

**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-021733**Date Inspected:** 10-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, Chin**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:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

**Bay 1**

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 1 ZPMC was in process of welding weld repairs on Re-Built traveler rail assembly. ZPMC CWI Tian Lei was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

WR20366

Weld- 20TR2-038-011

WPS-345-SMAW-1G(1F)-Repair

Welder-054467

1G/CJP/SMAW

**Bay 8**

This QA inspector observed ZPMC in process of performing SMAW base metal repairs on bike path assembly BK004A-063. ZPMC CWI Huang Min was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following

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## WELDING INSPECTION REPORT

( Continued Page 2 of 4 )

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location;  
CWR2542  
Weld- BK004A-063  
WPS-345-SMAW-3G(3F)-Repair  
Welder-040673  
3G/FCAW/CJP

### Bay 11

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 11 ZPMC was in process of heat straightening Re-Built traveler rail assemblies. ZPMC QC Wang Chuang Xui was present at this time of this observation and informed this QA inspector of the work that is in process and identified Fu Guo Gang as the CWI. This QA inspector verified this information for the following location;

HSR1 (B) 10131  
20TR2-034, 20TR2-035

### Bay 10

This QA inspector observed ZPMC in process of welding on bike path assembly, cantilever beam and traveler rail assemblies ZPMC OC inspector was present at this time of this observation and informed this QA inspector of the work that is in process and identified Fu Guo Gang as the CWI. It was stated that ZPMC had 14 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- 27TR1-016  
WPS-B-T-2132-ESAB  
Welder- 040533  
2F/FCAW  
QC-Shi Yu

Weld- 37TR2-009  
WPS-B-P-2212-TC-U5b  
Welder- 057266, 050038  
2G/SMAW/CJP  
QC-Shi Yu

Weld- 28TR1-012, 016  
WPS-B-P-2212-TC-U5b  
Welder- 500363  
2G/SMAW/CJP  
QC-Shi Yu

Weld- BK014A5-001-036, 037, 042, 043  
WPS-B-T-2132-ESAB

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## WELDING INSPECTION REPORT

( Continued Page 3 of 4 )

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Welder- 052075  
2F/FCAW  
QC-Yu Zhi Lai

Weld- BK014A3-001-025, 026  
WPS-B-T-2132-ESAB  
Welder- 053869, 040302  
2F/FCAW  
QC-Yu Zhi Lai

Weld- BK16B-001-016  
WPS-B-P-2211-TC-U4c  
Welder- 040365  
1G/SMAW/CJP  
QC-Shi Yu

Weld- BK014A5-001-036, 037, 042, 043  
WPS-B-P-2213-TC-U4c  
Welder- 053829  
1G/SMAW/CJPFCAW  
QC- Shi Yu

### Trial Assembly

This QA inspector observed ZPMC in process of SMAW welding on Lift 12 segment assemblies. ZPMC QC Wang Zhu was present at this time of this observation and informed this QA inspector of the work that is in process and identified Zhu Zhong Hai as the CWI. It was stated that ZPMC had 4 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

12CE  
Weld- CA3005E-081 & SEG3003E-117  
WPS-B-P-2113-FCM-1  
Welder- 040270  
3F/SMAW

12CE  
Weld- SEG3003C-010  
WPS-B-P-2112-FCM-1  
Welder- 040378  
2F/SMAW

12CE  
Weld- CA3005D-079, 080  
WPS-B-P-2112-FCM-1

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# WELDING INSPECTION REPORT

( Continued Page 4 of 4 )

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Welder- 052910  
2F/SMAW

12CE  
Weld- CA3005D-151, 152  
WPS-B-P-2114-FCM-1  
Welder- 040484  
4F/SMAW

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

**Summary of Conversations:**

“As noted within the contents of this report.”

**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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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley, Ken	QA Reviewer

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