

**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-018038**Date Inspected:** 29-Sep-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:** 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**Summary of Items Observed:**

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

West of Blast Bay 1-

This QA Inspector observed a transverse crack measuring 20mm in length in FL2-2 Floor beam to Longitudinal Diaphragm weld, SEG3003E-018 after ZPMC personnel excavated longitudinal linear indication found by ZPMC Ultrasonic Testing technicians as per ZPMC weld repair report WR 15764. QA observed a transverse linear indication in the excavation area measuring 20mm in length. The indication was shown to ZPMC QC Li Yan Hua. Mr. Ping stated that a Critical Weld Repair report would be submitted to Caltrans Engineering for approval prior to removing the indication. See attached photo below for additional information.

This QA Inspector observed the following work in progress: Shielded Metal Arc Welding (SMAW) of OBG Segment 12BE weld, SEG3002F-600. ZPMC welder was identified as 054013. ZPMC QC was identified as Li Ping. ZPMC CWI was identified as Wang Jie. The welding appeared to be in conformance with welding procedure specification, WPS-345-SMAW-2G(2F)-Repair.

Flux Cored Arc Welding (FCAW) of OBG Segment 12BE lifting lug weld, SEG3002F-600. ZPMC welder was identified as 066695. ZPMC QC was identified as Li Ping. ZPMC CWI was identified as Wang Jie. The welding appeared to be in conformance with welding procedure specification, WPS-345-FCAW-2G(2F)-Repair.

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# WELDING INSPECTION REPORT

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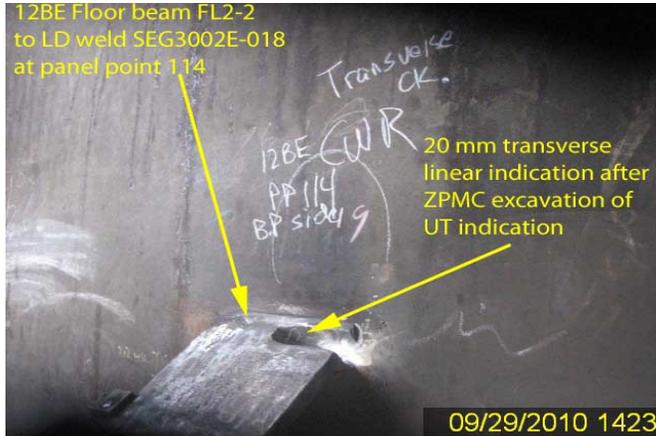
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Blast Bay 1-

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG segment 11EW upper internal base metal and weld surfaces. Areas requiring light grinding were marked for ZPMC personnel. Items which require repair were recorded for future repair.

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



## Summary of Conversations:

Only general conversation between QA and QC occurred this date.

## 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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| <b>Inspected By:</b> | Viars,Larry | Quality Assurance Inspector |
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| <b>Reviewed By:</b> | McClendon,Timothy | QA Reviewer |
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