

**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-019778**Date Inspected:** 22-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**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 and testing relative to the work being performed.

Bay 14 (east line)

This QA inspector performed a random observation for the Orthotropic Bridge Girders (OBG) located at ZPMC Shanghai China. During the observation performed it was noted that at Bay 14, ZPMC was in process of welding. ZPMC QC inspector Zhan Hai Feng was present at this time of this observation and informed this QA inspector of the work that is in process, and identified ABF inspector Yu Jiao as the CWI. It was stated that ZPMC had 7 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

13AE

Weld- SEG3007AB-015

WPS-B-T223-ESAB

Welder-066733

3G/FCAW/CJP

14E

Weld-SEG3019BB-037

WPS-B-P-2212-TC-U4b-FCM-1

Welder-216086

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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2G/SMAW/ CJP

Weld-SEG3019BB-081  
WPS-B-P-2214-TC-U4b-FCM-1  
Welder-215553  
2G/SMAW/CJP

Weld-SEG3019BB-096  
WPS-B-P-2214-TC-P4-FCM  
Welder-067571  
2G/SMAW/PJP

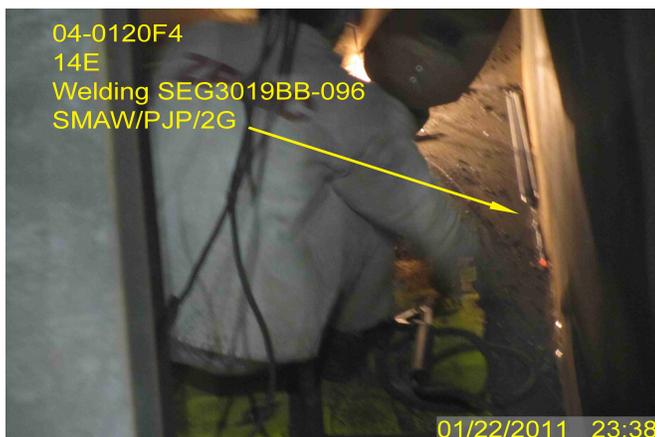
The following digital picture illustrates welder #067571 welding SEG3019BB-096.

## Bay 3

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 3, ZPMC was in process of welding critical weld repair (CWR1568), traveler rail 20TR-032 weld build-up (butter-up) on fabricated beam web. ZPMC CWI Wang Liang was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

CWR1568  
Weld-20TR2-032  
WPS-345-SMAW-1G(1F)-Repair  
Welder-058102  
Flat Position/ SMAW

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



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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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**Summary of Conversations:**

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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