

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
 690 Walnut Ave. St. 150  
 Vallejo, CA 94592-1133  
 (707) 649-5453  
 (707) 649-5493

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-019896**Date Inspected:** 22-Jan-2011**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:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, 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 for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Li Ping.

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.

Components; OBG 13CW

PCMK: DP3148-001

Weld No: 249,250,252,253,255,256,

Welder: 067611, 037780

WPS-B-P-2213-TC-U4b-FCM-1

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located on 13AW at DP3124-001 weld location due to contour grinding and visual indications as identified by ZPMC QC Inspectors.

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located on

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

DP3148-001 weld locations due to contour grinding and visual indications as identified by ZPMC QC Inspectors.

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 Zhan Hai Feng, AB Fluor QA Yu Jiao.

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.

Components; OBG FB3260A PP125

PCMK: SEG3019V ( see photo below )

Weld No: 029

Welder: 066416

Weld Repair: WR18912

WPS-345-SMAW-3G(3F)-FCM-Repair

Components; OBG

PCMK: SEG3019BB

Weld No: 096

Welder: 067571

WPS-B-P-2213-PC-P4-FMC

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

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhan Hai Feng, AB Fluor QA Yu Jiao.

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.

Components; OBG

PCMK: SEG3019S

Weld No: 049.050

Welder: 066763

WPS-B-T-2233-ESAB

Components; OBG

PCMK: SEG3007AB

Weld No: 015

Welder: 066733

WPS-B-T-2233-ESAB

Components; OBG

PCMK: SEG3007AU

Weld No: 091,092

Welder: 037723

WPS-B-T-2233-ESAB

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

Bay 19

This QA Inspector observed the following work in progress for Bay 19.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Ma Gian Li.

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.

Components; OBG Suspender Bracket

PCMK: SB108E

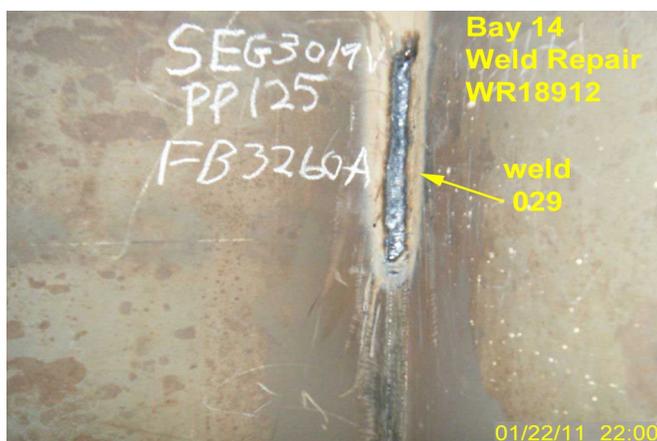
Weld No: 035

Welder: 062772

Weld Repair: SWR2731

WPS-345-SMAW-3G(3F)-Repair

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



### Summary of Conversations:

No significant 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 Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

---

**Inspected By:** Leavitt, Kelly

Quality Assurance Inspector

---

**Reviewed By:** Riley, Ken

QA Reviewer