

**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-021153**Date Inspected:** 13-Feb-2011**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:** Sha Zhi**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 13AE / Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (SMAW) in the 2G position of Deck Pane Diaphragm weld # SEG3007R-006. The welder is identified as 050242. ZPMC Quality Control (QC) is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB. See attached photograph Pic\_001.

OBG Segment 13AE / Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (SMAW) in the 3G position of weld # SEG3007AX-035. The welder is identified as 055491. ZPMC Quality Control (QC) is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

OBG Segment 13AE / Bay 14

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This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 1G position of EP 'I' rib to FB repair weld # SEG3007AB-029, as per B-WR # 19314. The welder is identified as 037743. ZPMC Quality Control (QC) is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with WPS- WPS-345-SMAW-1G(1F)-FCM-Repair.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 2G position of repair weld # SEG3019D-1-323, as per B-CWR # 2678. The welder is identified as 215553. ZPMC Quality Control (QC) is identified as Guo xing Hui. The welding variables recorded by QC appeared to comply with WPS- WPS-345-SMAW-2G(2F)-FCM-Repair. See attached photograph Pic\_002.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 2G position of Deck Panel weld # DP3161-001-019. The welder is identified as 050969. ZPMC Quality Control (QC) is identified as Guo xing Hui. The welding variables recorded by QC appeared to comply with WPS-B-P 2212-TC-U4b-FCM-1.

OBG Lift 13 and 14 / Bay 14

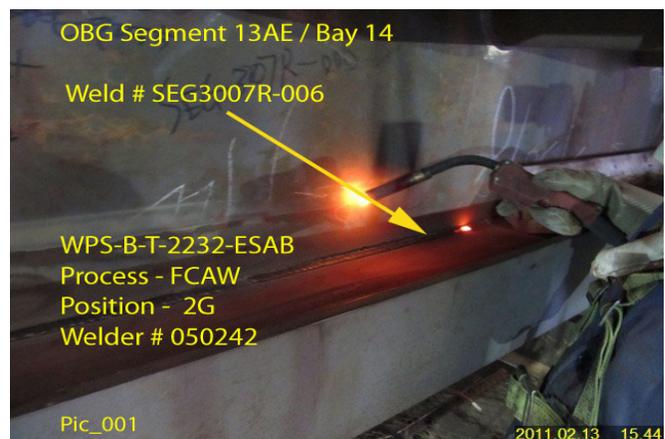
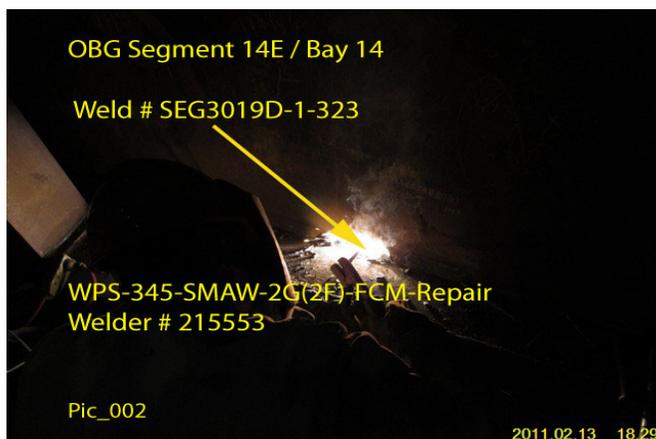
This QA Inspector observed the following:

ZPMC was not performing any work on OBG lift 13 and 14 in Bay 14 after 2100 hrs.

Reporting on PMIV

This QA Inspector performed the following:

This QA Inspector entered back date WIR and NDE reports on PMIV.



**Summary of Conversations:**

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

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