

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
 690 Walnut Ave. St. 150  
 Vallejo, CA 94592-1133  
 (707) 649-5453  
 (707) 649-5493

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-022331**Date Inspected:** 02-Apr-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 observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Wong Xiang Pin, CWI Wang Jun.

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 W

PCMK: SEG3020AQ

Weld No: 025

Welder: 066398

WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 14 W

PCMK: SEG3020BB

Weld No: 038

Welder: 067829

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

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

Components; OBG 14 W  
PCMK: SEG3020BB  
Weld No: 020  
Welder: 045246  
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14 W FIT UP  
PCMK: SEG3015  
Weld No: 004, 006  
Welder: 066179, 045196  
WPS-B-P-2212

Components; OBG 14 W  
PCMK: DP3175, DP3176, DP3177  
Weld No: FIT UP  
Welder: 205098  
WPS-B-P-2212

Components; OBG Traveler Rails  
PCMK: TR3008TR2-001  
Weld No: FIT UP  
Welder: 045175  
WPS-B-P-2212

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 Wong Xiang Pin, CWI Wang Jun.  
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: SA3125-001  
Weld No: 001~004  
Welder: 201583  
WPS-B-T-2231-ESAB

Components; OBG Traveler Rails  
PCMK: TR3001TR-001  
Weld No: 015  
Welder: 201215  
Weld Repair No. B-WR20561  
WPS-345-FCAW-2G(2F)-FCM Repair-1

---

---

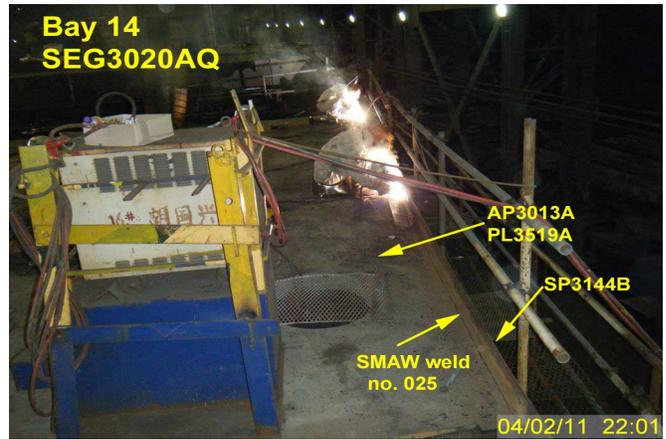
# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

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



## 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 James Devey 1500026784, who represents the Office of Structural Materials for your project.

---

**Inspected By:** Leavitt, Kelly

Quality Assurance Inspector

**Reviewed By:** Riley, Ken

QA Reviewer

---