

**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-023513**Date Inspected:** 21-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Geng Wei**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 Structure**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Mr. Manuel Teall was present during the times noted above for observations relative to the work being performed at ZPMC.

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On this day CALTRANS OSM Quality Assurance (QA) Inspector Manuel Teall was present during the times noted above for observations relative to the fabrication of the Self-Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

The FCAW process on weld joint no: SEG3020F-014 [DP diaphragm X4856M of DP 3171A to DP diaphragm X4857C of DP 3172A, CJP weld at PP128]. The welder is identified as 067275 and was observed welding in 3G position. ZPMC QC was identified as Mr. Liu Fang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

The FCAW process on weld joint no: SEG3020F-011 [DP diaphragm X4856C of DP 3170A to flange of FB3336A, CJP weld at PP128]. The welder is identified as 067888 and was observed welding in 2G position. ZPMC QC was identified as Mr. Liu Fang. The welding variables recorded by this QC appeared to comply with

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# WELDING INSPECTION REPORT

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WPS: B-T-2232-ESAB.

The FCAW process on weld joint no: SEG3020L-017 [DP diaphragm X4818B of DP 3170A to DP diaphragm X4818A of DP 3171A, CJP weld at PP127]. The welder is identified as 066881 and was observed welding in 3G position. ZPMC QC was identified as Mr. Liu Fang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

The FCAW process on weld joint no: SEG3020Y-015 [Longitudinal Diaphragm (LD) 3051A to DP diaphragm X4882E of DP 3172A, CJP weld at PP127 to PP127.5]. The welder is identified as 066421 and was observed welding in 2G position. ZPMC QC was identified as Mr. Liu Fang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

The FCAW process on weld joint no: SEG3020Y-016 [LD 3051A to DP diaphragm X4882G of DP 3172A, CJP weld at PP127.5 to PP128]. The welder is identified as 067949 and was observed welding in 2G position. ZPMC QC was identified as Mr. Liu Fang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

The FCAW process on weld joint no: SEG3020Y-017 [LD 3051A to DP diaphragm X4882H of DP 3172A, CJP weld at PP128 to PP128.3]. The welder is identified as 045143 and was observed welding in 2G position. ZPMC QC was identified as Mr. Liu Fang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

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

On this date Caltrans OSM Quality Assurance (QA) Inspector ,Mr. Manuel Teall was present during the times noted above for observations relative to the work being performed at ZPMC.

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

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<b>Inspected By:</b>	Teall,Manuel	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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