

**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-023759**Date Inspected:** 17-May-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Sun Tian Liang**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**Summary of Items Observed:**

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

Ultrasonic Testing (UT) – NWIT Document No: 009154

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 13B/CE. The weld designations reviewed are as follows:

1. AH3151-002, 004
2. AH3152-001

OBG Trail Assembly Yard

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SA3136-006-001, 002, 003 and 004 located on side plate connected SA3136 at panel point 123 to 123.5 FL2 side of OBG Segment 13CW. ZPMC Welder is identified as 045240. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-ESAB.

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FCAW welding of weld joint SA3137-030-009, 010, 011 and 012 located on bottom plate connected SA3137 at panel point 124 to 124.5 FL2 side of OBG Segment 13CW. ZPMC Welder is identified as 066695. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-ESAB.

FCAW welding of weld joint SEG3014S-017 located on vertical plate RS stiffeners at panel point 122 of OBG Segment 13BW. ZPMC Welder is identified as 066825. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-ESAB.

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3014D-229, 230 and 231 located on vertical plate RS stiffeners at panel point 121.5 of OBG Segment 13BW. ZPMC Welder is identified as 046704. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2211-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3014F-260, 261 and 262 located on vertical plate RS stiffeners at panel point 121 of OBG Segment 13BW. ZPMC Welder is identified as 040614. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2211-B-U2-FCM-1.

SMAW welding of weld joint SEG3015H-258 located on vertical plate RS stiffeners at panel point 123 of OBG Segment 13CW. ZPMC Welder is identified as 040270. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3015K-211 located on vertical plate RS stiffeners at panel point 122.5 of OBG Segment 13CW. ZPMC Welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1. See the attached pictures.

general compliance with the applicable contract documents.



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**Summary of Conversations:**

Only general conversation was held between QA and QC concerning this project.

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

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<b>Inspected By:</b>	Kumar,Vibin	Quality Assurance Inspector
<b>Reviewed By:</b>	Patel,Hiranch	QA Reviewer

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