

**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-020098**Date Inspected:** 10-Dec-2010**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:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Brett W Rice was present during the times noted above for observations relative to the work being performed at ZPMC.

Bay 14

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

ZPMC was using the Fluxed Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Li Ming Yang.

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.

PCMK: SEG-3014-E

Weld No: 042

WR: 18524

Welder: 066258

WPS-345-FCAW-3G(3F)-ESAB-Repair-FCM

PCMK: SEG-3014-C

Weld No: 106, 098

WR: 18509, 18510

Welder: 066258

WPS-345-FCAW-3G(3F)-ESAB-Repair-FCM

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## WELDING INSPECTION REPORT

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PCMK: SEG-3014-C

Weld No: 094

WR: 18509, 18511

Welder: 045143

WPS-345-FCAW-3G(3F)-ESAB-Repair-FCM

PCMK: DP-3133-001

Weld No: 024

CWR: 2422

Welder: 045240

WPS-345-FCAW-2G(2F)-ESAB-Repair-FCM

PCMK: DP-3133-001

Weld No: 027

CWR: 2423

Welder: 045143

WPS-345-FCAW-2G(2F)-ESAB-Repair-FCM

PCMK: DP-3148-001

Weld No: 241

CWR: 2414

Welder: 045276

WPS-345-FCAW-2G(2F)-ESAB-Repair-FCM

PCMK: DP-3148-001

Weld No: 251

CWR: 2417

Welder: 045280

WPS-345-FCAW-2G(2F)-ESAB-Repair-FCM

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 Ming Yang.

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.

PCMK: SEG-3014-G

Weld No: 098, 086

WR: 18534, 18535

Welder: 201583

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

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PCMK: SEG-3014-J  
Weld No: 077, 082  
WR: 18544, 18545  
Welder: 066258  
WPS-345-SMAW-3G(3F)-Repair

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

Photos please see ; Z:\Inspector Reports\B314 Rice

**Summary of Conversations:**

No relevant conversations were reported on this date.

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