

**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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019756**Date Inspected:** 05-Dec-2010**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 14

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

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

ZPMC QC is identified as Wang Xian Pin.

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-3013-G 13AW

Weld No: 005, 007

Welder: 201215

WPS-B-T-2233-ESAB

Volts: 26.3

Amps: 270

PCMK: DP-3146-001 13CW

Weld No: 248

Welder: 207465

WPS-B-T-2232-ESAB

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Volts: 25.4  
Amps: 301  
PCMK: DP-3146-001 13CW  
Weld No: 245  
Welder: 203871  
WPS-B-T-2232-ESAB  
Volts: 25.7  
Amps: 300

PCMK: DP-3133-001 13BW  
Weld No: 027  
Welder: 204730  
WPS-B-T-2232-ESAB  
Volts: 26.2  
Amps: 299

PCMK: DP-3148-001 13CW  
Weld No: 027  
Welder: 048646  
WPS-B-T-2232-ESAB  
Volts: 26.2  
Amps: 299

Bay 14

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 Wang Xian Pin.

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-3013-AD 13AW  
Weld No: 25~29  
Welder: 047866  
WPS-B-P-2214-TC-U4B-FCM-1  
Volts: 24  
Amps: 146

PCMK: SEG-3013-AD 13AW  
Weld No: 30~33  
Welder: 202122  
WPS-B-P-2214-TC-U4B-FCM-1  
Volts: 23.8  
Amps: 145

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

Photos please see ; Z:\Inspector Reports\B314 Rice

**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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