

**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-021782**Date Inspected:** 15-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), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhou Zhong Hai**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 Segments**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Trial Assembly Yard

Segment 12BW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a UT repair on a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated SEG3005K-090, Longitudinal Diaphragm to Bottom Plate. The welder is identified as #046709 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-345-2G (2F)-FCM-repair-1.

Segment 12CW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a UT repair on a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated SEG3006T-035, Longitudinal Diaphragm to Bottom Plate. The welder is identified as #046709 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-345-2G (2F)-FCM-repair-1.

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For the above mentioned welding activities ZPMC Quality Control (QC) Inspector is identified as Zhou Zhong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS.

### Segment 12AE

This QA Inspector observed the removal of temporary stiffeners from the FL3 web at panel point 112 by arc gouging.

### Segment 13AW

This QA Inspector observed segment 13AW was brought to the OBG Trial Assembly yard from bay 14.

### Bay 14

This QA Inspector observed Welder Qualification using the Shield Metal Arc Welding (SMAW) process for Groove Weld Qualification (Complete Joint Penetration) for plate of unlimited thickness in the 3G (vertical) and 4G (overhead) positions.

Position, Process, WPS, welder ID# and name are as follows:

4G  
SMAW  
WPS-B-P-2214-B-U2a-1

058102 Wang Chang Fa  
201087 Wu Hai Jun  
051946 Yang Jun Ping  
205098 Xun Zi Chuan  
045213 Mao li Wei

ZPMC CWI Li Yan Hua was present during welder qualification

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

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

No relevant 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 Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hernandez,Dan	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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