

**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-020511**Date Inspected:** 08-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**CWI Name:** Mr. Sha Zi**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, 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 230, Located on Side panel I rib to Floor beam in P.P 125.3 mtr. at Lift 14E, SEG3019D. Welder is identified as 066733. ZPMC Quality Control Inspector (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint 222, Located on Side panel I rib to Floor beam in P.P 125.3 mtr. at Lift 14E, SEG3019D. Welder is identified as 068501. ZPMC Quality Control Inspector (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

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Weld joint 048, Located on Longitudinal Diaphragm to AP, SEG3019Z. Welder is identified as 067079. ZPMC Quality Control Inspector (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint 032, Located on Floor beam FB 3150 to CA 3014 in Lift 13CE, SEG3011H. Welder is identified as 052696. 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.

Weld joint 006, Located on Deck panel diaphragm to Deck panel Diaphragm, in Lift 13BE, SEG3009B. Welder is identified as 066881. ZPMC Quality Control Inspector (QC) is identified as Gong wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Shielded Metal Arc Welding (SMAW):

Repair of Weld joint 037 as per CWR no. B-CWR-2737, Located on Lift 14E. Welder is identified as 215553. ZPMC Quality Control Inspector (QC) is identified as Gong Wei. The welding variables recorded by QC appeared to comply with the WPS-345 –SMAW -2G (2F)-FCM-Repair.

Repair of Weld joint 048 as per WRR no. B-WR-20180, Located on Longitudinal Diaphragm to Floor beam stiffener SEG3019AV. Welder is identified as 068099. ZPMC Quality Control Inspector (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-345 –SMAW -2G (2F)-FCM-Repair.

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 BK004A-014

Bike path BK005A-002

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:-

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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.

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**Inspected By:** Baskar, Govindarajan

Quality Assurance Inspector

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**Reviewed By:** Clifford, William

QA Reviewer