

**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-022341**Date Inspected:** 18-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**

Heat straightening of PCMK, FB3343A, LD3051A, LD3048A, DP3091A and DP3093A under approved Heat Straightening procedure, HSR1 (B)-10206. The in process temperature was observed as 430°C. The ZPMC QC was identified as Zheng Zhi Wei. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 5mm. (see photo 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 Zheng Zhi Wei, CWI Ji Cai Fang.

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 13CW

PCMK: DP3146-001

Weld No: 246,249

Welder: 067611, 067993

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

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 4 )

---

---

Components; OBG 14 W (see photo below)

PCMK: SEG3020AQ

Weld No: 025

Tack Welder: FIT UP

WPS-B-P-2213-B-U2-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 Zheng Zhi Wei, CWI Ji Cai Fang.

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 13CW

PCMK: SA3232A

Weld No: 033

Welder: 068445

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.

Components; OBG 13CE

PCMK: DP3098-001

Weld No: 026

Welder: 043661

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

Components; OBG 14 E

PCMK: SEG3019AP

Weld No: 027,031,035,039

Welder: 043661

Weld Repair No. B-WR20462

WPS-345-SMAW-2G(2F)-FCM-Repair-1

Components; OBG 14 E

PCMK: SEG3019N

Weld No: 272,265

Welder: 044779

Weld Repair No. B-WR20407

WPS-345-SMAW-4G(4F)-FCM-Repair-1

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 4 )

---

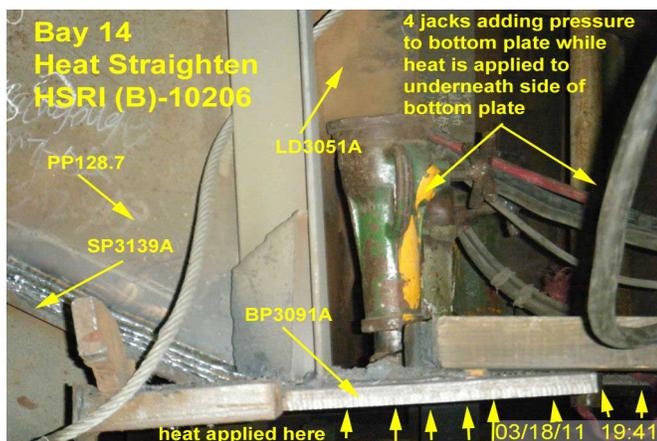
---

Components; OBG 14 E  
PCMK: SEG3019BB  
Weld No: 181  
Welder: 054013  
WPS-B-P-2114-TC-U4b-FCM-1

Components; OBG 14 E  
PCMK: SEG3019BB  
Weld No: 017,193  
Welder: 216086  
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 14 E  
PCMK: SEG3019U  
Weld No: 003  
Welder: 215553  
Weld Repair No. B-CWR2822  
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.

---

---

# WELDING INSPECTION REPORT

( Continued Page 4 of 4 )

---

---

---

<b>Inspected By:</b>	Leavitt, Kelly	Quality Assurance Inspector
----------------------	----------------	-----------------------------

---

<b>Reviewed By:</b>	Riley, Ken	QA Reviewer
---------------------	------------	-------------

---