

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
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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-018277**Date Inspected:** 13-Nov-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

|                                    |              |                                  |               |    |
|------------------------------------|--------------|----------------------------------|---------------|----|
| <b>CWI Name:</b>                   | An Qing Xing | <b>CWI Present:</b>              | Yes           | No |
| <b>Inspected CWI report:</b>       | Yes No N/A   | <b>Rod Oven in Use:</b>          | Yes No N/A    |    |
| <b>Electrode to specification:</b> | Yes No N/A   | <b>Weld Procedures Followed:</b> | Yes No N/A    |    |
| <b>Qualified Welders:</b>          | Yes No N/A   | <b>Verified Joint Fit-up:</b>    | Yes No N/A    |    |
| <b>Approved Drawings:</b>          | Yes No N/A   | <b>Approved WPS:</b>             | Yes No N/A    |    |
|                                    |              | <b>Delayed / Cancelled:</b>      | Yes No N/A    |    |
| <b>Bridge No:</b>                  | 34-0006      | <b>Component:</b>                | OBG COMPONENT |    |

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera 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 4G position for the OBG segment 11DE to 11EE, weld No. OBE11C-009. The welder is identified as #067752. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1.

SMAW in the 4G position for the OBG segment 11DE to 11EE, weld No. OBE11C-008. The welder is identified as #053871. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1.

SMAW in the 4G position for the OBG segment 11EE, weld No. CA094-006. The welder is identified as #044515. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW in the 4G position for the OBG segment 11DE, weld No. CA090-002. The welder is identified as #044515. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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WPS-B-P-2214-Tc-U4b-FCM-1.

FCAW in the 2G position for the OBG segment 11EE, weld No.CA093-001.The welder is identified as #040364. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW in the 2G position for the OBG segment 11DE, weld No.SEG72A-046.The welder is identified as #040364. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW in the 2F position for the OBG segment 11DW, weld No.SP170-001-027.The welder is identified as #053486. ZPMC QC is identified as Mr. Zhou Peng. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

FCAW in the 2F position for the OBG segment 11EW, weld No.SP171-001-008.The welder is identified as #053486. ZPMC QC is identified as Mr. Zhou Peng. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

Magnetic Particle Testing (MPT) for bay#6

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for OBG deck panel base metal repair. This QA inspector generated a (MT) report for this date .This area was previously tested and accepted by ZPMC QC MT technicians.

The deck panel designations are as follows

DP3116, DP3072

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



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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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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 150-0042-2372, who represents the Office of Structural Materials for your project.

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| <b>Inspected By:</b> | Bera,Subhasis     | Quality Assurance Inspector |
| <b>Reviewed By:</b>  | McClendon,Timothy | QA Reviewer                 |

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