

**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-019651**Date Inspected:** 02-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), Changxing Island **Location:** Shanghai, China

**CWI Name:** Mr. Liu Yang  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** 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:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #14

This QA Inspector observed the following work in progress

Orthotropic Box Girder (OBG)

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint # 024 as per CWR no. B-CWR 2411, located on OBG Component, Deck plate of Segment 13BW, DP 3135-001. Welder is identified as 066398. ZPMC Quality Control (QC) Inspector is identified as Shao Jian Yuan. The welding variables recorded by QC appeared to comply with the WPS - 345 - SMAW -2G (2F) - FCM-Repair.

Repair welding of Weld joint # 245 as per CWR no. B-CWR 2415, located on OBG Component, Deck plate of Segment 13CW, DP 3148-001. Welder is identified as 066459. ZPMC Quality Control (QC) Inspector is identified as Shao Jian Yuan. The welding variables recorded by QC appeared to comply with the WPS - 345 - SMAW -2G (2F) - FCM-Repair.

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Repair welding of Weld joint # 254 as per CWR no. B-CWR 2418, located on OBG Component, Deck plate of Segment 13CW, DP 3148-001. Welder is identified as 067904. ZPMC Quality Control (QC) Inspector is identified as Shao Jian Yuan. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -2G (2F) - FCM-Repair.

Repair welding of Weld joint # 026 as per WRR no. B-WR 19599, located on OBG Component, Side plate to floor beam of Segment 13AW, DP 3013AD-027. Welder is identified as 066301. ZPMC Quality Control (QC) Inspector is identified as Liu Fang. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -4G (4F) - Repair.

Weld joint # 055, 056 located on OBG Component, Architectural house of Segment 13AW, AH 3001. Welder is identified as 037932. ZPMC Quality Control (QC) Inspector is identified as Shao Jia Yuan. The welding variables recorded by QC appeared to comply with the WPS – B- P -2213- B –U3B.

Weld joint # 039, 040 located on OBG Component, Architectural house of Segment 13AW, AH 3001. Welder is identified as 067572. ZPMC Quality Control (QC) Inspector is identified as Shao Jia Yuan. The welding variables recorded by QC appeared to comply with the WPS – B- P -2213- B –U3B.

Flux cored Arc welding (FCAW)

Weld joint # 019, located on OBG Component, Sub assembly plate to Bottom plate of of Segment 14W, SEG 3020BB. Welder is identified as 066695. ZPMC Quality Control (QC) Inspector is identified as Zhu lin. The welding variables recorded by QC appeared to comply with the WPS – B-T-2232 -Esab.

Weld joint # 052, located on OBG Component, Hinge plate to Bottom plate of of Segment 14W, SEG 3020D. Welder is identified as 202122. ZPMC Quality Control (QC) Inspector is identified as Zhu lin. The welding variables recorded by QC appeared to comply with the WPS – B-T-2232 -Esab.

Weld joint # 056, located on OBG Component, Hinge plate to Bottom plate of of Segment 14W, SEG 3020D. Welder is identified as 066239. ZPMC Quality Control (QC) Inspector is identified as Zhu lin. The welding variables recorded by QC appeared to comply with the WPS – B-T-2232 -Esab.

Weld joint # 108, located on OBG Component, Sub assembly plate to P.P.125 mtr. Floor Beam of Segment 14W, SEG 3020BB. Welder is identified as 066236. ZPMC Quality Control (QC) Inspector is identified as Zhu lin. The welding variables recorded by QC appeared to comply with the WPS – B-T-2233 -Esab.

Weld joint # 100, located on OBG Component, Sub assembly plate to P.P.125 mtr. Floor Beam of Segment 14W, SEG 3020BB. Welder is identified as 068445. ZPMC Quality Control (QC) Inspector is identified as Zhu lin. The welding variables recorded by QC appeared to comply with the WPS – B-T-2233 -Esab.

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For further information see below pictures:-

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



### Summary of Conversations:

No relevent Conversations.

### 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 Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Baskar, Govindarajan	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford, William	QA Reviewer

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