

**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-021302**Date Inspected:** 03-Mar-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:** Mr. Lv Li Qing  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** Yes No N/A  
**Approved WPS:** Yes No N/A  
**Delayed / Cancelled:** Yes No N/A

**Bridge No:** 34-0006**Component:** BAY14 OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A. DeArmond was present during the time noted above and conducted observations relative to the work being performed.

BAY14

**Ultrasonic Testing (UT)**

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. All components were as listed on NWIT notification no. 08432. The member(s) is/are identified as Floor Beam Diaphragm to Deck Plate. The weld designations reviewed are as follows:

DP3172-001-034~038, 211~215, 250, 252, 254, 256, 258, 023

DP3173-001-036~041, 242~246, 280, 282, 284, 286, 288

DP3174-001-035~038, 210~215, 019~021, 250, 252, 254, 256, 258

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# WELDING INSPECTION REPORT

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This QA Inspector observed the following work in progress:

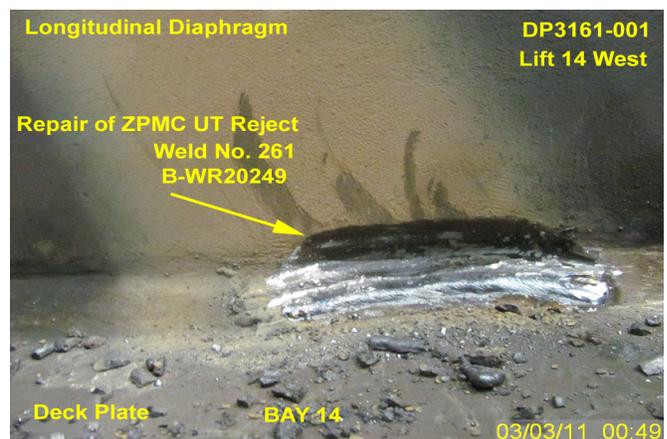
SMAW welding of complete joint penetration weld joint(s) located on lift 14 East, SEG3019Z Longitudinal Diaphragm to Deck Plate weld number(s) 007 and 008. Welder is identified as welder no. 067610. The welding variables recorded by ZPMC QC identified as Zhan Hai Feng appeared to comply with applicable WPS(s) WPS-B-P-2214-TC-U4b-FCM-1.

SMAW welding of complete joint penetration weld joint(s) located on lift 14 East, SEG3019BB Anchor Plate to Bottom Panel weld number(s) 003. Welder is identified as welder no. 066178. The welding variables recorded by ZPMC QC identified as Zhan Hai Feng appeared to comply with applicable WPS(s) WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR-2737

SMAW welding of complete joint penetration weld joint(s) located on lift 14 East, DP3161-001 Floor Beam Diaphragm to Deck Plate weld number(s) 261. Welder is identified as welder no. 215553. The welding variables recorded by ZPMC QC identified as Zhan Hai Feng appeared to comply with applicable WPS(s) WPS-345-SMAW-2G (2F)-FCM-Repair-1 and B-WR-20249

SMAW welding of complete joint penetration weld joint(s) located on lift 14 East, DP3167-001 Floor Beam Diaphragm to Deck Plate weld number(s) 023. Welder is identified as welder no. 050969. The welding variables recorded by ZPMC QC identified as Zhan Hai Feng appeared to comply with applicable WPS(s) WPS-345-SMAW-2G (2F)-FCM-Repair-1 and B-WR-20271

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



## Summary of Conversations:

As mentioned above between QA and QC concerning this project

## Comments

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## WELDING INSPECTION REPORT

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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 Jim Devy 150-002-6784, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	DeArmond,Robert	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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