

**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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021748**Date Inspected:** 11-Mar-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Lu Li Qing**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 14E**Summary of Items Observed:**

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

Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3019BB-149 located on Bottom Plate to Anchor Plate at panel point of OBG Segment 14E. ZPMC Welder is identified as 066418. ZPMC Quality Control (QC) is identified as Mr. Zhang Qing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3019BB-150 located on Bottom Plate to Anchor Plate at panel point 126 of OBG Segment 14E. ZPMC Welder is identified as 037997. ZPMC Quality Control (QC) is identified as Mr. Zhang Qing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3019C-002 located on Side Plate to Floor Beam at panel point 128.7 of OBG Segment 14E. ZPMC Welder is identified as 070007. ZPMC Quality Control (QC) is identified as Mr. Zhang Qing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

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SMAW welding of weld joint EP3027-001-095 located on Edge plate to Edge Plate at panel point 125 to 125.5 of OBG Segment 14E. ZPMC Welder is identified as 201087. ZPMC Quality Control (QC) is identified as Mr. Zhang Qing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3019Q-001-105 located on Floor Beam to Floor beam at panel point 126 of OBG Segment 14E. ZPMC Welder is identified as 201087. ZPMC Quality Control (QC) is identified as Mr. Zhang Qing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3019B-029, 030, 031 and 032 located on Side Plate I-Stiffener to Floor Beam of OBG Segment 14E. ZPMC Welder is identified as 066733. ZPMC Quality Control (QC) is identified as Mr. Zhang Qing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

FCAW welding of weld joint SEG3019Z-001-016 and 023 located on Longitudinal Diaphragm to Floor beam at panel point 125 of OBG Segment 14E. ZPMC Welder is identified as 201087. ZPMC Quality Control (QC) is identified as Mr. Zhang Qing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-ESAB.

FCAW welding of weld joint SEG3019L-001-247, 251 and 255 located on Bottom Plate I-Ribs to Floor beam at panel point 127 of OBG Segment 14E. ZPMC Welder is identified as 066439. ZPMC Quality Control (QC) is identified as Mr. Zhang Qing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

This QA inspector observed ABF personnel performed Ultrasonic Testing (MT) on Anchor Plate to Anchor Plate at panel point 125 to 127 of OBG Segment 14E. The weld number is identified as SEG3019AP-004.

This QA inspector observed ZPMC personnel performed Ultrasonic Testing (MT) on Edge Plate to Edge Plate at panel point 127 to 128.3 of OBG Segment 14E. The weld number is identified as SEG3019AG-050.

This QA inspector observed ABF personnel performed Magnetic Particle Testing (MT) after back gouging welding on side plate to side plate at bike path side of OBG Segment 14E. The Side Plate weld numbers are identified as SEG3019AW-100, 104 and 105. See the attached pictures.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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## Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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

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**Inspected By:** Kumar,Vibin

Quality Assurance Inspector

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**Reviewed By:** Patel,Hiranch

QA Reviewer