

**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-020703**Date Inspected:** 21-Dec-2010**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:** Yang Bai Qiung**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, Cross Beam**Summary of Items Observed:**

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

Bay 15

This QA Inspector observed the following work in progress for Bay 15.

ZPMC was using the Shielded Metal Arc Welding (SMAW) processes.

ZPMC QC is identified as Zhu Yuan Yuan

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: Cross Beam 16

PCMK: CB202A-016

Weld Number: 006

Welder: 049502

WPS-345-SMAW-2G-FCM-Repair

B-CWR2517

Component: Cross Beam 16

PCMK: CB202A-016

Weld Number: 018

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Welder: 046709  
WPS-345-SMAW-2G-FCM-Repair  
B-CWR2518

Bay 19

This QA Inspector observed the following work in progress for Bay 19.  
ZPMC was using the Shielded Metal Arc Welding (SMAW) processes.  
ZPMC QC is identified as Guo Xing Hui  
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).  
Listed below are the locations that were identified by this QA inspector

Component: Bike Path  
PCMK: BK005A1-002  
Weld Number: 043  
Welder: 259566  
WPS-345-SMAW-2G-Repair  
B-WR19180

Bay 28

This QA Inspector observed the following work in progress for Bay 28.  
ZPMC was using the Flux Cored Arc Welding (FCAW) processes.  
ZPMC QC is identified as Yang Bai Qiung  
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).  
Listed below are the locations that were identified by this QA inspector

Component: U Rib Splice Plate  
PCMK: SA3102C-001  
Weld Number: 005, 006  
Welder: 059378  
WPS-B-T-2231-ESAB

Component: U Rib Splice Plate  
PCMK: SA3102C  
Weld Number: 005, 006  
Welder: 059378  
WPS-B-T-2231-ESAB

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

### Summary of Conversations:

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

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<b>Inspected By:</b>	Combs,Dennis	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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