

**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  
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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-022762**Date Inspected:** 10-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:** Peng Wen Jun  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** Yes No N/A  
**Approved WPS:** Yes No N/A  
**Delayed / Cancelled:** Yes No N/A

**Bridge No:** 34-0006**Component:** OBG, Cable Bracket**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) process.

ZPMC QC is identified as Zhong Yang Gang.

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: Floor Beam Stiffener

PCMK: SEG3019E

Weld Number: 169

Welder: 044779

WPS-345-SMAW-4G-FCM-REPAIR-1

WR 20332

Component: Floor Beam Stiffener

PCMK: SEG3019E

Weld Number: 147

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Welder: 215553  
WPS-345-SMAW-1G-FCM-REPAIR-1  
WR 20332

Component: Floor Beam Stiffener  
PCMK: SEG3019E  
Weld Number: 146  
Welder: 044779  
WPS-345-SMAW-1G-FCM-REPAIR-1  
WR 20332

Component: Anchor Plate WT Stiffener  
PCMK: SEG3019N  
Weld Number: 118  
Welder: 054013  
WPS-B-P-2114-TC-U4b-FCM-1

BAY 16

This QA Inspector observed the following work in progress for Bay 16.  
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.  
ZPMC QC is identified as Ma Qian 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.

Component: Steel Barrier  
PCMK: E2-SB25-001  
Weld Number: 032~043  
Welder: 201905  
WPS-B-P-2113

BAY 19

This QA Inspector observed the following work in progress for Bay 19.  
ZPMC was using the Flux Cored Arc Welding (FCAW) process.  
ZPMC QC is identified as Ma Qian 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.

Component: Cable Bracket  
PCMK: SA6531  
Weld Number: 085  
Welder: 058792  
WPS-B-T-2133-ESAB

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Component: Cable Bracket

PCMK: SA6531

Weld Number: 040

Welder: 062806

WPS-B-T-2133-ESAB

Component: Cable Bracket

PCMK: SA6031

Weld Number: 011

Welder: 062749

WPS-B-T-2232-ESAB

Component: Cable Bracket

PCMK: SA6031

Weld Number: 001

Welder: 062783

WPS-B-T-2232-ESAB

Component: Bike Path

PCMK: BK24A4-001

Weld Number: 005, 006

Welder: 062734

WPS-B-T-2132-ESAB

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



## Summary of Conversations:

No relevant conversations.

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# WELDING INSPECTION REPORT

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## 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>	Combs,Dennis	Quality Assurance Inspector
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<b>Reviewed By:</b>	Riley,Ken	QA Reviewer
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