

**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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021937**Date Inspected:** 14-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:** Lu Li Qing**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, Steel Barrier**Summary of Items Observed:**

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

**BAY 10**

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08546 from ZPMC for Bay 10. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as Cantilever Box Bracket Assembly. The weld designations reviewed are as follows.

BK15A-001-030

**BAY 11**

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08546 from ZPMC for Bay 11. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as Traveler Rail. The weld designations reviewed are as follows.

30TR2-001, 012, 28TR1-001, 002, 32TR1-001, 012, 32TR2-001, 012, 34TR1-001, 012, 33TR1-001, 002, 32TR1-004, 005, 015, 016, 32TR2-004, 005, 015, 016, 30TR2-004, 005, 015, 016, 25TR2-003, 005, 014, 015, 30TR1-004, 005, 015, 016, 33TR1-004, 005, 014, 015, 35TR1-001, 012, 28TR1-004, 005, 014, 015.

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## WELDING INSPECTION REPORT

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### BAY 14

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

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

ZPMC QC is identified as Zhong Yang Gang.

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.

Component: Floor Beam I Rib

PCMK: SEG3019AJ

Weld Number: 053, 058

Welder: 216086

WPS-345-SMAW-3G-FCM-REPAIR

WR20245

Component: Floor Beam I Rib

PCMK: SEG3019BB

Weld Number: 099

Welder: 215553

WPS-345-SMAW-3G-FCM-REPAIR

WR20246

### BAY 16

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Shielded Metal Arc Welding (SMAW), and Flux Cored Arc Welding (FCAW) processes.

ZPMC QC is identified as Ma Qian Li.

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.

Component: Steel Barrier

PCMK: E2-SB37-001

Weld Number: 063~074, 084, 085

Welder: 206296

WPS-B-P-2133

Component: Steel Barrier

PCMK: E2-SB24B-001

Weld Number: 022, 023

Welder: 222396

WPS-B-P-2132

Component: Steel Barrier

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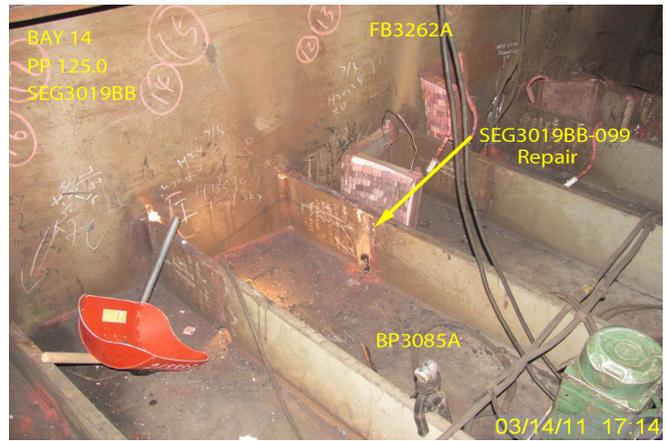
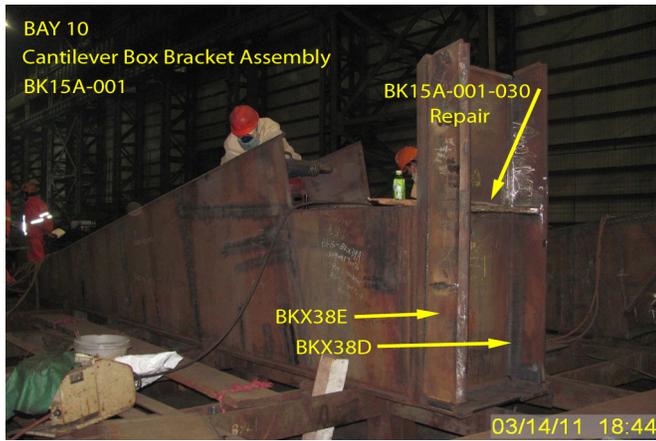
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PCMK: W5-SB31A-001  
Weld Number: 063~074  
Welder: 053753  
WPS-B-P-2113

Component: Steel Barrier  
PCMK: E2-SB33-001  
Weld Number: 001~012  
Welder: 201905  
WPS-B-P-2113

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

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**Inspected By:** Combs,Dennis

Quality Assurance Inspector

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**Reviewed By:** Riley,Ken

QA Reviewer