

**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-021916**Date Inspected:** 27-Feb-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:** Qiu Wen**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 Components**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector, Anand Upadhye was present during the times noted above for observations relative to the work being performed.

**WELDING**

This QA Inspector observed the following work in progress:

**BAY 14**

This QA Inspector observed ZPMC qualified welding personnel identified as 067588 perform repair welding by Shielded Metal Arc Welding (SMAW), on Deck panel of OBG Segment 14W. Weld joint is identified as DP3172-001-036. ABF Quality Assurance (QA) Inspector identified as Shen Jian was present to monitor the welding process. The welding variables recorded by ABF QA appeared to be in general compliance with WPS-345 SMAW-2G (2F)-FCM-Repair-1 and welding repair report B-WR20289.

This QA Inspector observed ZPMC qualified welding personnel identified as 066155 perform repair welding by Shielded Metal Arc Welding (SMAW), on Deck panel of OBG Segment 14W. Weld joint is identified as DP3172-001-213. ABF Quality Assurance (QA) Inspector identified as Shen Jian was present to monitor the welding process. The welding variables recorded by ABF QA appeared to be in general compliance with WPS-345 SMAW-2G (2F)-FCM-Repair-1 and welding repair report B-WR20289.

This QA Inspector observed ZPMC qualified welding personnel identified as 066398 perform repair welding by Shielded Metal Arc Welding (SMAW), on Deck panel of OBG Segment 14W. Weld joint is identified as

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DP3174-001-394. ABF Quality Assurance (QA) Inspector identified as Shen Jian was present to monitor the welding process. The welding variables recorded by ABF QA appeared to be in general compliance with WPS-345 SMAW-2G (2F)-FCM-Repair-1 and welding repair report B-WR20313.

This QA Inspector observed ZPMC qualified welding personnel identified as 066239 perform welding by Flux Cored Arc Welding (FCAW), on Anchor plate to Bottom plate weld of OBG Segment 14W. Weld joint is identified as SEG3020BB-049. ZPMC Quality Control (QC) Inspector identified as Sun Tian Liang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2232-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 045175 perform welding by Flux Cored Arc Welding (FCAW), on Anchor plate to Bottom plate weld of OBG Segment 14W. Weld joint is identified as SEG3020BB-058. ZPMC Quality Control (QC) Inspector identified as Sun Tian Liang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2232-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 047864 perform welding by Shielded Metal Arc Welding (SMAW), on Anchor plate to longitudinal diaphragm weld of OBG Segment 14W. Weld joint is identified as SEG3020AB-134. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2214-Tc-U5-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 068445, 066419 perform welding by Flux Cored Arc Welding (FCAW), on OBG Segment 13AW. Weld joint is identified as SEG3013S-011. ZPMC Quality Control (QC) Inspector identified as Liu Fang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2232-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 045143 perform welding by Flux Cored Arc Welding (FCAW), on OBG Segment 13AW. Weld joint is identified as SEG3013B-255. ZPMC Quality Control (QC) Inspector identified as Liu Fang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2232-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 066359 perform welding by Flux Cored Arc Welding (FCAW), on OBG Segment 13AW. Weld joint is identified as SEG3013G-023. ZPMC Quality Control (QC) Inspector identified as Liu Fang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2232-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 067765 perform welding by Shielded Metal Arc Welding (SMAW), on Edge plate to Deck plate weld of OBG Segment 13AW. Weld joint is identified as SEG3013AA-109. ZPMC Quality Control (QC) Inspector identified as Liu Fang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1.

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

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documents.

**Summary of Conversations:**

No significant 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, phone: 15000422372 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Upadhye,Anand	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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