

**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-020100**Date Inspected:** 31-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 Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhang Lin.

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: DP-3174-001

Weld No: Tack welding LD to DP

Welder: 049972

WPS-B-P-2211

PCMK: DP-3125A to DP-3126A

Weld No: Tack welding

Welder: 205098

WPS-B-P-2211

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

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

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

ZPMC QC is identified as Zhang Lin.

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: AH-3001A to EP-3124A

Welder: 207465

WPS-B-T-2232-ESAB

ZPMC was observed on this date performing grinding on various welds for PCMK DP-3135 and DP-3133. It was noted that during the grinding operation ZPMC was both cleaning the welds and grinding the welds to the appropriate contour.

Bay 19

ZPMC was observed on this date performing grinding on various welds for PCMK SB-024-106 and SB-025-106.

It was noted that during the grinding operation ZPMC was both cleaning the welds and grinding the welds to the appropriate contour.

Bay 28

PCMK: SA-3321-011

Weld No: 003 and 004

Welder: 062265

Carbon Arc Back Gouging

PCMK: SA-3321-012

Weld No: 003 and 004

Welder: 062265

Carbon Arc Back Gouging

PCMK: SA-3321-019

Weld No: 003 and 004

Welder: 062265

Carbon Arc Back Gouging

PCMK: SA-3053D-008

Weld No: 003 and 004

Welder: 062265

Carbon Arc Back Gouging

PCMK: SA-3102-012

Weld No: 003 and 004

Welder: 062265

Carbon Arc Back Gouging

---

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

ZPMC was observed on this date performing grinding on various welds for PCMK SP4, SP7, and SP8. It was noted that during the grinding operation ZPMC was both cleaning the welds and grinding the welds to the appropriate contour.

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.

---

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

---