

**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-020805**Date Inspected:** 30-Oct-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), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**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 Assembly**Summary of Items Observed:**

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

**OBG Segment 12AW**

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4F position of weld joint SEG3004Z-120 located on Cross Beam side Edge Panel at PP112. The welder is identified as 066261. ZPMC Quality Control (QC) is identified as Wu Shi Gao. The welding variables recorded by QC appeared to comply with the WPS B-P-2114-FCM-1. See attached photograph Pic\_001.

**OBG Segment 12AW**

This QA Inspector observed the following work in progress:

During in process inspection this QA Inspector observed ZPMC NDT personnel performing Magnetic Particle Testing (MT) on Cross Beam side Longitudinal Diaphragm (LD) to Bottom Panel welds.

**Bay 16/ Steel Barriers**

# WELDING INSPECTION REPORT

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This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2F position of W5-SB1-053 Steel Barrier internals weld # W5-SB1-053-129. The welder is identified as 068858. ZPMC Quality Control (QC) is identified as Guo Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

Bay 16/ Steel Barriers

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2F position of W5-SB2-006 Steel Barrier internals weld # W5-SB2-006-095. The welder is identified as 070254. ZPMC Quality Control (QC) is identified as Guo Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

Bay 16/ Steel Barriers

This QA Inspector observed the following work in progress:

During in process inspection this QA Inspector observed ZPMC NDT personnel performing Ultrasonic Testing (UT) on Steel Barrier W5-SB13A-001 weld # 050. ZPMC found not acceptable indication & marked for repair.

OBG Segment 12AW

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of weld joint SEG3004Y-124 located on Cross Beam side Edge Panel at PP110. The welder is identified as 066261. ZPMC Quality Control (QC) is identified as Wu Shi Gao. The welding variables recorded by QC appeared to comply with the WPS B-P-2214-TC-U4b-FCM-1. See attached photograph Pic\_002.



## Summary of Conversations:

No relevant conversations 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 (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

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# WELDING INSPECTION REPORT

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