

**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-023928**Date Inspected:** 25-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**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, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

**Trial Assembly**

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Wong Xiang Pin and ABF QA Sha Zhi.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14E

PCMK: DP3161-002

Weld No: 346

Welder: 501946

Weld Repair No. B-WR20985

WPS-345-SMAW-3G(3F)-FCM-Repair-1

Components; OBG 14E

PCMK: SEG3019AY

Weld No: 114,115,117

Welder: 044779

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Weld Repair No. B-WR21028  
WPS-345-SMAW-3G(3F)-FCM-Repair-1

Components; OBG 14E  
PCMK: SEG3019J  
Weld No: 205,200,190,185

Welder: 037997  
Weld Repair No. B-WR21029  
WPS-345-SMAW-3G(3F)-FCM-Repair-1

Components; OBG 14E  
PCMK: DP3166-001  
Weld No: 002~005  
Welder: 037723  
WPS-B-P-2114-FCM-1

Components; OBG 14E (see photo)  
PCMK: DP3156-001  
Weld No: 001~010  
Welder: 068097  
WPS-B-P-2114-FCM-1

Components; OBG 13CE  
PCMK: VP3007-001  
Weld No: 011,023,036,049  
Welder: 058102  
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 14E  
PCMK: VP3016-001  
Weld No: 001~004  
Welder: 058102  
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14E  
PCMK: FB3260-001  
Weld No: 048,049,049,053  
Welder: 049769  
WPS-B-P-2112-FCM-1

Components; OBG  
PCMK: SEG3019V  
Weld No: 090,091,095,096  
Welder: 050977

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WPS-B-P-2212-TC-U4b-FCM-1

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Wong Xiang Pin and ABF QA Sha Zhi.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 13BE

PCMK: SA7016-(001~005)

Weld No: 001~006

Welder: 055491

WPS-B-T-2132-ESAB

Components; OBG 13CE

PCMK: SA3037-(001~006)

Weld No: 001~004

Welder: 052696

WPS-B-T-2132-ESAB

Components; OBG 13AE

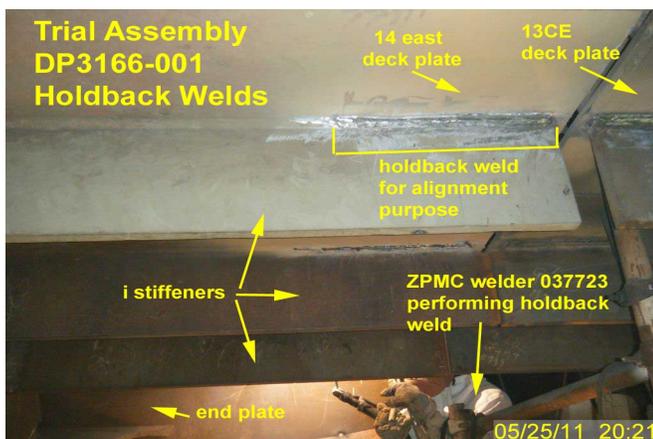
PCMK: OBE13AA

Weld No: 003,004

Welder: 050242

WPS-B-T-2232-ESAB

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



## Summary of Conversations:

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“No relevant conversations.”

## **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 1500026784, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Leavitt,Kelly	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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