

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-023284**Date Inspected:** 01-May-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:** Mr. Li Yang**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 Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

Trial Assembly / OBG segment 13AW

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of repair weld # SEG3013AD-035, as per B-CWR # 2935. The welder is identified as 067572. Quality Control (QC) is identified as Shen Jian Bo. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-FCM-Repair. See attached photograph Pic\_001.

Trial Assembly / OBG segment 13AW

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4F position of weld # SEG3013AA-090. The welder is identified as 066002. Quality Control (QC) is identified as Shen Jian Bo. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-FCM-1.

Trial Assembly / OBG segment 13AW

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4F position of weld # SEG3013AA-126. The welder is identified as 067572. Quality Control (QC) is identified as Shen Jian Bo. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-FCM-1.

Trial Assembly / OBG segment 13AW

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of weld # SEG3013AL-088. The welder is identified as 067103. Quality Control (QC) is identified as Shen Jian Bo. The welding variables recorded by QC appeared to comply with WPS- B-T-2233-ESAB.

Trial Assembly / OBG segment 13AW-13BW

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 1G position of deck panel weld # OBW13-001. The welder is identified as 067876. Quality Control (QC) is identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS- B-T-223(2)1-ESAB.

Trial Assembly / OBG segment 12CW

This QA Inspector observed the following work in progress:

This QA Inspector observed ABF personnel performing Magnetic Particle Testing (MT) on OBG12CW Deck Panel temporary attachment removed area.

Trial Assembly / OBG segment 14E

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of repair weld # SEG3019AL-010, as per B-WR # 20235. The welder is identified as 215553. Quality Control (QC) is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-FCM-Repair.



---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

**Summary of Conversations:**

No relevant conversations 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 James Devey (+86) 15000026784 , who represents the Office of Structural Materials for your project.

---

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

---