

**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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016610**Date Inspected:** 28-Aug-2010**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. Geng Wei & Mr. Xu Tao**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 Segments**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.

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 044771 perform Submerged Arc Welding (SAW) Welding on OBG Segment 13AE, weld joint identified as SEG3007AE-002. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 044790 perform Flux Core Arc Welding (FCAW) Welding on OBG Segment 13AE, weld joint identified as SEG3007AD-005 and 006. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-U2-F.

This QA inspector observed ZPMC qualified welding personnel identified as 045270 perform SAW Welding on OBG Segment 13BW, weld joint identified as SEG3015A-001. ZPMC QC is identified as Mr. Xia Chun Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 047866 perform FCAW Welding on

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## WELDING INSPECTION REPORT

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OBG Segment 13CW, weld joint identified as CA3016B – 167 and 168. ZPMC QC is identified as Mr. Xia Chun Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

This QA inspector observed ZPMC personnel performed Ultrasonic Testing (UT) on OBG Segment 13BW Side plates splice joint, weld joint identified as SEG3014N-001.

### CB 16 Diaphragm

This QA inspector observed ZPMC qualified welding personnel identified as 202121 perform Flux Core Arc Welding (FCAW) Welding on Cross Beam 16, weld joint identified as SSD25-PP110-197 and 200. ZPMC QC is identified as Mr. Wang Wei ming. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

### Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 062808 perform Flux Core Arc Welding (FCAW) welding on suspender bracket, weld joint identified as SB019-078-026 and 032. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 062755 perform FCAW welding on suspender bracket, weld joint identified as SB016-072-026 and 032. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

### OBG Segment 12AE

This QA inspector observed ZPMC qualified welding personnel identified as 050232 perform Shield Metal Arc Welding (SMAW) welding on OBG Segment 12AE, weld joint identified SEG3001J-226 and 246. ZPMC QC is identified as Mr. Li Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2212-Tc-U4b-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 044772 perform SMAW repair welding on OBG Segment 12AE, weld joint identified SEG3001R-002 and 003. ZPMC QC is identified as Mr. Li Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3G(3F)-FCM-Repair.

### Visual Inspection after Blast

### Segment 11AW

This QA Inspector performed a preliminary random visual inspection after the grit blast of the exterior components of the deck panel, floor beams and corner assemblies of this segment. Areas of visual weld defects

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# WELDING INSPECTION REPORT

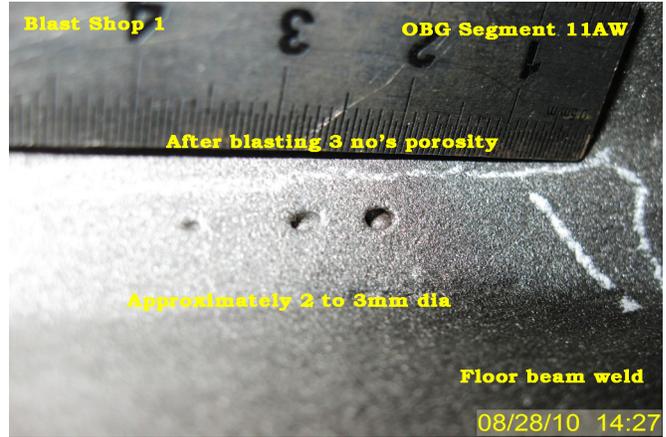
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that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection. See the attached pictures.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



### 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>	McClendon,Timothy	QA Reviewer

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