

**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-021951**Date Inspected:** 15-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China**CWI Name:** Sha Zhi**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, DJ Shin 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 for Bay 14.

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

ZPMC QC is identified as Zhu Lin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: 13BW

PCMK: SEG3014F-164

Welder: 066734

WPS-B-T-2233-ESAB

Components: 13CW

PCMK: SEG3015F-007

Welder: 048433

WPS-B-T-2232-ESAB

PCMK: SEG3015H-009

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Welder: 048696  
WPS-B-T-2233-ESAB

PCMK: SEG3015I-014  
Welder: 045143  
WPS-B-T-2233-ESAB

Components: 14W  
PCMK: SEG3020C-056  
Welder: 047866  
WPS-B-T-2233-ESAB

PCMK: SEG3020T-128,129  
Welder: 068445  
WPS-B-T-2233-ESAB

PCMK: SEG3020T-143,144  
Welder: 066421  
WPS-B-T-2233-ESAB

PCMK: SEG3020AJ-042,043  
Welder: 067876  
WPS-B-T-2233-ESAB

This QA Inspector observed the following work in progress for Bay 14.  
ZPMC was using the Shield Metal Arc Welding (SMAW) process.  
ZPMC QC is identified as Zhu Lin.  
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

Components: 13BW  
PCMK: SEG3012-002  
Welder: 067829  
WPS-B-P-2214-B-U2-FCM-1

PCMK: SEG3014F-003  
Welder: 067993  
WPS-B-P-2213-TC-U4b-FCM-1

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

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<b>Inspected By:</b>	Shin,DJ	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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