

**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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022528**Date Inspected:** 06-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai

<b>CWI Name:</b>	Tian Lei, Liu Fa Wen, Chen Shigang			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	OBG		

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

Bay Number 1

SMAW welding of fillet welds located on Bike Path Handrail component identified as BKR-NS-3 for miscellaneous 4mm welds attaching P-45 to P-171 and P-171 to P-40 parts. Welder is identified as welder no. 049769. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-P-2112.

SMAW welding of fillet welds located on Bike Path Handrail component identified as BKR-NS-3 for miscellaneous 4mm welds attaching P-45 to P-171 and P-171 to P-40 parts. Welder is identified as welder no. 215248. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-P-2112.

This inspector observed fitting up and initial welding of components identified as Lift 13 & 14 lifting frame beam.

Bay Number 4

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## WELDING INSPECTION REPORT

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FCAW welding of complete joint penetration welds located on Traveler Rails component identified as 3010TR1-002 weld no.(s) 009. Welder is identified as welder no. 066683. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

FCAW welding of complete joint penetration welds located on Traveler Rails component identified as 3023TR1-001 weld no.(s) 011. Welder is identified as welder no. 066683. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

FCAW welding of complete joint penetration welds located on Traveler Rails component identified as 3023TR1-001 weld no.(s) 007. Welder is identified as welder no. 066283. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

### Bay Number 7

FCAW welding of fillet welds located on Cantilever Box Bracket Assembly component identified as BK3003-001 weld no.(s) 040, 041, 044, 045, 032, 033, 036, & 037. Welder is identified as welder no. 046706. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2133-ESAB.

### Bay Number 8

Performed verification VT for the component(s) identified as OBG West Deviation Saddle Housing and West Jacking Saddle Housing as WDSH-01.1 and WJSH-01.1, This QA inspector signed green tag #15890.

FCAW welding of fillet welds located on Light Base component identified as LB3001-001 weld no.(s) 037. Welder is identified as welder no. 219414. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2232-ESAB.

FCAW welding of fillet welds located on Light Base component identified as LB3100-001 weld no.(s) 061. Welder is identified as welder no. 054459. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2232-ESAB.

### Bay Number 9

FCAW welding of complete joint penetration welds located on Sub Assembly component identified as SA7505D-001 weld no.(s) 001. Welder is identified as welder no. 201840. The welding variables recorded by ZPMC QC identified as Chen Shigang appeared to comply with applicable WPS(s) WPS-B-T-2133-ESAB.

FCAW welding of complete joint penetration welds located on Sub Assembly component identified as SA7026A-002 weld no.(s) 001. Welder is identified as welder no. 059378. The welding variables recorded by ZPMC QC identified as Chen Shigang appeared to comply with applicable WPS(s) WPS-B-T-2133-ESAB.

FCAW welding of complete joint penetration welds located on Sub Assembly component identified as SA7026A-003 weld no.(s) 001. Welder is identified as welder no. 059416. The welding variables recorded by

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# WELDING INSPECTION REPORT

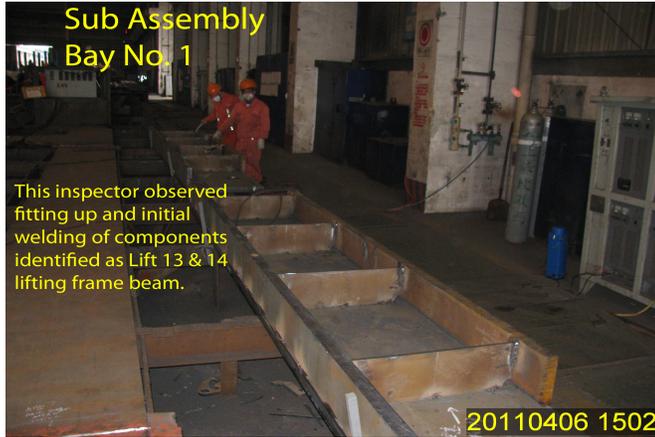
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ZPMC QC identified as Chen Shigang appeared to comply with applicable WPS(s) WPS-B-T-2133-ESAB.

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents



## Summary of Conversations:

Pertinent conversations are included in the body of the report.

## 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 1500-0042-02372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Hernandez,Rene

Quality Assurance Inspector

**Reviewed By:** Hall,Steven

QA Reviewer

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