

**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-022772**Date Inspected:** 13-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**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 14**

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08538 from ZPMC for Bay 14. This QA inspector performed magnetic particle testing (MT) verification of welds after ZPMC had performed their MT inspection. The segment is identified as OBG Floor Beam. The weld designations reviewed are as follows.

FB3316-001-094

FB3317-001-143

SEG3020V-043, 045

SEG3020W-021, 023, 029, 031, 033

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.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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Component: Floor Beam

PCMK: SEG3019D

Weld Number: 323

Welder: 216086

WPS-345-SMAW-2G-FCM-REPAIR

CWR2677

Component: Longitudinal Diaphragm

PCMK: SEG3019AA

Weld Number: 025

Welder: 216086

WPS-345-SMAW-2G-FCM-REPAIR

CWR2755

Component: Anchor Plate

PCMK: SEG3019

Weld Number: 003

Welder: 215553

WPS-345-SMAW-2G-FCM-REPAIR

CWR2822

Component: Longitudinal Diaphragm

PCMK: SEG3019Y

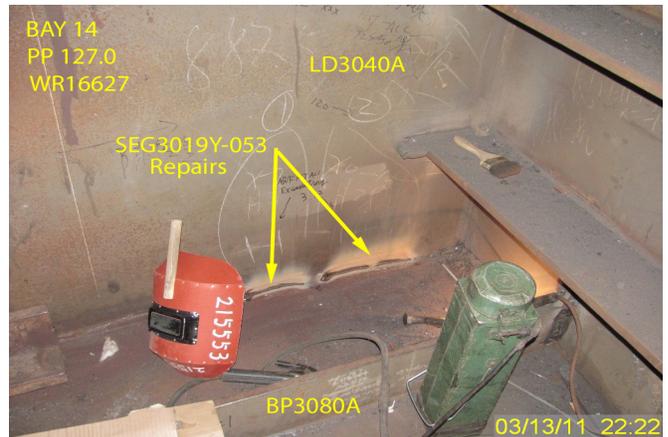
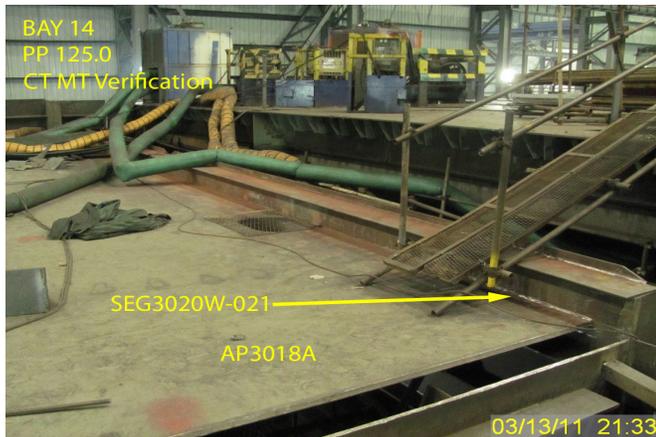
Weld Number: 053

Welder: 215553

WPS-345-SMAW-2G-FCM-REPAIR

WR16627

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



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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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

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

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