

**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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022400**Date Inspected:** 08-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:** Lu Li Qing**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, Steel Barrier**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the 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), and Flux Cored Arc Welding (FCAW) processes.

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.

Component: I Rib

PCMK: SEG3020AJ

Weld Number: 287

Welder: 045175

WPS-B-T-2232-ESAB

Component: I Rib

PCMK: SEG3020AJ

Weld Number: 290

Welder: 067949

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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WPS-B-T-2232-ESAB

Component: Anchor Plate Bearing Block

PCMK: 83-06

Welder: 204339

WPS-CASTING-SMAW-1G-REPAIR-1

CWR 2784

Component: Anchor Plate Bearing Block

PCMK: 87-03

Welder: 204339

WPS-CASTING-SMAW-1G-REPAIR-1

CWR 2784

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08489 from ZPMC for Bay 14. This QA inspector performed magnetic particle testing (MT) verification of castings after ZPMC had performed their MT inspection. The segment is identified as OBG Anchor Plate Bearing Blocks. The bearing blocks reviewed are as follows.

APBB1-083-05, APBB1-082-06, APBB1-107-08, APBB1-108-16

BAY 16

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Shielded Metal Arc Welding (SMAW), and Flux Cored Arc Welding (FCAW) processes.

ZPMC QC is identified as Guo Xing Hui.

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.

Component: Steel Barrier

PCMK: E5-SB25-004

Weld Number: 063~074

Welder: 048625

WPS-B-T-2133-ESAB

Component: Steel Barrier

PCMK: E5-SB38-001

Weld Number: 019, 050, 081

Welder: 062092

WPS-B-T-2231-ESAB

Component: Steel Barrier

PCMK: E5-SB28-001

Weld Number: 053, 054

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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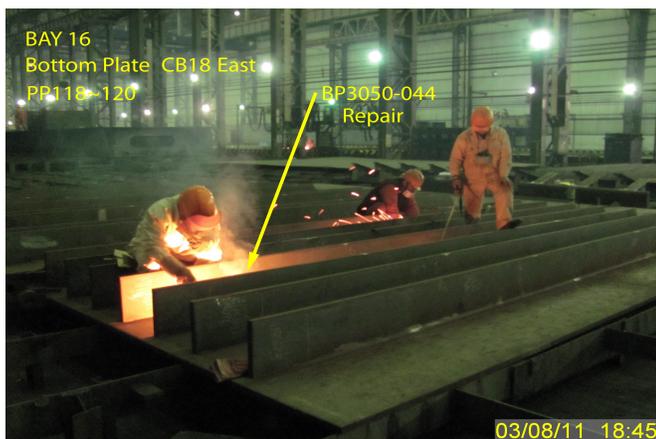
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Welder: 222396  
WPS-B-P-2132-ESAB

Component: Steel Barrier  
PCMK: E5-SB25A-002  
Weld Number: 051, 052  
Welder: 201074  
WPS-B-T-2132-ESAB

Component: Bottom Plate  
PCMK: BP3050  
Weld Number: 044, 069  
Welder: 053753  
WPS-345-SMAW-2F-REPAIR  
CWR 2850

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 Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Combs,Dennis

Quality Assurance Inspector

**Reviewed By:** Riley,Ken

QA Reviewer

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