

**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-016959**Date Inspected:** 20-Sep-2010**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:** Tower and OBG Components**Summary of Items Observed:**

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

Bay 11

This QA Inspector randomly observed the following work in progress in Bay 11:

SMAW tack welding on PCMK BK5A, edge plate to bike path deck. QC was identified as ZPMC CWI Yu Dong Ping (QC1). QC1 was unable to provide the weld number to this QA Inspector. Welder was identified as 220191. Welding variables recorded by QC1 appeared to comply with WPS-B-P-2214-B-U2.

SMAW tack welding on the back side of backing plate to bike path plate located on PCMK BK4A/BKPL3A. QC was identified as QC1. QC1 was unable to provide the weld number to this QA Inspector. See photo below of bike path plate identification observed by this QA Inspector on underside of plate. Welder was identified as 202319. Welding variables recorded by QC1 appeared to comply with WPS-B-P-2112.

Bay 10

This QA Inspector randomly observed no apparent welding work in progress in Bay 10. However, the following work was being performed:

ZPMC personnel finish drilling of previously scored bolt holes through various tower, lift 5, skin splice plates using magnetically held drill presses. See photo below.

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

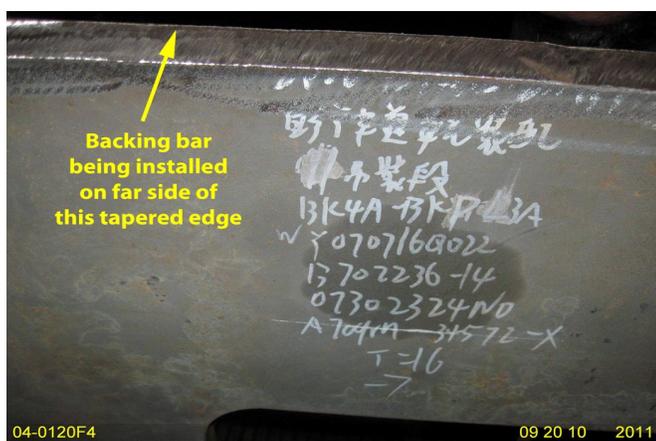
---

## Heavy Dock

This QA Inspector randomly observed the following on the Heavy Dock:

No apparent welding related work was being performed on the Heavy Dock. All 4 towers' lift 3 were connected and positioned vertically on a base pedestal at end of the Heavy Dock. East, south, west, and north towers, lift 4 were positioned on top of east, south, west, and north towers, lift 3, respectively, on the Heavy Dock. The ZPMC 4000 ton floating crane was moored to the end of the Heavy Dock and sitting idle.

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



## Summary of Conversations:

As noted above.

## 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 Micheal Ng, 159-2184-5703, who represents the Office of Structural Materials for your project.

---

**Inspected By:** Goulet, George

Quality Assurance Inspector

**Reviewed By:** Clifford, William

QA Reviewer

---