

**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-019583**Date Inspected:** 17-Jan-2011**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**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Brett W Rice was present during the times noted above for observations relative to the work being performed at ZPMC.

**Bay 13**

This QA Inspector observed the following work in progress for Bay 13.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhong Guo Hui.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SA-7038C

Weld No: 223, 228 and 231

CWR: 2756

Welder: 216086

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

**Bay 14 West**

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Submerged Arc Welding (SAW) process.

ZPMC QC is identified as Wang Xiang Pin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

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Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3014

Weld No: 003

Welder: 250050

WPS-B-T-223(2)-IT-ESAB-1

Bay 14 East

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Zhong Guo Hui.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3007AY

Weld No: 050

Welder: 066733

WPS-B-T-2232-ESAB

PCMK: SEG-3019AG

Weld No: 001

Welder: 066571

WPS-B-T-2233-ESAB

PCMK: SEG-3019L-1

Weld No: 107, 109, 116, and 118

Welder: 037723

WPS-B-T-2233-ESAB

Bay 14 East

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhong Guo Hui.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3007AB

Weld No: 016

WR: 20166

Welder: 215553

WPS-345-SMAW-3G(3F)-FCM-Repair

PCMK: SEG-3019Z

Weld No: 012

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WR: 19726

Welder: 066416

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

PCMK: SEG-3019Z

Weld No: 013

WR: 19725

Welder: 067656

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

PCMK: SEG-3019J

Weld No: 261

Welder: 067571

WPS-B-P-2214-TC-U4B-FCM-1

Bay 19

This QA Inspector observed the following work in progress for Bay 19.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Ma Qian Li.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SB-022-104W

Weld No: 004

CWR: 2699

Welder: 062772

WPS-345-SMAW -3G(3F)-FCM-Repair

ZPMC was observed on this date performing grinding on various welds for PCMK

BK-005A-002andSB-023-106E. It was noted that during the grinding operation ZPMC was both cleaning the welds and grinding the welds to the appropriate contour.

Bay 28

This QA Inspector observed the following work in progress for Bay 28.

ZPMC was observed on this date performing grinding on various welds for PCMK

SA-3400B-005andSA-3400B-006. It was noted that during the grinding operation ZPMC was both cleaning the welds and grinding the welds to the appropriate contour.

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

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## Summary of Conversations:

No relevant conversations were reported on this date.

## 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, 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Rice,Brett	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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