

**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-021976**Date Inspected:** 12-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:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

**Bay 14**

This QA Inspector performed random document review of "Team China request for information (TC-RFI)" document #TC-RFI-0035R3. This RFI addresses OBG Lift 14 West and 14 East, hole penetrations, doubler plates, for dehumidification ducts. This QA Inspector performed random visual inspections of the welds listed in the RFI and observed ZPMC appears to have not completed the hole penetrations, doubler plates, for dehumidification ducts as referenced in the RFI. This QA Inspector took random photographs of the areas and copies of the photographs have been placed in "TC-RFI Documentation" folder located on Team China common Z drive. (see photos below)

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 Shen Jian Bo, CWI Shi Zhi.

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; OBG 13 W

PCMK: SA3173-001

Weld No: 027

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## WELDING INSPECTION REPORT

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Welder: 067520  
Weld Repair No. B-WR10730  
WPS-345-SMAW-3G(3F)-FCM-Repair-1

Components; OBG 13 W  
PCMK: SA3174-001  
Weld No: 009  
Welder: 066383  
Weld Repair No. B-WR10731  
WPS-345-SMAW-3G(3F)-FCM-Repair-1

Components; OBG 13 W  
PCMK: SEG3013AA  
Weld No: 118  
Welder: 066038  
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 13 W  
PCMK: SEG3013AA  
Weld No: 116  
Welder: 047864  
WPS-B-P-2214-TC-U4b-FCM-1

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 Shen Jian Bo, CWI Shi Zhi.  
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; OBG 13BW  
PCMK: SF3231C-001  
Weld No: 002  
Welder: 048433  
WPS-B-T-2232-ESAB

Components; OBG 14 W  
SEG3020K  
Weld No: 295,296  
Welder: 204730  
WPS-B-T-2132-ESAB

Components; OBG 14 W  
PCMK: DP3174-001  
Weld No: 383,382

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Welder: 048696  
WPS-B-T-2232-ESAB

Components; OBG 14 W  
PCMK: SEG3020AC  
Weld No: 076,077  
Welder: 067949, 045175  
WPS-B-T-2132-ESAB

Components; OBG 13AW  
PCMK: SEG3013K  
Weld No: 162  
Welder: 067876  
WPS-B-T-2233-ESAB

Components; OBG 13 W  
PCMK: SEG3013H  
Weld No: 058  
Welder: 203671  
WPS-B-T-2232-ESAB

Components; OBG 13 W  
PCMK: SEG3013R  
Weld No: 006  
Welder: 066421  
WPS-B-T-2232-ESAB

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 Zhong Yong Gang, CWI Bao Gian.  
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; OBG 14 E  
PCMK: SEG3007AH  
Weld No: 030.031  
Welder: 050262, 055491, 055564  
WPS-B-T-2232-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 Zhong Yong Gang, CWI Bao Gian.  
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.

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# WELDING INSPECTION REPORT

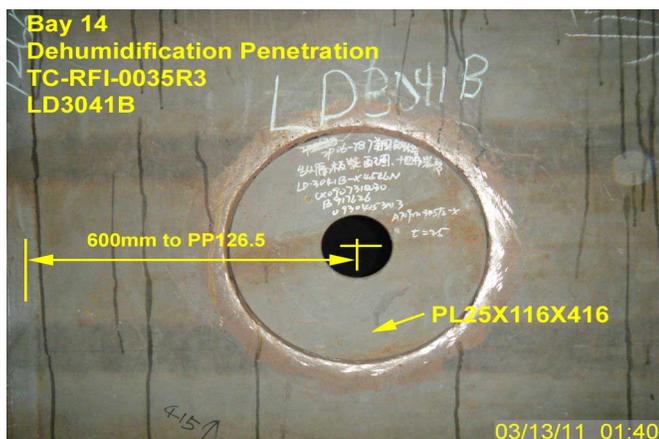
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Components; OBG 14 E  
PCMK: SEG3019D-1  
Weld No: 232  
Welder: 216086  
Weld Repair No. B-CWR2677  
WPS-345-SMAW-2G(2F)-FCM-Repair-1

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



### Summary of Conversations:

No significant 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 James Devey 1500026784, who represents the Office of Structural Materials for your project.

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**Inspected By:** Leavitt, Kelly

Quality Assurance Inspector

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**Reviewed By:** Riley, Ken

QA Reviewer