

**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-020959**Date Inspected:** 23-Feb-2011**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**CWI Name:** Tian Lei, Liu Fa Wen**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 R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

Bay Number 1

FCAW welding of complete joint penetration welds located on Traveler Rail component identified as 9TR1-001 as identified on weld repair data sheet B-WR-22057 for repaired complete joint penetration welds identified as weld no.(s): 020. Welder is identified as welder no. 217185. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-345-FCAW-2G(2F)-ESAB-repair.

FCAW welding of fillet welds located on Cable Tray components identified as SA6508A (3 pieces) & SA6508B (2 pieces) for fillet welds connecting gusset plates and stiffeners at 10 locations typical for each cable tray 6 welds total for each stiffener or gusset plate. Welder is identified as welder no. 051246. The welding variables recorded by ZPMC QC personnel identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

FCAW welding of complete joint penetration welds located on traveler rail component identified as 9TR1-001 & 002 and for 9TR2-001 & 002 for weld no.(s) 011 & 012 for each traveler rail. Welder is identified as welder no. 053609. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable

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WPS(s) WPS-B-T-2132-ESAB.

Bay Number 3

SMAW welding of complete joint penetration welds located on Edge Plate for Architectural Housing component identified as EP3017-001 for weld no.(s) 002~007. Welder is identified as welder no. 200113. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-P-2114.

SMAW welding of complete joint penetration welds located on Edge Plate for Architectural Housing component identified as EP3017-001 for weld no.(s) 001. Welder is identified as welder no. 058102. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-P-2311-TC-P4.

Bay Number 6

The following components were in the above noted bay: RL3011A, RL3011B, RL3015A, RL3016A, RL3016B, RL3017A, RL3017B, RL3343A, & RL3343B. At the time this inspector was in this bay, this inspector did not observe any work being performed on these components.

Bay Number 8

FCAW welding of complete joint penetration welds located on bike path component identified as BK004A6-062 weld no.(s) 072 & 073. Welder is identified as welder no. 054459. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2132-ESAB.

FCAW welding of complete joint penetration welds located on bike path component identified as BK004A8-062 weld no.(s) 072 & 073. Welder is identified as welder no. 054459. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2132-ESAB.

FCAW welding of complete joint penetration welds located on bike path component identified as BK004A3-062 weld no.(s) 032, 033, 058, & 059. Welder is identified as welder no. 219414. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2132-ESAB.

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents

**Summary of Conversations:**

Pertinent conversations are included in the body of the report.

**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 1500-0042-02372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hernandez,Rene	Quality Assurance Inspector
<b>Reviewed By:</b>	Hall,Steven	QA Reviewer

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