

**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-021795**Date Inspected:** 02-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:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Brett W Rice was present during the times noted above for observations relative to the work being performed at ZPMC.

Bay 14 East

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

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

ZPMC QC is identified as Zha Hai Feng.

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.

PCMK: SEG-3007L

Weld No: 031 and 034

Welder: 055491

WPS-B-T-2232-ESAB

PCMK: SEG-3007J

Weld No: 021 and 024

Welder: 055564

WPS-B-T-2132-ESAB

PCMK: SEG-3007G

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Weld No: 035 and 038  
Welder: 050242  
WPS-B-T-2232-ESAB

PCMK: SEG-3019N  
Weld No: 264  
Welder: 051356  
WPS-B-T-2231-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 Zha Hai Feng.  
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.

PCMK: SEG-3019D-2  
Weld No: 159  
WR: 20332  
Welder: 037748  
WPS-345-SMAW-4G(4F)-FCM-Repair-1

PCMK: DP-3076-001  
Weld No: 012  
Welder: 067610  
WPS-B-P-2213-TC-U4b-FCM-1

PCMK: DP-3091-001  
Weld No: 025  
Welder: 044790  
WPS-B-P-2213-TC-U4b-FCM-1

PCMK: DP-3167-001  
Weld No: 040  
WR: 20271  
Welder: 050969  
WPS-345-SMAW-2G(2F)-FCM-Repair-1

PCMK: DP-3162-001  
Weld No: 034 and 035  
CWR: 2822  
Welder: 215553  
WPS-345-SMAW-2G(2F)-FCM-Repair-1

PCMK: SEG-3019BB

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Weld No: 147  
CWR: 2737  
Welder: 044779  
WPS-345-SMAW-2G(2F)-FCM-Repair-1

PCMK: SEG-3019U  
Weld No: 003  
CWR: 2822  
Welder: 054013  
WPS-345-SMAW-2G(2F)-FCM-Repair-1

PCMK: SEG-3019L  
Weld No: 093 and 094  
WR: 20321  
Welder: 067610  
WPS-345-SMAW-G(4F)-FCM-Repair-1

PCMK: APBB1-069-1  
Weld No: 001  
CWR: 20294  
Welder: 037748  
WPS-345-SMAW-1G(1F)-FCM-Repair-1

Bay 16

This QA Inspector observed the following work in progress for Bay 16.

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

ZPMC QC is identified as Ma Qian Li.

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.

PCMK: E5-SB16B-003  
Tack Weld No: 126~131  
Welder: 222396  
WPS-B-T-2132-ESAB

PCMK: E5-SB26A-001  
Tack Weld No: 126~131  
Welder: 048625  
WPS-B-T-2132-ESAB

PCMK: E5-SB22-002  
Tack Weld No: 126~131  
Welder: 201074  
WPS-B-T-2132-ESAB

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PCMK: E5-SB22-002

Tack Weld No: 032~043, 049 and 048

Welder: 201074

WPS-B-T-2133-ESAB

PCMK: E5-SB24-003

Tack Weld No: 126~131

Welder: 201888

WPS-B-T-2132-ESAB

Bay 19

This QA Inspector observed the following work in progress for Bay 19.

ZPMC was using the Heat Straightening (HSR) process.

ZPMC QC is identified as Ma Qian Li.

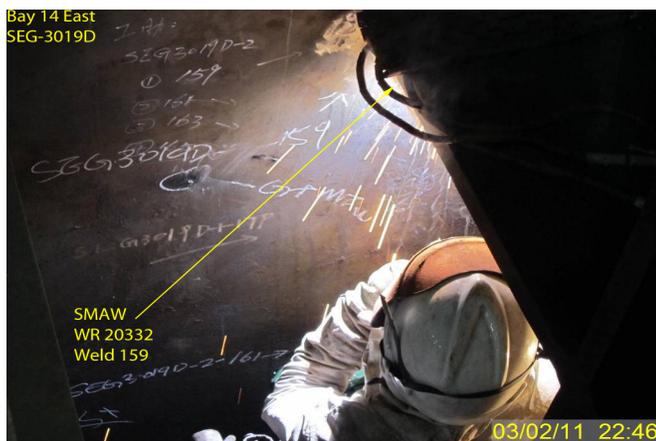
Listed below are the locations that were identified by this QA inspector.

PCMK: SB-025-108E

Bottom Panel

HSR-1(B)-9955-Rev-1

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



## Summary of Conversations:

No relevant conversations were reported on this date.

## 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 15000422372, who represents the Office of Structural Materials for your project.

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| <b>Inspected By:</b> | Rice,Brett | Quality Assurance Inspector |
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| <b>Reviewed By:</b> | Riley,Ken | QA Reviewer |
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