

**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-020387**Date Inspected:** 30-Jan-2011**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), Changxing Island **Location:** Shanghai China**CWI Name:** Gang Wei**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 Structure**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Mr. Manuel Teall was present during the times noted above for observations relative to the work being performed at ZPMC.

BAY 14 -14E

Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as DP3160-001-043,044, located on the Longitudinal Diaphragm Stiffener of OBG Segment 14E. The welder is identified as 066439. ZPMC Quality Control (QC) is identified as Mr. Xi Meng Feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2133-ESAB

Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as DP3160-001-051.052, 059, 060, 067 located on the Longitudinal Diaphragm Stiffener of OBG Segment 14E. The welder is identified as 066439. ZPMC Quality Control (QC) is identified as Mr. Xi Meng feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2133-ESAB

Flux Cored Arc Welding (FCAW)

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as DP3160-001-068,088,089,096,097,104,105,112,113,134,135. located on the Longitudinal Diaphragm Stiffener of OBG Segment 14E. The welder is identified as 066439. ZPMC Quality Control (QC) is identified as Mr. Xi Meng Feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2133-ESAB

: MAGNETIC PARTICLE TESTING (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG segment 13AE W3T3007Y. The welds designations reviewed are as follows:W3T3007Y-389,390,393,394,388.

MAGNETIC PARTICLE TESTING (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG segment 13AE Seg3007AT. The welds designations reviewed are as follows:Seg3007AT-081,02083,206,207.

MAGNETIC PARTICLE TESTING (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG segment 13AE Seg3007AZ. The welds designations reviewed are as follows:Seg3007AZ-056,057,050,051,036,037

MAGNETIC PARTICLE TESTING (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG segment 13AE Seg3007AX. The welds designations reviewed are as follows:Seg3007AX-033,034,027,028,043,044.

MAGNETIC PARTICLE TESTING (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG segment 13AE Seg3007U. The welds designations reviewed are as follows:Seg3007U-113,111

On this date Caltrans OSM Quality Assurance (QA) Inspector ,Mr. Manuel Teall was present during the times noted above for observations relative to the work being performed at ZPMC.

**Summary of Conversations:**

---

---

# WELDING INSPECTION REPORT

*( Continued Page 3 of 3 )*

---

---

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.

---

<b>Inspected By:</b>	Teall,Manuel	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

---