

**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-022778**Date Inspected:** 25-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:** Wang Jun**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 QA Inspector observed the following work in progress for Bay 14.

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

ZPMC QC is identified as Wang Xiang Pin.

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

PCMK: SEG3020L

Weld Number: 018

Welder: 069896

WPS-B-P-2112-FCM

Component: Traveler Rail

PCMK: TR3001TR1-001

Weld Number: 001

Welder: 201215

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WPS-B-T-2231-ESAB

Component: Traveler Rail

PCMK: TR3008TR2-001

Weld Number: 025, 026

Welder: 067876

WPS-B-T-2231-ESAB

Component: Traveler Rail

PCMK: TR3002TR2-001

Weld Number: 017, 018

Welder: 047866

WPS-B-T-2231-ESAB

Component: Side Plate

PCMK: SEG3014N

Weld Number: 340

Welder: 066673

WPS-B-T-4212-B-U2-1

Component: I Rib

PCMK: SEG3014S

Weld Number: 002

Welder: 067641

WPS-B-P-2211-TC-U4b-FCM

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08630 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 Side Plate I Ribs. The weld designations reviewed are as follows.

SEG3009N-011~016, 031, 032, 033, 035

SEG3009S-054, 055, 065~068, 078, 079, 087, 088, 096, 097, 103, 104

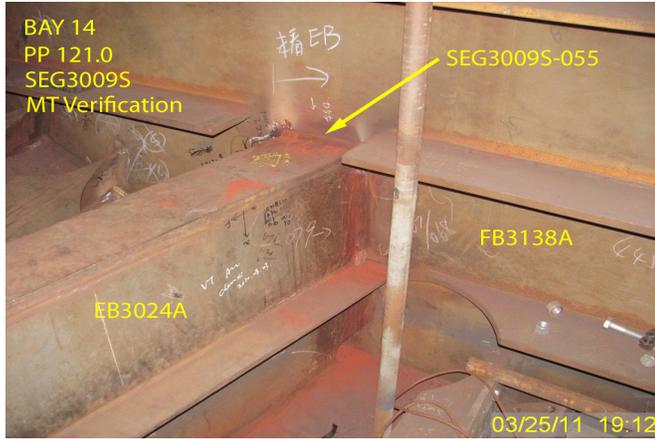
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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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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