

**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-018895**Date Inspected:** 22-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:

ZPMC workers removing an unidentified tower, lift 5 from a lift transport vehicle and positioning it on dunnage and butted up to another unidentified tower, lift 5 at the skin E connection plates. The stationary section had a splice plate attached to the connection plate at the D/E corner with temporary bolt sets.

**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:

Heat straightening of various weld joints located on PCMK OBG 12AE/12BE, side plate stiffener to side plate stiffener, south (bikepath) side, at transverse joint. QC was identified as ZPMC CWI Gu Rong Jiang (QC1). Assisting QC1 at this location and appearing to be monitoring the heat straightening operation and recording data was ZPMC QC Zhu Yuan Yuan (QCA1), who was not a CWI. Heat treatment variables recorded by QCA1 appeared to comply with ZPMC document HSR1(B)-9962 as presented to this QA Inspector and verbally

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# WELDING INSPECTION REPORT

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identified by QCA1. See photos of document below as presented to this QA Inspector.

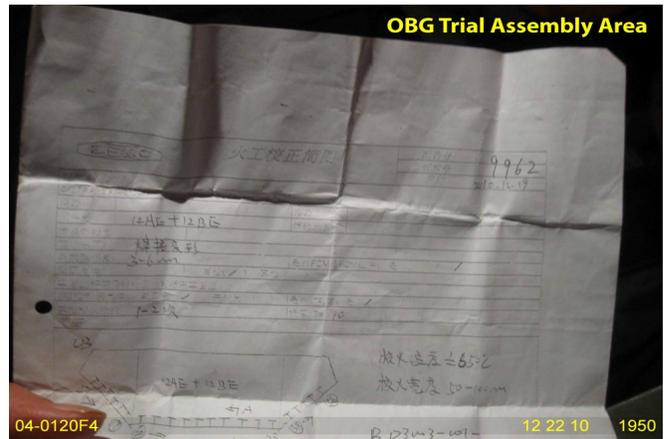
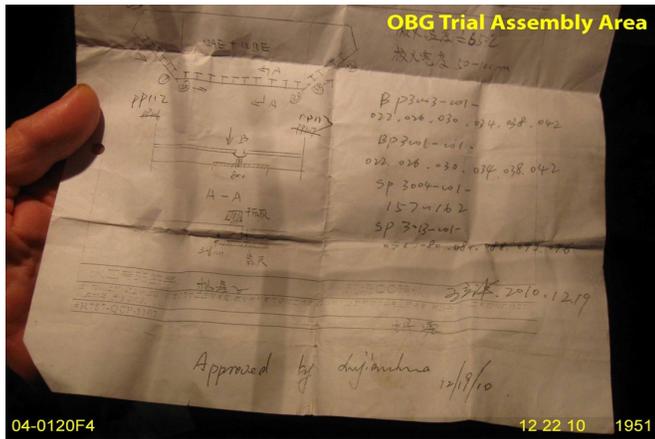
ZPMC workers adjusting the height of OBG segments 12AW/12BW on stanchions at bottom plates using motorized hydraulic jacking equipment.

ZPMC workers performing match drilling of unidentified splice plates using templates and magnetically attached drill presses.

## 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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**Inspected By:** Goulet, George

Quality Assurance Inspector

**Reviewed By:** Carreon, Albert

QA Reviewer