

**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-020809**Date Inspected:** 25-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**

During in process inspection this QA Inspector observed ABF Quality Assurance (QA) personnel performing Magnetic Particle Testing (MT) on Deck Panel Diaphragm to Flange weld at PP110W.

**OBG Segment 12BE**

During in process inspection this QA Inspector observed ABF Quality Assurance (QA) personnel performing Ultrasonic Testing (UT) on CB side corner assembly to PP113.5 splice weld. See attached photograph Pic\_001.

**Bay 16/ Steel Barriers**

Flux Core Arc Welding (FCAW) in the 2F position of W5-SB1D-007 Steel Barrier internals weld # SB1-035-076. The welder is identified as 201074. 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**

# WELDING INSPECTION REPORT

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Flux Core Arc Welding (FCAW) in the 2F position of W5-SB1-036 Steel Barrier internals weld # SB1-036-055. 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. See attached photograph Pic\_002.

Paint Shop 3 / Cross Beam CB 14

This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated MT report for this date. The member is identified as Cross Beam intermediate diaphragm web to bottom weld after HSR as per ZPMC notification # 7090.

The weld designations reviewed are as follows:

CB202G-043-148/166/147/165

CB202G-044-148/166/147/165

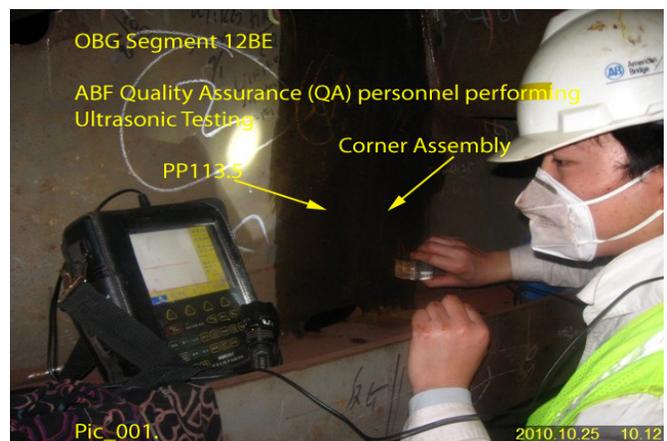
CB202G-041-148/166/147/165

CB202G-042-148/166/147/165

OBG Segment 12AW

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4F position of weld joint OBW12B-013 located on Counterweight side Drain Plate. The welder is identified as 067746. ZPMC Quality Control (QC) is identified as Wang Wei Ming. The welding variables recorded by QC appeared to comply with the WPS B-P-2114-FCM-1.



## 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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