

**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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018626**Date Inspected:** 19-Dec-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) Chanxing Island**Location:** Shanghai, China

**CWI Name:** Mr. Geng Wei  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** 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 Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) – NWIT Document No: 007837

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment. The weld designations reviewed are as follows:

1. AP3004-001-026, 027, 042, 043, 058, 059, 074, 075
2. AP3003-001-026, 027, 042, 043, 058, 059, 074, 075, 090, 091, 106, 107

Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SEG3015B-101 located on Side Plate to Edge Plate of the OBG Segment 13CW. ZPMC Welder is identified as 067876. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

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Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3015B-143, 144 located on Side Plate to Edge Plate of the OBG Segment 13CW. ZPMC Welder is identified as 066079. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2114-FCM-1.

FCAW welding of weld joint SEG3015B-271 located on Side Plate to Edge Plate of the OBG Segment 13CW. ZPMC Welder is identified as 045213. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-T-2232-ESAB.

FCAW welding of weld joint SEG3020D-035 located on Longitudinal Diaphragm to Floor Beam of the OBG Segment 14W. ZPMC Welder is identified as 045175. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-T-2233-ESAB.

FCAW welding of weld joint SEG3020E-053 located on Longitudinal Diaphragm to Floor Beam of the OBG Segment 14W. ZPMC Welder is identified as 201215. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-T-2233-ESAB.

Submerge Arc Welding (SAW) welding of weld joint DP3162-001-023 located on deck plate to deck plate of OBG Segment 14E. ZPMC Welder is identified as 050502. ZPMC Quality Control (QC) is identified as Mr. Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-L2c-S-2.

SAW welding of weld joint DP3163-001-017 located on deck plate to deck plate of OBG Segment 14E. ZPMC Welder is identified as 050502. ZPMC Quality Control (QC) is identified as Mr. Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-L2c-S-2.

SAW welding of weld joint DP3164-001-014 located on deck plate to deck plate of OBG Segment 14E. ZPMC Welder is identified as 050502. ZPMC Quality Control (QC) is identified as Mr. Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-L2c-S-2.

SMAW welding of weld joint SEG3013AA-001 located on edge plate to side plate of OBG Segment 13CW. ZPMC Welder is identified as 068924. ZPMC Quality Control (QC) is identified as Mr. Liu Fang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

FCAW welding of weld joint SEG3013AA-005, 006, 007, 008 009, 010 located on panel point 118 FL3 to Edge plate of the OBG Segment 13AW. ZPMC Welder is identified as 066421. ZPMC Quality Control (QC) is identified as Mr. Liu Fang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint SEG3013AA-053, 054, 055, 056, 057, 058, 059, 060 located on panel point 119 FL3 to Edge plate of the OBG Segment 13AW. ZPMC Welder is identified as 066421. ZPMC Quality Control (QC) is identified as Mr. Liu Fang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-U4b-F. See the attached picture.

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Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



## Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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

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**Inspected By:** Kumar,Vibin

Quality Assurance Inspector

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**Reviewed By:** Patel,Hiranch

QA Reviewer