

**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-018893**Date Inspected:** 20-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**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 and Tower Components**Summary of Items Observed:**

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

Bay 10

This QA Inspector randomly observed the following work in progress in Bay 10:

SMAW welding of weld joints BK004A3-031-065, 067~071, 101~105 and BK004A4-031-080, 082, 083, 085~087, 100~105 located on PCMK OBG BK004-031. Welder was identified as 500363. QC was identified as ZPMC CWI Yu Dong Ping (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Deng Zhi Bing (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2112 and WPS-B-P-2114 as verbally identified by QCA1.

SMAW tack welding of weld joints BK004A8-032-072, 073 located on PCMK OBG BK004-032, stiffener end plate to bearing plate. Welders were identified as 057239, 040400. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2112 as verbally identified by QCA1.

See photo of the drawing presented to this QA Inspector by QCA1 showing the welds noted above.

Heat straightening of weld joints NSD1-FDSA6-3-1~8 located on PCMK north tower, lift 6, skin B. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the heat straightening operation and recording data was QCA1, who was not a CWI. Heat treatment variables recorded by QCA1 appeared to

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comply with ZPMC document HSR1(T)-11642 as presented to this QA Inspector and verbally identified by QCA1.

## Bay 11

This QA Inspector randomly observed no welding related work in progress in Bay 11.

## OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

SMAW repair welding of various weld joints located on CB15, deck plate to I-ribs and web plates to I-rib stiffeners at the extreme ends of the crossbeam. Welder was identified as 040378. QC was identified as ZPMC CWI Gu Rong Jian (QC2). Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Zhu Yuan Yuan (QCA2), who was not a CWI. QCA2 informed this QA Inspector that this welding was being performed as a result of ZPMC magnetic particle testing (MT). ABF technicians were performing MT and ZPMC workers were performing grinding of the areas as directed by the MT technicians. Welding variables recorded by QCA2 appeared to comply with WPS-B-P-2113-FCM-1 as verbally identified by QC2.

## Heavy Dock

This QA Inspector randomly observed no apparent work being performed on the Heavy Dock.

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



## Summary of Conversations:

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

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<b>Inspected By:</b>	Goulet, George	Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon, Albert	QA Reviewer
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