

**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-017934**Date Inspected:** 06-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China**CWI Name:** Chen Xi**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:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

**Bay 1**

Heat straightening of PCMK, 20TR2-046 under approved Heat Straightening procedure, HSR (B)-362. The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Zhu Lin. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 80mm.

**Bay 2**

This QA Inspector observed the following work in progress for Bay 2.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Zhu Lin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components: Floor Beam

PCMK: FB3317-001-011,012

Welder: 045209

WPS-B-T-2233-TC-U4b-F

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PCMK: FB3327-001-016~024

Welder: 045227

WPS-B-T-2233-TC-U4b-F

PCMK: FB3327-001-047

Welder: 045221

WPS-B-T-2233-TC-U4b-F

Components: Bulk Head Sub-Assembly

PCMK: SA3410-001-053

Welder: 045240

WPS-B-T-2233-TC-U4b-F

PCMK: SA3410-001-016

Welder: 045276

WPS-B-T-2233-TC-U4b-F

Bay 3

This QA Inspector observed the following work in progress for Bay 3.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Zhen Hei Feng.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components: Floor Beam

PCMK: FB3266-001-003

Welder: 217805

WPS-B-T-2132-3

PCMK: FB3286-001

Welder: 026623/055564

Report: B-CWR1822

WPS-345-FCAW-1G (1F)-Repair

Heat straightening of PCMK, FB3291-001 under approved Heat Straightening procedure, HSR 1 (B)-9544. The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Zhen Hei Feng. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 8mm.

Bay 6

This QA Inspector observed the following work in progress for Bay 6.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Shu Yang Hua.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

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Listed below are the locations that were identified by this QA inspector.

Components: Cross Beam  
PCMK: CB3002J-001-027  
Welder: 053609  
WPS-B-T-2232-TC-U5-F

PCMK: CB3002K-004-027  
Welder: 217185  
WPS-B-T-2232-TC-U5-F

Bay 7

This QA Inspector observed the following work in progress for Bay 7.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Shen Jian Guo.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components: Cross Beam  
PCMK: CB3-3C-019-003  
Welder: 215689  
WPS-B-T-2231-B-U5-F

Components: Floor Beam  
PCMK: FB3245-002-012  
Welder: 053742  
WPS-B-T-2233-TC-U4b-F

Components: Deck Plate  
PCMK: DP3165-001-137,138,140,144  
Welder: 048625  
WPS-B-T-4132

PCMK: DP3165-001-137,138,140,144  
Welder: 062447  
WPS-B-T-4132

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

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## Summary of Conversations:

No relevant conversations

## 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 15000422372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Shin,DJ

Quality Assurance Inspector

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**Reviewed By:** Carreon,Albert

QA Reviewer