

**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-026369**Date Inspected:** 26-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:** Lv 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, Vikram Singh was present during the times noted above for observations relative to the work being performed at ZPMC.

**WELDING**

OBG Bay 14

This QA Inspector randomly observed the following work in progress:

**Flux Cored Arc Welding (FCAW)**

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3020B-053 located on the OBG Segment 14W. The welder is identified as 066239. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3020C-053 located on floor beam of the OBG Segment 14W. The welder is identified as 045175. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

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This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as TR3007TR1-001-012 located on traveler rail. The welder is identified as 067876. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as TR3021TR1-001-013 located on traveler rail. The welder is identified as 066695. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-ESAB.

### Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG30120U-591 located on anchor plate of the OBG Segment 14W. The welder is identified as 067609. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020AQ-025 located on the OBG Segment 14W. The welder is identified as 051348. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3015C-014 located on Corner assembly to side plate of the OBG Segment 13CW. The welder is identified as 066621. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3014F-216 located on vertical plate of the OBG Segment 13BW. The welder is identified as 067588. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3014M-001 located on corner assembly to side plate of the OBG Segment 13BW. The welder is identified as 067942. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3014F-159 located on vertical plate of the OBG Segment 13BW. The welder is identified as 066674. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020AP-039 located on anchor plate of the OBG Segment 14W. The welder is identified as 066398. ZPMC

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Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair and B-WR20503.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as OBW13A-018 located on Edge Plate to Edge Plate of the 13BW and 13CW. The welder is identified as 066673. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-U4b-FCM-1. For more details please see attached photo below:

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



### Summary of Conversations:

No relevant conversations were reported on this date.

### 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, 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Singh, Vikram	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson, Rodney	QA Reviewer

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