

**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-022780**Date Inspected:** 28-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:** Cui Zheng Hua**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, 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), and Flux Cored Arc Welding (FCAW) processes.

ZPMC QC is identified as Wang Xiang Pin.

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: Deck Plate

PCMK: DP3153

Weld Number: 093, 094

Welder: 066179

WPS-B-P-4113-FCM-1

Component: Vertical Plate

PCMK: SEG3014F

Weld Number: 216

Welder: 066674

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WPS-B-P-2213-TC-U4b-FCM-1

Component: Deck Plate

PCMK: SP3020AV

Weld Number: 006

Welder: 067829

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

Component: Deck Plate

PCMK: SP3020AV

Weld Number: 011

Welder: 067609

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

Component: Vertical Plate

PCMK: SEG3014H

Weld Number: 159

Welder: 066674

WPS-B-T-2213-TC-U4b-FCM-1

Component: Traveler Rail

PCMK: TR3001TR1-001

Weld Number: 015

Welder: 201215

WPS-B-T-2231-ESAB

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08657 from ZPMC for Bay 14. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as OBG Traveler Rails. The weld designations reviewed are as follows.

TR3027TR2-001-011

TR3027TR1-001-011

TR3004-001-001

TR3007TR1-001-001

TR3004-001-016

TR3007TR1-001-002

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 Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Combs,Dennis

Quality Assurance Inspector

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**Reviewed By:** Riley,Ken

QA Reviewer