

**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-021797**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:**

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-3019B

Weld No: 002

Welder: 051356

WPS-B-T-2233-ESAB

PCMK: SEG-3007N

Weld No: 081

Welder: 055491

WPS-B-T-2133-ESAB

PCMK: SEG-3007E

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Weld No: 174  
Welder: 055491  
WPS-B-T-2132-ESAB

PCMK: SEG-3007L  
Weld No: 124  
Welder: 055491  
WPS-B-T-2132-ESAB

PCMK: SEG-3007S  
Weld No: 006  
Welder: 055564  
WPS-B-T-2132-ESAB

PCMK: SEG-3007AH  
Weld No: 123, 124, 126, 127, 141, 142, 156, and 157  
Welder: 050242  
WPS-B-T-2131-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: DP-3160-001  
Weld No: 006  
WR: 20269  
Welder: 215553  
WPS-345-SMAW-2G(2F)-FCM-Repair-1

PCMK: SEG-3019L  
Weld No: 060, 066, 067, 071, and 074  
Welder: 054013  
WPS-B-P-2213-TC-U4b-FCM-1

PCMK: SEG-3019Q  
Weld No: 115, 117, 119, and 121  
Welder: 050969  
WPS-B-P-2213-TC-U4b-FCM-1

PCMK: SEG-3019Q  
Weld No: 123, 125, and 127  
Welder: 044779

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WPS-B-P-2213-TC-U4b-FCM-1

PCMK: SEG-3019AG

Weld No: 050

Welder: 067610

W WPS-B-P-2214-TC-U4b-FCM-1

PCMK: SA-3324-001

Weld No: 078

Welder: 037748

WPS-B-P-2114-TC-U4b-FCM-1

PCMK: SEG-3007B

Weld No: 138

Welder: 216086

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

PCMK: SEG-3007C

Weld No: 245

Welder: 216086

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

PCMK: SEG-3007D

Weld No: 222

Welder: 216086

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

PCMK: SEG-3007E

Weld No: 224

Welder: 216086

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

PCMK: SEG-3007K

Weld No: 001

Welder: 201087

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

PCMK: SEG-3007L

Weld No: 003

Welder: 201087

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

PCMK: SEG-3007M

Weld No: 001

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Welder: 201087  
WPS-B-P-2213-B-U2-FCM-1

PCMK: SEG-3007N  
Weld No: 001  
Welder: 201087  
WPS-B-P-2213-B-U2-FCM-1

Bay 16

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

ZPMC was using the Shielded Metal Arc Welding (SMAW) 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: W2-SB16A-001  
Tack Weld No: 126~131 and 116~121  
Welder: 053753  
WPS-B-P-2212

PCMK: W2-SB16A-001  
Tack Weld No: 013~016 and 020~025,  
Welder: 053753  
WPS-B-P-2213

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: W2-SB27A-001  
Tack Weld No: 094~098, 114~122 and 126~131  
Welder: 048625  
WPS-B-T-2132-ESAB

PCMK: W2-SB28-001  
Tack Weld No: 001~018, 020~025, 032~043, 044~ 049, and 051~056  
Welder: 048625  
WPS-B-T-2133-ESAB

PCMK: E5-SB23-001  
Tack Weld No: 063~074, 079, 080, 116~121, and 126~131

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Welder: 222396

WPS-B-T-2133-ESAB

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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**Inspected By:** Rice, Brett

Quality Assurance Inspector

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**Reviewed By:** Riley, Ken

QA Reviewer