

**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-018998**Date Inspected:** 24-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 11**

This QA Inspector randomly observed the following work in progress in Bay 11:

FCAW welding of weld joint BK005A1-003-002 located on PCMK OBG BK005-003. Welder was identified as 054460. QC was identified as ZPMC CWI Zhang Huang (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Wang Chuan Xin (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2132-ESAB as verbally identified by QCA1.

**Bay 10**

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

SMAW welding of weld joints BK004ASD1-031-007~013 located on PCMK OBG BK004-031. Welders were identified as 040434, 044511. QC was identified as ZPMC CWI Guo Yan Fei (QC2). Weld variables recorded by QC2 appeared to comply with WPS-B-T-2312-TC-P4, WPS-B-T-2313-TC-P4 as verbally identified by QC2.

FCAW welding of weld joints SSD1-FFSA6-1-3, 4 located on PCMK tower, lift6, skin F as verbally identified by QC2. Welder was identified as 040302. QC was identified as QC2. Weld variables recorded by QC2 appeared to

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comply with WPS-B-T-2132-ESAB as verbally identified by QCA2. See photos below.

FCAW welding of weld joints SSD1-FFSA6-1-1, 2 located on PCMK tower, lift6, skin F as verbally identified by QC2. Welder was identified as 052075. QC was identified as QC2. Weld variables recorded by QC2 appeared to comply with WPS-B-T-2132-ESAB as verbally identified by QCA2. See photos below.

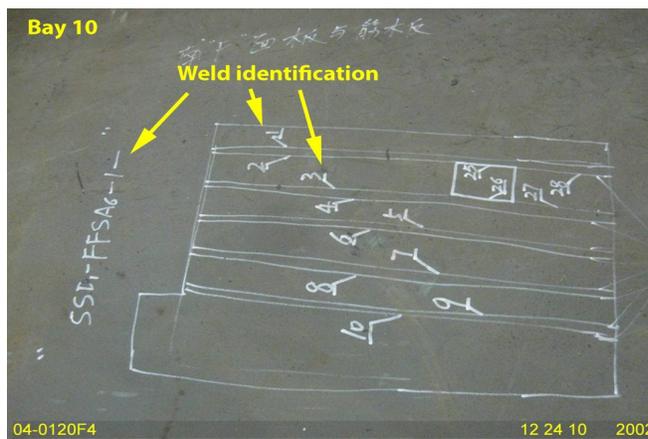
### OBG Trial Assembly Area

This QA Inspector randomly observed no welding related work in progress in the OBG Trial Assembly Area:

### 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

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**Reviewed By:** Carreon, Albert

QA Reviewer