

**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-019758**Date Inspected:** 10-Dec-2009**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:** 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, Mike Hasler was present during the times noted above for observations relative to the work being performed.

OBG Segment Name: 12CE / Bay 14

This Caltrans QA inspector observed Submerged Arc Welding (SAW) in progress. Welder operator is identified as #044771 welding complete joint penetration (CJP) weld in the 1G position using WPS-B-T-2221-B-L2c-S-2. The weld is identified as SEG3003A-005. ZPMC QC inspectors are identified as Mr. Zhong Guo Hui and certified welding inspector (CWI), Mr. Lv Liqing. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 11DE / Bay 14

This Caltrans QA inspector observed Flux Cored Arc Welding (FCAW) in progress. Welder is identified as #058551 welding weld identified as #SEG072-020 using WPS-B-T-B-U2-F. ZPMC QC inspectors are identified as Mr. Zhong Guo Hai and CWI, Mr. Lv Liqing. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 10CW / Bay 14

This Caltrans QA inspector observed FCAW in progress. Welder is identified as #201215 welding in the 3G using welding procedure WPS-B-T-2233TC-U4b-F. The weld is identified as #SEG063E-042. ZPMC QC inspectors are identified as Mr. Xu Tao and CWI, Mr. Liu Hua Jie. The welding variables recorded by QC appeared to comply with the WPS.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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OBG Segment Name: 11CE / Bay 13

This Caltrans QA inspector observed ZPMC shop worker free hand flame cutting more than 300mm in length. The approximate cut length for the deck plate diaphragm plate measured 746mm and 1460mm length for the floor beam plate. ABF Free Hand Flame Cutting Procedure Scope: 2.1 procedure outlines the technique and process for flame cutting of material 25mm in thickness and up to 300mm in length when mechanical guides are not available.

This QA inspector generated a Quality Assurance-Incident Report for the heat straightening violation. See Quality Assurance-Incident Report, dated 12-10-09 for additional information. ZPMC QC inspector is identified as Mr. Guo Xing Hui.

OBG Segment Name: 11CE / Bay 13

This Caltrans QA inspector observed FCAW in progress. Welder is identified as #067764 welding CJP weld identified as #SSD20A-PP101-233 in the 1G position using WPS-B-T-2214-TC-U4b-FCM-1. ZPMC QC inspectors are identified as Mr. Tang Yan Hua and CWI, Mr. Lv Liqing. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 11CE / Bay 13

This Caltrans QA inspector observed FCAW in progress. Welder is identified as #055691 welding Fillet Weld (FW) in the 2F position using WPS-B-T2232. The weld identified as #SSD20A-PP103-005. ZPMC QC inspectors are identified as Mr. Tang Yan Hua and CWI, Mr. Lv Liqing. The welding variables recorded by QC appeared to comply with the WPS.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

“As noted within the contents of this report.”

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

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

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