

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-019604**Date Inspected:** 27-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 Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Zhang Qiang.

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: 009

Welder: 066763

WPS-B-T-2231-ESAB

**Bay 14 West**

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 Li Ping.

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.

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

PCMK: SEG-3015H  
Weld No: 002  
Welder: 066239  
WPS-B-T-2231-ESAB

PCMK: SEG-3015H  
Weld No: 002  
Welder: 066421  
WPS-B-T-2231-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 Zhang Qiang.

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-3019AA  
Weld No: 002  
CWR: 2774  
Welder: 215553  
WPS-345-SMAW-3G(3F)-FCM-Repair-1

PCMK: SEG-3019Z  
Weld No: 010  
CWR: 2775  
Welder: 216086  
WPS-345-SMAW-3G(3F)-FCM-Repair-1

PCMK: SEG-3019E-2  
Weld No: 166 and 169  
Welder: 037723  
WPS-B-P-2214-TC-U4B-FCM-1

PCMK: SEG-3019AG  
Weld No: 007  
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 observed on this date performing grinding on various welds for PCMK SB-106E, SB-106W and

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

SB-108E. 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.



### 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.

---

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

---