**DEPARTMENT OF TRANSPORTATION**
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

# WELDING INSPECTION REPORT

**Resident Engineer:** Siegenthaler, Peter
**Address:** 333 Burma Road
**City:** Oakland, CA 94607

**Report No:** WIR-017197
**Date Inspected:** 18-Sep-2010

**Project Name:** SAS Superstructure
**Prime Contractor:** American Bridge/Fluor Enterprises, a JV
**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

**OSM Arrival Time:** 700
**OSM Departure Time:** 1900
**Location:** Shanghai,China

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|---|---|---|---|
| **CWI Name:** | Mr.Wang 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 Segment

**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.

In process Inspection

OUTSIDE YARD

This QA Inspector observed the following work in progress:
SMAW in the 3G position for the OBG Segment 12AE, Corner Assembly X3S Plate weld No: SEG3001Y-001. The welder is identified as #216086. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-T-4213-TC-U4B-2.

This QA Inspector observed the following work in progress:
SMAW in the 4F position for the OBG Segment 12AE, Corner Assembly X3S Plate weld No: SEG3001Y-0044. The welder is identified as #044772. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2114-FCM-1.

This QA inspector observed the following work in progress:
SMAW welding of weld joint no: SEG3002F-226 located on OBG Segment 12BE Lifting Lug. Welder is identified as #051013. ZPMC QC is identified as Mr. Wang Xiang Pin. Welding was performed according to the weld repair report B-WR15131.The welding variables recorded by QC appeared to comply with the

WPS-345-SMAW-2G(2F)-FCM-Repair.

Bay #19

This QA Inspector observed the following work in progress:
FCAW in the 2F position for the Bike Path, weld No: BK004A3-013-025/026. The welder is identified as #062807. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

This QA Inspector observed the following work in progress:
FCAW in the 4G position for the Bike Path, weld No: BK004A6-010-070. The welder is identified as #208633. ZPMC QC is identified as Mr.Li ming yang.The welding variables recorded by QC appear to comply with WPS-B-T-2334-TC-P4-F. Please see the attached picture.

This QA Inspector observed the following work in progress:
FCAW in the 3G position for the Bike Path, weld No: BK004A6-011-076. The welder is identified as #062904. ZPMC CWI is identified as Mr. Wang Jie.The welding variables recorded by QC appear to comply with WPS-B-T-2233-TC-P4-F.

Bay #14

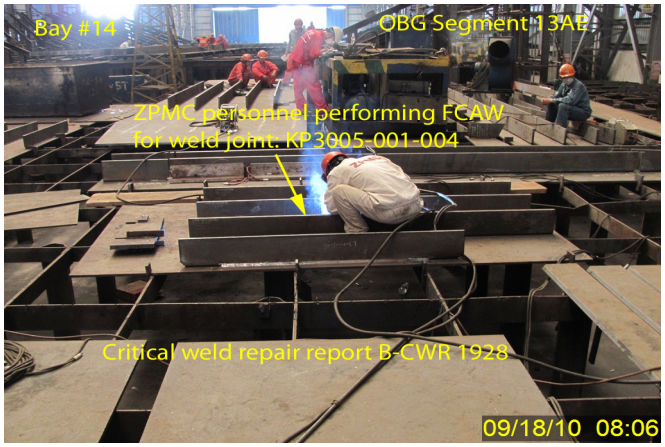
This QA inspector observed the following work in progress:
FCAW welding of weld joint no: KP3005-001-004 located on OBG Segment 13AE K-Plate Rib to Web weld. Welder is identified as #051013. ZPMC QC is identified as Mr. Wang Xu. Welding was performed according to the Critical weld repair report B-CWR 1928 and the U T report no: B787-UT-15229.The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G(2F)-FCM-Repair. Please see the attached picture.

This QA Inspector observed the following work in progress:
FCAW in the 2G position for the OBG Segment 13AE K-Plate, weld No: KP3006-001-003. The welder is identified as #067079. ZPMC CWI is identified as Mr. Zhang Lin. The welding variables recorded by QC appear to comply with WPS-B-T-2233-TC-P4-F.

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

# WELDING INSPECTION REPORT

*( Continued Page 3 of 3 )*




**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.

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| **Inspected By:** | Pillai,Pandaram | Quality Assurance Inspector |
| **Reviewed By:** | McClendon,Timothy | QA Reviewer |