

**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-022786**Date Inspected:** 05-Apr-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:** Lv Li Qing**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, 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), and Flux Cored Arc Welding (FCAW) processes.

ZPMC QC is identified as Zheng Zhi Wei.

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

PCMK: SEG3014G

Weld Number: 013

Welder: 045196

WPS-345-SMAW-3G-REPAIR-1

WR20539

Component: Deck Plate Diaphragm

PCMK: SEG3020H

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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Weld Number: 011  
Welder: 067876  
WPS-B-T-2232-ESAB

Component: Vertical Shear Plate  
PCMK: SEG3020BB  
Weld Number: 047  
Welder: 067829  
WPS-B-P-2214-TC-U4b-FCM-1

Component: Deck Plate Diaphragm  
PCMK: SEG3019D  
Weld Number: 010  
Welder: 050242  
WPS-B-T-2232-ESAB

Component: Deck Plate Diaphragm  
PCMK: SEG3019AB  
Weld Number: 008  
Welder: 050242  
WPS-B-T-2212-TC-U4b-FCM-1

Component: Deck Plate Diaphragm  
PCMK: SEG3019K  
Weld Number: 008  
Welder: 215553  
WPS-B-T-2212-TC-U4b-FCM-1

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: SA6031  
Weld Number: 028, 037  
Welder: 062783  
WPS-B-T-2233-ESAB

Component: Cable Bracket  
PCMK: SA6031

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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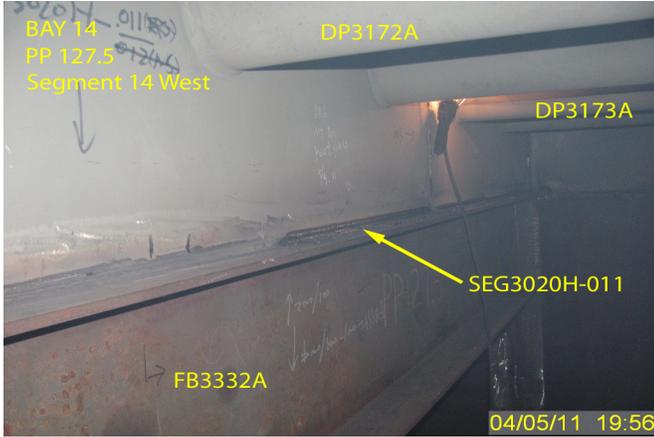
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Weld Number: 028, 037

Welder: 062783

WPS-B-T-2233-ESAB

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



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