

**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-022749**Date Inspected:** 22-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 Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector randomly observed the following work in progress in the Bay 10:

SMAW welding of weld joints BK014A7-001-058, 061, 078, 081 located on PCMK OBG bike path. Welder was identified as 056364. QC was identified as ABF CWI Liu Cheng (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Zhu Peng (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2313-TC-P4 as verbally identified by QCA1.

SMAW repair welding of weld joint BK3001-001-001 located on PCMK OBG bike path cantilever beam. Welder was identified as 040581. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-345-SMAW-2G(2F)-repair as displayed on ZPMC Weld Repair Report B-WR20477 as presented to this QA Inspector and verbally identified by QCA1.

SMAW repair welding of weld joint BK3001-001-003 located on PCMK OBG bike path cantilever beam. Welder was identified as 040365. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by

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QCA1 appeared to comply with WPS-345-SMAW-2G(2F)-repair as displayed on ZPMC Weld Repair Report B-WR20477 as presented to this QA Inspector and verbally identified by QCA1. See photo below of QCA1's markings on the bike path cantilever beam showing weld number, welder identification and ZPMC Weld Repair Report number B-WR20477.

SMAW welding of weld joint BK15A-001-002 located on PCMK OBG bike path cantilever beam. Welder was identified as 500363. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2212-TC-U4c as verbally identified by QCA1.

SMAW welding of weld joints BK15C-001-001, 002, 004 located on PCMK OBG bike path cantilever beam. Welder was identified as 057220. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2212-TC-U4c as verbally identified by QCA1.

SAW welding of weld joint BK16B-001-005 located on PCMK OBG bike path, cantilever beam. Welder was identified as 209051. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2221-TC-U4a-S as verbally identified by QCA1. See photo below showing the SAW welding in progress.

Bay 11

This QA Inspector randomly observed the following work in progress in the Bay 11:

SMAW tack welding of temporary web stiffeners located on PCMK OBG 28TR1, traveler rail . Welder was identified as 500436. QC was identified as ZPMC CWI Xu Le Feng (QC2). Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was Mao Bin Bin (QCA2), who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-P-2112, WPS-B-P-2113, and WPS-B-P-2114 as verbally identified by QCA2.

OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

FCAW welding of weld joints SEG3007C-269, 047, 053 located on PCMK OBG 13AE. Welder was identified as 055564. QC was identified as ABF CWI Wu Ke Wen (QC3). Assisting QC3 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Zhan Hai Feng (QCA3), who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA3.

FCAW welding of weld joint SEG3007Q-269, 047, 053 located on PCMK OBG 13AE. Welder was identified as 055491. QC was identified as QC3. Assisting QC3 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA3.

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SMAW welding of weld joint SEG3007B-133 located on PCMK OBG 13AE. Welder was identified as 068924. QC was identified as QC3. Assisting QC3 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-P-2212-TC-U4b-FCM-1 as verbally identified by QCA3.

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



## Summary of Conversations:

As noted above.

## 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:** Goulet, George

Quality Assurance Inspector

**Reviewed By:** Riley, Ken

QA Reviewer

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