

**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-024855**Date Inspected:** 25-Jun-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:** Liu Hua Jie**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, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing:-

BAY #14

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Segment 13 and 14E "I" ribs connection plates. The weld designation reviewed is as follows:

SA3042-002-005,006

SA3035-011-007,008

SA3035-012-007,008

SA3040-015-005

SA3040-016-005

In process Inspection:-

BAY#13

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG Segment 14W Traveler rail bracket. The weld joint was designated as: SA8514-001-013. The welder is identified as #043661. ZPMC CWI is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appear to comply with WPS-B-P-2213-TC-U4C. Please see the attached picture.

This QA Inspector observed the following work in progress:

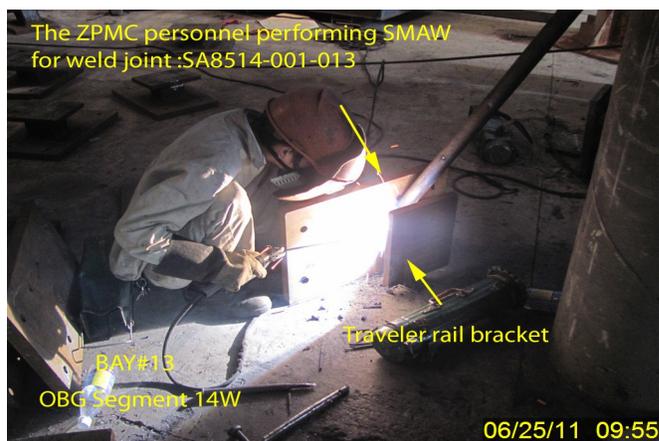
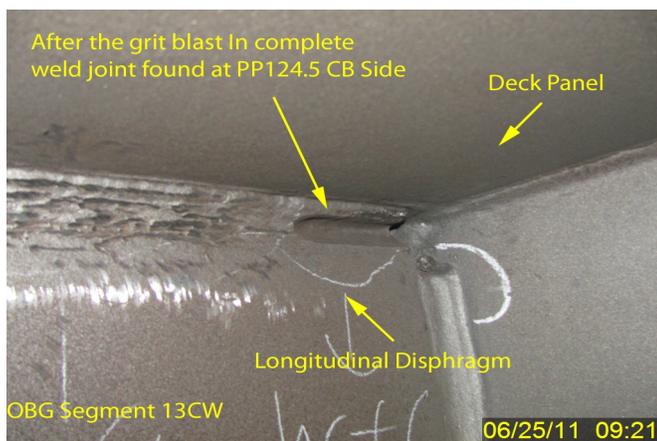
SMAW in the 3G position for the OBG Segment 14W Traveler rail bracket. The weld joint was designated as: SA8514-001-021. The welder is identified as #043661. ZPMC CWI is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appear to comply with WPS-B-P-2213-TC-U4C.

Visual Inspection after Blast

OBG Segment 13BW&13CW

This QA Inspector performed a preliminary random visual inspection after the grit blast of the Interior components of the FL2 Deck panel “U” ribs, floor beam and longitudinal diaphragm of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection. Please see the attached picture.

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



## Summary of Conversations:

No Relevant Conversation.

## 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 150-0042-2372, who represents the Office of Structural Materials for your project.

---

---

# WELDING INSPECTION REPORT

*( Continued Page 3 of 3 )*

---

---

<b>Inspected By:</b>	Pillai,Pandaram	Quality Assurance Inspector
----------------------	-----------------	-----------------------------

<b>Reviewed By:</b>	Patel,Hiranch	QA Reviewer
---------------------	---------------	-------------