

**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-021267**Date Inspected:** 01-Jul-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.

This QA Inspector observed the following work in progress:

**OBG Segment 9BE-9CE**

Shielded Metal Arc Welding (SMAW) in the 4G position of Bike Path side EP to SP holdback area, weld joint CA64-005. The welder is identified as 220067. ZPMC CWI is identified as Anqing Xiang. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1. See attached photograph Pic\_001

**OBG Segment 9AW-9BW**

Shielded Metal Arc Welding (SMAW) in the 3G position of Counterweight side Edge Panel, weld joint OBW9-001. The welder is identified as 045221. ZPMC Quality Control (QC) is identified as Zhang Hai Tao. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-TC-U4b-FCM-1. See attached photograph Pic\_002

**OBG Segment 9AW**

Shielded Metal Arc Welding (SMAW) in the 1G position of SP to BP split joint repair area at Cross Beam side as per

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Repair report # B-CWR-1626, weld joint SEG049A-014. The welder is identified as 045133. ZPMC Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G(1F)-FCM-Repair-1.

## OBG Segment 9AW-9BW

Shielded Metal Arc Welding (SMAW) in the 4G position of Cross Beam side EP to DP holdback area, weld joint CA055-006. The welder is identified as 068097. ZPMC Quality Control (QC) is identified as Zhang Hai Tao. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1.

## OBG Segment 8CW

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 an MT report for this date. The member is identified as 7E RETRO Plate as per notification #6097 item # 1

The weld designations reviewed are as follows:

RETRO-G-01-001-056, 057, 047 and 048

RETRO-G-01-002-045, 046, 053 and 054

RETRO-G-01-003-047, 048, 056 and 057



## 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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Inspected By: Gade,Ramesh

Quality Assurance Inspector

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**Reviewed By:** McClendon, Timothy

QA Reviewer