

**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-022593**Date Inspected:** 18-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, China**CWI Name:** Zhu Zhong Hai**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 Segments**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Trial Assembly Yard

Segment 13CE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG3011A-012, Side Plate to Bottom Plate at locations of removed jig fixture. The welder is identified as #051359 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG3011A-001, Side Plate to Bottom Plate at locations of removed jig fixture. The welder is identified as #066258 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

Segment 13CW

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This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG3015A-009, Side Plate to Bottom Plate at locations of removed jig fixture. The welder is identified as #045213 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

### Segment 13BW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG3014A-009, Side Plate to Bottom Plate at locations of removed jig fixture. The welder is identified as #045213 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

### Segment 13BE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG3009-001, Side Plate to Bottom Plate at locations of removed jig fixture. The welder is identified as #051359 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

### Cross Beam 17

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as SP3025-017-070, MEP to Side Panel, exterior. The welder is identified as #044504 and was observed welding in the 4F (overhead), 3F (vertical) and 2F (horizontal) positions using the following approved Welding Procedure Specifications WPS-B-P-2114-FCM-1, WPS-B-P-2113-FCM-1 and WPS-B-P-2112-FCM-1.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as SP3025-017-224, MEP to Side Panel, exterior. The welder is identified as #040378 and was observed welding in the 4F (overhead), 3F (vertical) and 2F (horizontal) positions using the following approved Welding Procedure Specifications WPS-B-P-2114-FCM-1, WPS-B-P-2113-FCM-1 and WPS-B-P-2112-FCM-1.

For the above mentioned welding activities ZPMC Quality Control (QC) Inspector is identified as Li Yang and Wang Xing Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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

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# WELDING INSPECTION REPORT

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## 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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<b>Inspected By:</b>	Hernandez,Dan	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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