

**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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020225**Date Inspected:** 21-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Jiao, Xu Tao**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, Dennis Combs, was present during the times noted above for the 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), and Submerged Arc Welding (SAW) processes.

ZPMC QC is identified as Zheng Zhi Wei

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

Component: Deck Plate

PCMK: DP3091A to DP3092A

Weld Number:

Welder: 058100

WPS-B-T-2221-B-L2C-S-2

Component: Deck Plate

PCMK: DP3146

Weld Number: 255, 256

Welder: 067611

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

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

Component: Deck Plate

PCMK: DP3146

Weld Number: 252, 253

Welder: 037780

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

Component: Sub Assembly

PCMK: SEG3019BB

Weld Number: 037

Welder: 215553, 216086

WPS-345-SMAW-2G-FCM-Repair

CWR2737

Component: Sub Assembly

PCMK: SEG3019BB

Weld Number: 030

Welder: 067571

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

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08256 from ZPMC for Bay 14. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as OBG. The weld designations reviewed are as follows.

SEG3007H-076, 077

SEG3007M-188

SEG3007N-227, 228

SEG3007AE-024

SEG3007AY-026

BAY 19

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

ZPMC QC is identified as Dai Gang Sheng

Heating variables recorded by QC appeared to comply with the approved Heat Straightening Repair (HSR). Listed below are the locations that were identified by this QA inspector

Component: Suspender Bracket

PCMK: SB23-106

Weld Number: 004

HSR1(B)9943

Component: Suspender Bracket

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

PCMK: SB23-104

Part Number: X67

HSR1(B)10028

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

**Summary of Conversations:**

No relevant 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 , who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Combs,Dennis	Quality Assurance Inspector
----------------------	--------------	-----------------------------

---

<b>Reviewed By:</b>	Riley,Ken	QA Reviewer
---------------------	-----------	-------------