

**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-022789**Date Inspected:** 08-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:** Chen Kun**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 14W**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) process.

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: Deck Plate Diaphragm

PCMK: SEG3020AB

Weld Number: 017

Welder: 066398

WPS-B-P-2212-B-U2-FCM-1

Component: Deck Plate Diaphragm

PCMK: SEG3020V

Weld Number: 039

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Welder: 066674  
WPS-B-T-2232-ESAB

Component: Deck Plate Diaphragm  
PCMK: SEG3020S  
Weld Number: 059  
Welder: 067876  
WPS-B-T-2232-ESAB

Component: Anchor Plate  
PCMK: SEG3020U  
Weld Number: 591  
Welder: 067904  
WPS-B-P-2214-TC-U4b-FCM-1

Component: Anchor Plate  
PCMK: SEG3020U  
Weld Number: 591  
Welder: 067572  
WPS-B-P-2214-TC-U4b-FCM-1

Component: Anchor Plate  
PCMK: SEG3020U  
Weld Number: 591  
Welder: 066002  
WPS-B-P-2214-TC-U4b-FCM-1

Bay 19

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08771 from ZPMC for Bay 19. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as OBG Cable Bracket. The weld designations reviewed are as follows.

SA6531-002-118, 119, 125, 126

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08772 from ZPMC for Bay 19. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as OBG Cable Bracket. The weld designation reviewed are as follows.

SA6530-001-080

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

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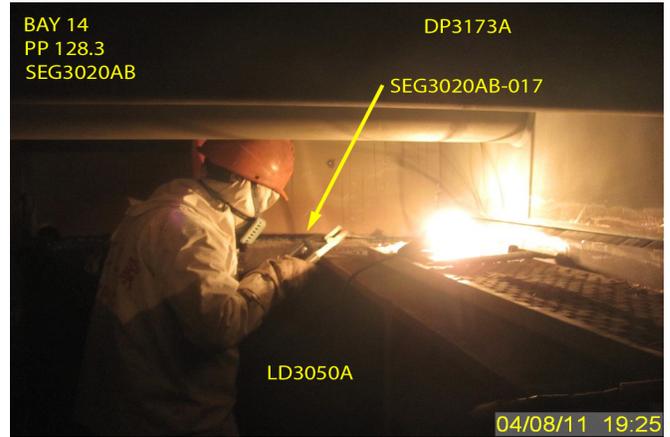
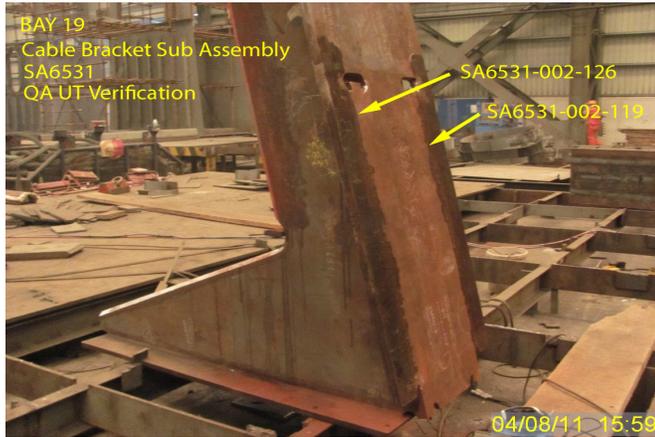
# WELDING INSPECTION REPORT

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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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**Inspected By:** Combs,Dennis

Quality Assurance Inspector

**Reviewed By:** Riley,Ken

QA Reviewer

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