

**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-019831**Date Inspected:** 11-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:** Mr. Yu Jiao (ABF)**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:** BAY 14 OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A. DeArmond was present during the time noted above and conducted observations relative to the work being performed.

OBG BAY 14

Magnetic Particle Testing (MT)

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. All components were as listed on NWIT notification no. 08141. The member(s) is/are identified as 13A East Line: Floor beam Stiffener to Bottom Plate. The weld designations reviewed are as follows:

SEG3007H-090, 091, 107, and 106

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# WELDING INSPECTION REPORT

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OBG BAY 14

This QA Inspector observed the following work in progress:

SMAW welding of complete joint penetration weld joint(s) located on lift 13C East Line SEG-3009J Bottom Plate Stiffener to Floor Beam weld number(s) 035, 037, 039 and 041. Welder is identified as welder no. 048047. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-345-SMAW-3G (3F)-Repair-FCM-1 and B-WR-20096.

SMAW welding of complete joint penetration weld joint(s) located on lift 13C East Line SEG3011E VP Stiffener to VP Stiffener weld number(s) 616 and 617. Welder is identified as welder no. 068097. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-B-P-2214-B-U2-FCM-1.

FCAW welding of complete joint penetration weld joint(s) located on lift 13A East Line SA7038 Saddle Connection Plate weld number(s) 263, 237, 238, 235, and 236. Welder is identified as welder no. 067079. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-345-FCAW-1G (1F)-ESAB-Repair-FCM-1 and B-WR-19722.

SMAW welding of complete joint penetration weld joint(s) located on lift 13A East Line SEG3007AU Stiffener to Bottom Plate weld number(s) 050 and 102. Welder is identified as welder no. 068206. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-B-T-2233-ESAB.

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

**Summary of Conversations:**

As mentioned above between QA and QC concerning this project.

**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>	DeArmond,Robert	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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