Wanh Xu appeared to comply with applicable WPS(s) WPS-B-T-2133.

FCAW welding of complete joint penetration weld joint(s) located on U-Rib to Diaphragm plate identified as DP3117-001 weld number(s) 197, 202, 395, and 404. Welder is identified as welder no. 067184. The welding variables recorded by ZPMC QC identified as Mr. Wang XU appeared to comply with applicable WPS(s) WPS-B-T-2231-T-C-U4b-F.

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

**Summary of Conversations:**

As mentioned above between QA and QC concerning this project

**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 Jim Devy 150-002-6784, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	DeArmond,Robert	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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