

**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-021485**Date Inspected:** 03-Mar-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:** See Below**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, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

**Bay 1**

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 1 ZPMC was in process of FCAW (ESAB) welding on traveler rail assembly. ZPMC CWI inspector Wang Liang was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 3 welders and identified the welders by ZPMC welder identification number appointed to them by ZPMC. This QA inspector verified this information for the following location;

Weld- 20TR2-038-009

WPS-B-T-2232-ESAB

Welder-217185

2G/CJP/FCAW

Weld- 20TR2-038-013, 015

WPS-B-T-2232-ESAB

Welder-053609

2G/CJP/FCAW

Weld- 20TR2-038-017

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WPS-B-T-2232-ESAB  
Welder-204342  
2G/CJP/FCAW

This QA inspector observed SMAW welding on Cable Tray Support assembly in Bay 1. ZPMC CWI Wang Liang stated that ZPMC had 2 welders performing welding and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Cable Tray Support  
WPS-B-P-2112  
Welder-048659, 215083  
2F//SMAW

## UT Inspection

This Caltrans QA inspector received ZPMC non-destructive test (NDT) Inspection Notification, Doc. #08442 from ZPMC for steel barrier in Bay 1. This QA inspector performed ultrasonic test (UT) verification for Item 1, after ZPMC had performed their UT inspection of the following locations.

Item 1  
W2-SB13-001-081

At the time of the verification it was noted that the above component appeared to be within compliance of the contract documents. See Caltrans Ultrasonic Test Report (TL6027), dated 03-03-2011 for additional information.

The following digital picture illustrates weld W2-SB13-001-081.

## Bay 10

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 10 ZPMC was in process of welding and Heat Straightening. ZPMC QC inspector Yu Zhan Lai was present at this time of this observation and informed this QA inspector of the work that is in process and identified Li Jun as the CWI. It was stated that ZPMC had 5 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld-BK16B-001-002  
WPS-B-T-2233-ESAB  
Welder-057266  
3G/FCAW/CJP

Weld-BK15B-001-013  
WPS-B-T-2213-TC-U4c  
Welder-040582  
3G//SMAW/CJP

Weld-26TR1-011-013

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WPS-B-T-2232-ESAB  
Welder-053869  
2G/FCAW/CJP

Weld-26TR1-011-011  
WPS-B-T-2232-ESAB  
Welder-054069  
2G/FCAW/CJP

Weld-26TR1-006-002  
WPS-B-T-2232-ESAB  
Welder-040265  
2G/FCAW/CJP

HRS1 (B) 10151  
BK10A-001~006, 014~017, etc

This QA inspector observed during the observation that at Bay 10 ZPMC was welding on traveler rail and bike path assembly. ZPMC CWI Li Jun was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 4 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld-BK014A6-001-072, 073  
WPS-B-P-2132-ESAB  
Welder-052075, 040302, 040533  
2F/FCAW

WR20330  
Weld-20TR2-039-009, 011, 013, 015, 017  
WPS-345- SMAW- 2G (2F)-Repair  
Welder-052930  
2G/SMAW/CJP

Bay 11

This QA inspector observed ZPMC in process of SMAW welding on traveler rail assembly 20TR2-034 and 20TR2-035. ZPMC QC inspector Xu Jie was present at this time of this observation and informed this QA inspector of the work that is in process and identified Fu Guo Gang as the CWI. It was stated that ZPMC had 4 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- 20TR2-034-015  
WPS-B-P-2211-TC-U5b  
Welder- 044541

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1G/SMAW/CJP

Weld- 20TR2-034-011  
WPS-B-P-2211-TC-U5b  
Welder- 040614, 041271  
1G/SMAW/CJP

Weld- 20TR2-035-011  
WPS-B-P-2211-TC-U5b  
Welder- 046769  
1G/SMAW/CJP

### Trial Assembly

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Trial Assembly ZPMC was in process of welding on Lift 12. ZPMC QC inspector Wang Zhu was present at this time of this observation and informed this QA inspector of the work that is in process and identified Zhu Zhong Hai as the CWI. It was stated that ZPMC had 2 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

CWR2844 Rev. 0  
12BW + 12CW  
Weld- Deck Plate Splice  
WPS-345-SMAW-4G-FCM-Repair-1  
Welder-046709  
4G/SMAW/CJP

12BE Corner Assembly (BK-side)  
CA3002  
WPS-B-P-2112  
Welder-62200  
2F/SMAW/Alignment Aids

The following digital picture illustrates welding deck plate critical weld repair.

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

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## Summary of Conversations:

“As noted within the contents of this report.”

## 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 James Devey 1500026784, who represents the Office of Structural Materials for your project.

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**Inspected By:** Hasler, Mike

Quality Assurance Inspector

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**Reviewed By:** Riley, Ken

QA Reviewer