

**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-026341**Date Inspected:** 21-Apr-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 TA-Yard

This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3007AA-005 located on X8E stiffener of the OBG Segment 13AE. The welder is identified as 215553. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. 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 SEG3013A-022 located on side plate to vertical plate of the OBG Segment 13AW. The welder is identified as 047864. ZPMC Quality Control (QC) is identified as Mr. Zhang Qiang. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

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This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3007AA-048 located on X8E stiffener of the OBG Segment 13AE. The welder is identified as 200113. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as EP3023-029 located on edge plate of the OBG Segment 13AW. The welder is identified as 067611. ZPMC Quality Control (QC) is identified as Mr. Zhang Qiang. The welding variables recorded by QC appeared to comply with WPS-B-P-2211-B-U2-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as CA3010-005 located on edge plate to side plate of the OBG Segment 12CW. The welder is identified as 067829. ZPMC Quality Control (QC) is identified as Mr. Zhang Qiang. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

### Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3013R-221 located on edge beam of the OBG Segment 13AW. The welder is identified as 066673. ZPMC Quality Control (QC) is identified as Mr. Zhang Qiang. 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 SEG3013AP-021 located LD to floor beam of the OBG Segment 13AW. The welder is identified as 048433. ZPMC Quality Control (QC) is identified as Mr. Zhang Qiang. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

During random in process observations of OBG Segment 13BW, this QA inspector observed AB/F personnel performing Ultrasonic Testing on weld joint identified as OBW13A-001-016 located on deck panel to deck panel of OBG Segment 13BW & 13CW. This QA performed Visual Testing (VT) of the joint and found that appeared to be in general compliance with the applicable contract documents. 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.

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# WELDING INSPECTION REPORT

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## 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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