

**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-021231**Date Inspected:** 12-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, China**CWI Name:** Geng Wei**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 Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#14

East Side

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Repair welding of a weld joint #169 located on 14E, SEG3019BB as per the critical weld repair report # B-CWR2737. Welder is identified as 058087. ZPMC Quality Control (QC) Inspector is identified as Xie Ming Feng.

The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM-Repair-1.

Repair welding of a weld joint #085 located on 13AE, SEG3007E as per the weld repair report # B-WR20179.

Welder is identified as 068924. ZPMC Quality Control (QC) Inspector is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-FCM-Repair-1.

Repair welding of a weld joint #133 located on 13AE, edge plate to floor beam, SEG3007N as per the weld repair report # B-WR20188. Welder is identified as 037743. ZPMC Quality Control (QC) Inspector is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G

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(3F)-FCM-Repair-1.

Repair welding of a weld joint #125 located on 14E, SEG3019BB as per the critical weld repair report # B-CWR2737. Welder is identified as 058087. ZPMC Quality Control (QC) Inspector is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G

(2F)-FCM-Repair-1.

Flux Cored Arc Welding (FCAW):

Weld joint #157 located on 14E, SEG3019BB. Welder is identified as 066763. ZPMC Quality Control (QC) Inspector is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #031 located on 13AE, SEG3007AV. Welder is identified as 066163. ZPMC Quality Control (QC) Inspector is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133-ESAB.

Weld joint #066 located on 13AE, SEG3007AV. Welder is identified as 066163. ZPMC Quality Control (QC) Inspector is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #069 located on 14E, SEG3019BB. Welder is identified as 067877. ZPMC Quality Control (QC) Inspector is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #032 located on 13AE, SEG3007AV. Welder is identified as 066163. ZPMC Quality Control (QC) Inspector is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133-ESAB.

Weld joint #002 located on 14E, SEG3019U. Welder is identified as 066236. ZPMC Quality Control (QC) Inspector is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

### DECK PANEL INSTALLATION ON FLOOR BEAM (FL3) SIDE OF 13A EAST SEGMENT

This QA inspector observed deck panel installation and fit-up on floor beam (FL3) side of 13A east segment. The member is identified as OBG Component. (See attached photo)

Witness of Ultrasonic Testing (UT)

This QA inspector Witnessed UT performed by ABF Quality Control personnel. The member is identified as OBG Component. The component and weld designation identified as follows:

SEGMENT 13B EAST DECK PLATE TO DECK PLATE WELD (DP3091A+DP3092A)

SEG3009-007

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

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# WELDING INSPECTION REPORT

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documents.



## Summary of Conversations:

No Relevant Conversations.

## 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 - 15000422372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Kumar,Sandeep

Quality Assurance Inspector

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**Reviewed By:** Patterson,Rodney

QA Reviewer