

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: 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-017865**Date Inspected:** 12-Oct-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), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC and ABF**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 13 & 14**Summary of Items Observed:**

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

**Bay #14**

Caltrans QA inspector observed a fit up group performed fit up and SMAW tack weld process on sandwich plates to anchor plate of lift 14E. The weld is T joint PJP weld. The sandwich plate ID is SA3348A/B/C/D and SA3347A/B/C/D. A numerous temporary tack welds have been welded attach between plate and plate after adjusted and secured by hand jack. The fit up and SMAW tack welding process were monitored and recorded by ZPMC and ABF QC inspector. Base on Caltrans QAI observation, no discrepancies were noted.

Caltrans QA Inspector observed two welding operators in process of semi-automatic SAW on CJP weld. The CJP weld is connected between two U-rib deck panels (DP) of lift #13CW. The weld number and plate number are SEG3232-001-003/DP3151A to DP3152A. The region of the weld joint has been pre-heating to specific desired temperature prior SAW welding. The SAW process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

Caltrans QA Inspector observed two ZPMC welders performed FCAW root pass process on plate to plate of side plate (SP) and bottom plate (BP) for lift #13AW and 13CW. The weld is designed CJP butt joint with back gouging welded flat position (1G). The plates ID are SP3099A to 13AW bottom plate and BP3074 to SP3099. The region of the weld joint has been pre-heating to specific desired temperature prior FCAW root pass welding. The FCAW process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

**CLOSING STATEMENT**

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

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# WELDING INSPECTION REPORT

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documents.

**Summary of Conversations:**

As notes within report 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 James Devey 15000026784 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Pau,Wai	Quality Assurance Inspector
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<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer
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