

**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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019627**Date Inspected:** 29-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. SHAU JIAN YUAN**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 Segment**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Santhosh Ramakrishna was present during the times noted above for observations relative to fabrication work of the Self Anchored Suspension (SAS) Superstructure being performed.

This QA inspector randomly observed the following work:

## 1. INPROCESS:

Bay-14

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Repair weld for the floor beam plate to bottom plate weld joint located on 14W. The weld is designated as SEG3020D-052. The welder is identified as 066038. ZPMC QC Mr. QIU WEN was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1. The weld repair report number is named as CWR-2734 R1.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Repair weld for the floor beam plate to bottom plate weld joint located on 14W. The weld is designated as SEG3020E-056. The welder is identified as 066398. ZPMC QC Mr. QIU WEN was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1. The weld repair report number is named as CWR-2734 R1. Further weld detail mention in attached picture.

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

ZPMC welding personnel performing Flux Core Arc Welding (FCAW) of Partial Joint Penetration (PJP) welds joining the deck plate to deck panel longitudinal diaphragm weld joint located on 14W. The weld is designated as DP3171-001-427. The welder is identified as 067520. ZPMC QC Mr. Shao Jian Yuan was onsite monitoring the welding variables. The inprocess FCAW appears to be progressing in compliance with WPS-B-T-2232-ESAB.

## 2. NDT:

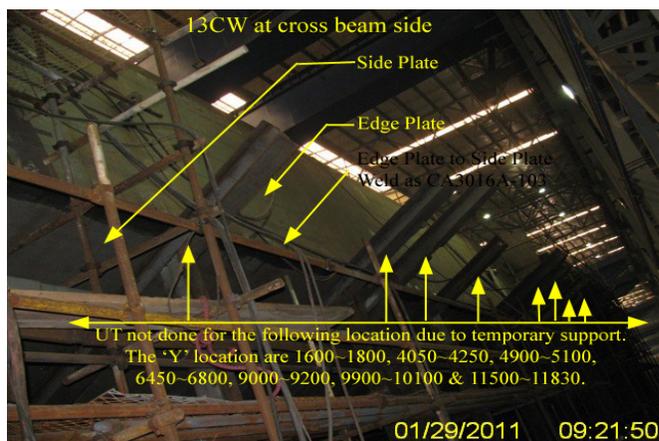
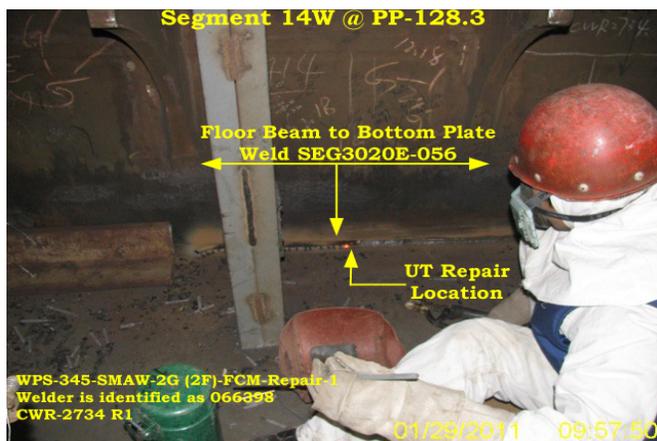
Ultrasonic Testing (UT) (A, B, C and D-Scan):

UT carried out as per the ABF submitted UT Report No UT-13W-010.

This QA Inspector performed Ultrasonic testing (UT) 10 % of the area that has been previously tested and accepted by ABF Quality control personnel. This QA inspector generated a UT (TL-6027) report on this date. The members are identified as corner joint between edge plate to side plate weld joint located on 13CW at cross beam side. According to rejection criteria of "D" Scan procedure that Caltrans QA did not find any Rejected indication at scanning area. The Weld Designation is as follows: CA3016A-103.

Note: UT not done for the following location due to temporary support. The 'Y' location are 1600~1800, 4050~4250, 4900~5100, 6450~6800, 9000~9200, 9900~10100 & 11500~11830.

Unless otherwise noted, all work observed on this date appeared to generally comply with 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 150-0042-2372, who represents the Office of Structural Materials for your project.

---

---

# WELDING INSPECTION REPORT

*( Continued Page 3 of 3 )*

---

---

---

<b>Inspected By:</b>	Pillai,Santosh	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

---