

**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-020163**Date Inspected:** 18-Jan-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 & Tower**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations relative to the work being performed.

OBG Segment Name: OBG 6AE / Trial Assembly

This Caltrans QA inspector observed ZPMC welder performing weld repair back gouging per critical weld repair, B-CWR-1092. This QA inspector also observed the welder preheating back gouge locations, prior to back gouging.

The weld locations being back gouged are identified as DP to EP-E2, CA026-002, 004 and 006. The welding procedure specification is identified as WPS-345-SMAW-2G(2F)-FCM-Repair-1. ZPMC Quality Control (QC) inspectors are identified as Mr. Zhang Qing and certified welding inspector (CWI); Mr. Wu Zhi Cheng.

OBG Segment Name: OBG 6AW / Trial Assembly

This Caltrans QA inspector observed Shielded Metal Arc Welding (SMAW) in progress. Welder is identified as #048659 welding weld repair B-WR9729, SEG029B-009 in the 3G position using welding procedure specification WPS-345-SMAW-3G(3F)-FCM-Repair-1. ZPMC QC inspectors are identified as Mr. Wang Li Yang and CWI; Mr. Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: OBG 5AW / Trial Assembly

This Caltrans QA inspector observed SMAW in progress. Welder is identified as #054467 welding critical weld repair B-CWR-1046, SEG021A-007 in the 1G position using welding procedure specification WPS-345-SMAW-1G(1F)-FCM-Repair-1. ZPMC QC inspectors are identified as Mr. Wang Li Yang and CWI; Mr. Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with the WPS.

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OBG Segment Name: OBG 5BE DP-EP-E2 / Trial Assembly

This Caltrans QA inspector performed American Bridge / Fluor (ABF) Visual Testing (VT) and Ultrasonic Testing (UT) Verification Witness Request #01182010-1 Item 2 inspection of weld repair areas identified as CA020-002, 003 and 004. QAMT was not performed due to the surface condition of the plate having couplant on it from ABF UT inspection. Item 3 (OBG 5CE DP-EP-E2), QA inspection could not be performed due to access. The platform was not equipped with walkway screens. See Caltrans Ultrasonic Test Report (TL6027), date 01-18-2010 for additional information.

OBG Segment Name: Lift 1 Tower / Heavy Duty Dock

This Caltrans QA inspector observed Flux Cored Arc Welding (FCAW) in progress. Welder is identified as #040759 welding partial joint penetration (PJP) weld in the 3G position using WPS-B-T-2333-TC-P4-F. The weld is identified as WSD1-SA279-27; Skin B. ZPMC QC inspectors are identified as Mr. Sun Zi Wang and CWI, Mr. Gong Liang Zhu. The welding variables recorded by QC appeared to comply with the WPS.

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

**Summary of Conversations:**

“As noted within the contents of this report.”

**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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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley, Ken	QA Reviewer

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