

**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-019430**Date Inspected:** 21-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Fa Wen**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**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

Bay 14 (east line)

This QA inspector performed a random observation for the Orthotropic Bridge Girders (OBG) located at ZPMC Shanghai China. During the observation performed it was noted that at Bay 14, ZPMC was in process of welding. ZPMC QC inspector Zhan Hai Feng was present at this time of this observation and informed this QA inspector of the work that is in process, and identified ABF inspector Yu Jiao as the CWI. It was stated that ZPMC had 8 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- SEG3019E-1-182 (CWR2677)

WPS-345-SMAW-2G(2F)-FCM-Repair-1

Welder-044830

2G/SMAW/ CJP

FB3273A to Bottom Plate

Weld-SEG3019J-011

WPS-B-P-2212-TC-U4b-FCM-1

Welder-067656

2G/SMAW/ CJP

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Weld-SEG3019BB-030  
WPS-B-P-2214-TC-U4b-FCM-1  
Welder-067571  
4G/SMAW/ CJP

The following digital picture illustrates welder #044830 welding CWR2677.

## Bay 8

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 8, ZPMC was in process of welding bike path assembly welds. ZPMC QC inspector Liu Chuan Gang was present at this time of this observation and informed this QA inspector of the work that is in process, and identified Liu Fa Wen as the CWI. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld-BK004A3-063, 067, 068  
WPS-B-P-2112  
Welder-040673  
2F/ SMAW

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



## Summary of Conversations:

“As noted within the contents of this report.”

## 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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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley, Ken	QA Reviewer

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