

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-023983**Date Inspected:** 04-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), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**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 Components**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector, Anand Upadhye was present during the times noted above for observations relative to the work being performed.

## NDT

Outside Yard – OBG Trial Assembly/ Bay 14

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted notification number 09023 and 09024.

Ultrasonic Testing (UT).

This QA inspector performed UT of approximately 10 % of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

DP3146-001-256, 255, 253, 252, 250, 249, 247, 246, 244, 243.

DP3133-001-029, 028, 026, 025, 023, 022, 020, 019.

SEG3014B-144.

BK017-001-019, 022, 003.

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BK017B-001-022.

## WELDING

This QA Inspector observed the following work in progress:

### Outside Yard – OBG Trial Assembly

This QA Inspector observed ZPMC qualified welding personnel identified as 066695 perform welding by Flux Cored Arc Welding (FCAW), on Deck panel diaphragm to Floor beam weld at panel point PP128.3 of OBG Segment 14W. Weld joint is identified as SEG3020D-038. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2232-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 045246 perform repair welding by Shielded Metal Arc Welding (SMAW), on Top Anchor plate to Side plate weld of OBG Segment 14W. Weld joint is identified as SEG3020AQ-025. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1, which is used as per Critical Welding Repair Report B-CWR2923 R1.

This QA Inspector observed ZPMC qualified welding personnel identified as 070101 perform welding by Flux Cored Arc Welding (FCAW), on Deck panel diaphragm to Anchor plate weld at panel point 127 of OBG Segment 14W. Weld joint is identified as SEG3020L-015. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2232-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 067949 perform welding by Flux Cored Arc Welding (FCAW), on Deck panel diaphragm to Deck panel diaphragm weld at panel point 127 of OBG Segment 14W. Weld joint is identified as SEG3020L-014. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2233-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 037748 perform welding by Shielded Metal Arc Welding (SMAW), on Floor beam to Anchor plate weld at panel point 127 of OBG Segment 14W. Weld joint is identified as SEG3020L-013. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1.

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

### **Summary of Conversations:**

No significant conversations were reported on this date.

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### 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, phone: 15000422372 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Upadhye,Anand	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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