

**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-020070**Date Inspected:** 01-Feb-2011**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) Chanxing Island **Location:** Shanghai, China**CWI Name:** Mr. Qui Wen**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 Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, 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:

Shielded Metal Arc Welding (SMAW) repair welding of weld joint SEG3020D-052 located on Floor Beam to Bottom Plate of OBG Segment 14W. ZPMC Welders are identified as 066038. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G (2F) – FCM – Repair, which is used as per Critical Welding Repair (CWR) B-CWR-2734-R1.

SMAW repair welding of weld joint SEG3020E-056 located on Floor Beam to Bottom Plate of OBG Segment 14W. ZPMC Welders are identified as 066398. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G (2F) – FCM – Repair, which is used as per Critical Welding Repair (CWR) B-CWR-2734-R1.

Flux Core Arc Welding (FCAW) welding of weld joint DP3169-001-018 located on Deck Panel of OBG Segment 14W. ZPMC Welder is identified as 067888. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

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FCAW welding of weld joint DP3169-001-266 located on Deck Panel of OBG Segment 14W. ZPMC Welder is identified as 203781. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

FCAW welding of weld joint DP3170-001-165 located on Deck Panel of OBG Segment 14W. ZPMC Welder is identified as 066239. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

SMAW welding of weld joint DP3173-001-284 located on Deck Panel of OBG Segment 14W. ZPMC Welder is identified as 067707. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM-1.

SMAW welding of weld joint DP3174-001-252 located on Deck Panel of OBG Segment 14W. ZPMC Welder is identified as 069493. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM-1.

FCAW welding of weld joint SEG3014H-001 located on Deck Panel Diaphragm to Floor Beam of OBG Segment 13BW. ZPMC Welders are identified as 067876 and 201583. ZPMC Quality Control (QC) is identified as Mr. Chen Kun. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

FCAW welding of weld joint SEG3020H-176 located on Longitudinal Diaphragm to Floor Beam of OBG Segment 14W. ZPMC Welder is identified as 067765. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-ESAB.

Sub Merged Arc (SAW) welding of weld joint OBE-13A-009 located on deck panel to deck pane splice weld joint of OBG Segment 13BE to OBG Segment 13CE. ZPMC Welder is identified as 047771. ZPMC Quality Control (QC) is identified as Mr. Geng Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-L2c-S-2.

SMAW welding of weld joint SEG3015D-325 located on Deck Panel Diaphragm to Longitudinal Diaphragm at panel point 123 of OBG Segment 13CW. ZPMC Welder is identified as 066674. ZPMC Quality Control (QC) is identified as Mr. Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

See the attached picture.

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

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## Summary of Conversations:

Only general conversation was held 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 , who represents the Office of Structural Materials for your project.

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**Inspected By:** Kumar,Vibin

Quality Assurance Inspector

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**Reviewed By:** Patel,Hiranch

QA Reviewer