

**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-020509**Date Inspected:** 06-Feb-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

<b>CWI Name:</b>	Mr. Chen Xi	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG	

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #14

This QA Inspector observed the following work in progress

Flux Cored Arc Welding (FCAW)

Weld joint 079, Located on Deck Panel to Diaphragm, DP 3172-001. Welder is identified as 066888. ZPMC Quality Control Inspector (QC) is identified as Zhong Lin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Weld joint 004, Located on Deck panel DP3087 to Deck panel DP3088 in SEG 3009H. Welder is identified as 067138. ZPMC Quality Control Inspector (QC) is identified as Gong Wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Shielded Metal Arc Welding (SMAW):

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

Weld joint 030, Located on Deck Panel to Diaphragm, DP 3177-001. Welder is identified as 067707. ZPMC Quality Control Inspector (QC) is identified as Zhong Lin. The welding variables recorded by QC appeared to comply with the WPS-B-P -2212-TC-U4B-FCM.

Weld joint 124, Located on Deck Panel to Diaphragm, DP 3176-001. Welder is identified as 066888. ZPMC Quality Control Inspector (QC) is identified as Zhong Lin. The welding variables recorded by QC appeared to comply with the WPS-B-P -2212-TC-U4B-FCM.

Weld joint 247, Located on Deck Panel to Diaphragm, DP 3175-001. Welder is identified as 067904. ZPMC Quality Control Inspector (QC) is identified as Zhong Lin. The welding variables recorded by QC appeared to comply with the WPS-B-P -2212-TC-U4B-FCM.

Bay #19

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG) in Bay 19;

Suspender Bracket SB 106E, SB 106W, SB 108E  
Bike path BK004B-001  
Bike path BK004A -014-043

This QA observed that ZPMC was not performing any work on the above mentioned components during the time, this QA inspectors was present.

Bay #28

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG) in Bay 28;

Crash Barrier –SB8-001-002,003  
Crash Barrier –SB12 -001 -001, 002, 003

This QA observed that ZPMC was not performing any work on the above mentioned components during the time, this QA inspectors was present.

For further information see below pictures:-

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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 Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

---

**Inspected By:** Baskar, Govindarajan

Quality Assurance Inspector

**Reviewed By:** Clifford, William

QA Reviewer