

**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-022720**Date Inspected:** 07-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: SEG3020BB

Weld No: 056

Welder: 067829

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

Components; OBG 14 W

PCMK: SEG3020V

Weld No: 591

Welder: 067904, 067572, 067609

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

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Components; OBG 14 W  
PCMK: SEG3020Y  
Weld No: 017  
Welder: 067611  
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 14 W  
PCMK: SEG3020AB  
Weld No: 016  
Welder: 066398  
WPS-B-P-2212-TC-U4b-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 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 Traveler Rails  
PCMK: 3007TR1  
Weld No: 011  
Welder: 201215  
WPS-B-T-2232-ESAB

Components; OBG 14 W  
PCMK: SEG3020\*  
Weld No: 012  
Welder: 201583  
WPS-B-T-2232-ESAB

Components; OBG 14W  
PCMK: SEG3020Y  
Weld No: 016  
Welder: 067876  
WPS-B-T-2232-ESAB

Components; OBG 14 W  
PCMK: SEG3020J  
Weld No: 001  
Welder: 066673  
WPS-B-T-2233-ESAB

This QA Inspector observed the following work in progress for Bay 14.

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

ZPMC QC is identified as Lu Li Qing, CWI Zhang Qi Li.

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 E

PCMK: SEG3019Y

Weld No: 058

Welder: 051946

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

Components; OBG 14 E

PCMK: SEG3019BB

Weld No: 045

Welder: 216086

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

Components; OBG 14 E

PCMK: SEG3019BB

Weld No: 068

Welder: 044772

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

Components; OBG 14 E

PCMK: SEG3019V

Weld No: 006

Welder: 058102

WPS-B-P-2214-TC-U4b-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 Lu Li Qing, CWI Zhang Qi Li.

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 E

PCMK: SEG3019F

Weld No: 015

Welder: 051356

WPS-B-T-2232-ESAB

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

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

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<b>Inspected By:</b>	Leavitt, Kelly	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley, Ken	QA Reviewer

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