

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
 690 Walnut Ave. St. 150  
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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-021704**Date Inspected:** 04-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**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**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhu Lin, CWI Lishi Lou.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 13 W

PCMK: SA3174-001

Weld No: 021,033,009,025

Welder: 045175

WPS-B-T-2232-ESAB

Components; OBG 13 W

PCMK: SA3174-001

Weld No: 025,037,013,037

Welder: 207465

WPS-B-T-2233-ESAB

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Components; OBG  
PCMK: SEG3013AH  
Weld No: 183  
Welder: 068445  
WPS-B-T-2232-ESAB

Components; OBG  
PCMK: SEG3013G  
Weld No: 023  
Welder: 067949, 066421  
WPS-B-T-2232-ESAB

Components; OBG  
PCMK: SEG3013J  
Weld No: 008  
Welder: 203871  
WPS-B-T-2232-ESAB

Components; OBG  
PCMK: SEG3013C  
Weld No: 113  
Welder: 067876  
WPS-B-T-2232-ESAB

This QA Inspector observed the following work in progress for Bay 14.  
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.  
ZPMC QC is identified as Zhu Lin, CWI Lishi Lou.  
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).  
Listed below are the locations that were identified by this QA inspector.

Components; OBG  
PCMK: SEG3013H  
Weld No: 027~036  
Welder: 047864  
WPS-B-P-2114-FCM-1

Components; OBG  
PCMK: SEG3013K  
Weld No: 027~030,032~037  
Welder: 066038  
WPS-B-P-2114-FCM-1

Components; OBG

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PCMK: SEG3013F  
Weld No: 029~038  
Welder: 067764  
WPS-B-P-2114-FCM-1

This QA Inspector observed the following work in progress for Bay 14.  
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.  
ZPMC QC is identified as Li Peng Fei, CWI Bao Qian.  
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).  
Listed below are the locations that were identified by this QA inspector.

Components; OBG 14E  
PCMK: DP3160-001  
Weld No: 006  
Welder: 215553  
Weld Repair No. B-WR20269  
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Components; OBG 14E  
PCMK: SEG3019L  
Weld No: 060,066,067,071,074  
Welder: 054013  
WPS-B-P-2213-U4b-FCM-1

Components; OBG 14E  
PCMK: SEG3019Q  
Weld No: 115,117,119,121  
Welder: 050969  
WPS-B-P-2213-TC-U4b-FCM-1

Components; OBG 14E  
PCMK: SEG3019Q  
Weld No: 123,125,127  
Welder: 044779  
WPS-B-P-2213-TC-U4b-FCM-1

Components; OBG 14E  
PCMK: SEG3019AG  
Weld No: 050  
Welder: 067610  
WPS-B-P-2213-FC-U4b-FCM-1

Components; OBG 14E  
PCMK: SA3324-001

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Weld No: 078  
Welder: 037748  
WPS-B-P-2114-FCM-1

Components; OBG 13AE  
PCMK: SEG3007B  
Weld No: 138  
Welder: 216086  
WPS-B-P-2213-B-U2-FCM-1

Components; OBG 13AE  
PCMK: SEG3007C  
Weld No: 245  
Welder: 216086  
WPS-B-P-2213-B-U2-FCM-1

Components; OBG 13AE  
PCMK: SEG3007G  
Weld No: 224  
Welder: 216086  
WPS-B-P-2213-B-U2-FCM-1

Components; OBG 13AE  
PCMK: SEG3007D  
Weld No: 212,222  
Welder: 216086  
WPS-B-P-2213-B-U2-FCM-1

Components; OBG 13AE  
PCMK: SEG3007K  
Weld No: 001  
Welder: 201087  
WPS-B-P-2213-B-U2-FCM-1

Components; OBG 13AE  
PCMK: SEG3007L  
Weld No: 003  
Welder: 201087  
WPS-B-P-2213-B-U2-FCM-1

Components; OBG 13AE  
PCMK: SEG3007N  
Weld No: 001  
Welder: 201087

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WPS-B-P-2213-B-U2-FCM-1

Components; OBG 13AE

PCMK: SEG3007M

Weld No: 001

Welder: 201087

WPS-B-P-2213-B-U2-FCM-1

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Li Peng Fei, CWI Bao Qian.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14E

PCMK: SEG3019B

Weld No: 002

Welder: 051356

WPS-B-T-2233-ESAB

Components; OBG 13AE

PCMK: SEG3007N

Weld No: 081

Welder: 055491

WPS-B-T-2232-ESAB

Components; OBG 13AE

PCMK: SEG3007L

Weld No: 124,125

Welder: 055491

WPS-B-T-2233-ESAB

Components; OBG 13AE

PCMK: SEG3007H

Weld No: 123,124,141,162,156,157,120,127

Welder: 050242

WPS-B-T-2231-ESAB

Components; OBG 13AE

PCMK: SEG3007S

Weld No: 006

Welder: 055564

WPS-B-T-2232-ESAB

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



## Summary of Conversations:

No significant 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 James Devey 1500026784, who represents the Office of Structural Materials for your project.

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**Inspected By:** Leavitt, Kelly

Quality Assurance Inspector

**Reviewed By:** Riley, Ken

QA Reviewer