

**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-020520**Date Inspected:** 11-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 QING 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 Flux Core Arc Welding (FCAW) of Repair weld for the bottom plate to side plate hold back weld joint located on east side of 11EE at cross beam side. The weld is designated as SEG074A-016. The welder is identified as 047353. ZPMC QC Mr. LIU HUA JIE was onsite monitoring the welding variables. The inprocess FCAW appears to be progressing in compliance with WPS-345-FCAW-1G (1F)-FCM-Repair-1. The weld repair report number is named as WR-18688.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the edge plate to edge plate transverse splice weld joint located on 12AE+12BE at cross beam side. The weld is designated as OBE12-001. The welder is identified as 044515. ZPMC QC Mr. AN QING XING was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with

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WPS-B-P-2213-B-U2-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 west side of 12AE at bike path side. The weld is designated as SEG3001A-016. The welder is identified as 053871. ZPMC QC Mr. WANG LI YANG was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. The weld repair report number is named as WR-18689. Further weld detail mention in attached picture.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the edge plate to edge plate transverse splice weld joint located on 12AE+12BE at bike path side. The weld is designated as OBE12-007. The welder is identified as 044515. ZPMC QC Mr. AN QING XING was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-P-2213-B-U2-FCM-1.

ZPMC welding personnel performing Flux Core Arc Welding (FCAW) of Complete Joint Penetration (CJP) welds joining the U-Rib splice plate weld joint located on LIFT 12W. The weld is designated as USPLI-654-001. The welder is identified as 040759. ZPMC QC Mr. ZHOU PENG was onsite monitoring the welding variables. The inprocess FCAW appears to be progressing in compliance with WPS-B-T-2231-ESAB.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the drip plate to deck plate weld joint located on 11EE at cross beam side. The weld is designated as OBE11E-016. The welder is identified as 050289. ZPMC QC Mr. AN QING XING was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-P-2213-B-U2-FCM-1.

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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