

**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-020335**Date Inspected:** 17-Dec-2010**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. AN QIANG XING**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 (QA) Inspector Santhosh Ramakrishna was present during the times noted above for observations relative to fabrication work of the Self Anchored Suspension (SAS) Superstructure being performed.

This QA inspector randomly observed the following work:

## 1. INPROCESS:

Orthotropic Box Girder (OBG) at Trial Assembly Area:

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the edge plate to side plate hold back weld joint located on 12AW+12BW at counter weight side. The weld is designated as CA3007-005(12AW) & CA3008-001(12BW). The welder is identified as 044551. ZPMC QC Mr. WANG ZHU was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-P-2214-TC-U4b-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the edge plate to side plate hold back weld joint located on 12AW+12BW at cross beam side. The weld is designated as SEG3004AA-022(12AW) & CA3009-001(12BW). The welder is identified as 040656. ZPMC QC Mr. WANG ZHU was onsite monitoring the welding variables. The inprocess SMAW appears to be

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progressing in compliance with WPS-B-P-2214-TC-U4b-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the edge plate to deck plate hold back weld joint located on 12AW+12BW at counter weight side. The weld is designated as CA3007-006(12AW) & CA3008-002(12BW). The welder is identified as 044551. ZPMC QC Mr. WANG ZHU was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-P-2212-TC-U4b-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the edge plate to deck plate hold back weld joint located on 12AW+12BW at cross beam side. The weld is designated as SEG3004AA-021(12AW) & CA3009-002(12BW). The welder is identified as 040656. ZPMC QC Mr. WANG ZHU was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-P-2212-TC-U4b-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Repair weld for the bottom plate to side plate hold back weld joint located on CB-16 at south side, Panel Point (PP-106). The weld is designated as CB202A-016-006. The welder is identified as 040611. ZPMC QC Mr. ZHU YUAN YUAN was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1. The weld repair report number is named as CWR-2133 Critical Weld Repair (CWR), Due to UT repair gouging done more than 65% thickness of depth & full length of hold back in FCM weld. Further weld detail mention in attached picture.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Repair weld for the bottom plate to side plate hold back weld joint located on CB-16 at south side, Panel Point (PP-104). The weld is designated as CB202A-016-018. The welder is identified as 046709. ZPMC QC Mr. ZHU YUAN YUAN was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1. The weld repair report number is named as CWR-2133.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Repair weld for the floor beam to bottom plate hold back weld joint located on CB-16+11DE at Panel Point (PP-106). The weld is designated as FB028-012-128. The welder is identified as 046709. ZPMC QC Mr. ZHU YUAN YUAN was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1. The weld repair report number is named as WR-19175.

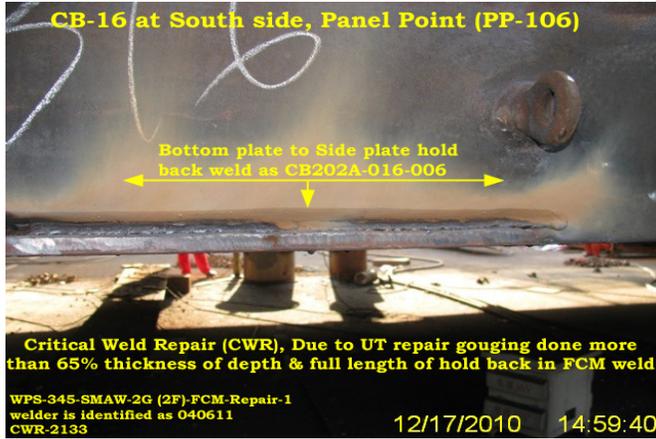
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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## 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 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Pillai,Santosh	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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