

**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-021174**Date Inspected:** 19-Sep-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:** Tian Lei**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.

This QA Inspector performed the following work:

Bay 2 / OBG Segment 14W

Flux Core Arc Welding (FCAW) in the 3G position of Floor Beam 'I' rib splice weld # FB3321-001-136. The welder is identified as 058245. ZPMC Quality Control (QC) is identified as Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2-F. See attached photograph Pic\_001.

Bay 2 / OBG Segment 14W

Flux Core Arc Welding (FCAW) in the 3G position of Floor Beam 'I' rib splice weld # FB3317-001-145. The welder is identified as 201583. ZPMC Quality Control (QC) is identified as Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2-F.

Bay 2 / OBG Segment 14W

Flux Core Arc Welding (FCAW) in the 2F position of Floor Beam to 'I' rib weld # FB3316-001-045. The welder

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is identified as 045209. ZPMC Quality Control (QC) is identified as Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3. See attached photograph Pic\_002.

## Bay 2 OBG Sub Assy14W

Sub Arc Welding (SAW) in the 1G position of Longitudinal Diaphragm plate # X4920B to X4921A splice weld # LD3051-001-001. The welder is identified as 207237. ZPMC CWI is identified as Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

## Bay 4 OBG Edge and Bottom Plate

This QA inspector performed Magnetic Particle (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Edge and Bottom Palter as per ZPMC notification # 06714 item # 2, 3, 4 and 6.

The weld designations reviewed are as follows:

EP3028-001-002, 006, 007 008, 009, 018, 019, 020, 021, 014, 026, 027, 028, 029, 030 and 031

BP3085-001-001

BP3084-001-001

BP3083-001-001 (MT carried out on one side only)



## 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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<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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