

**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  
(707) 649-5453  
(707) 649-5493

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-022878**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:** Sha Zhi**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:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 11

This QA Inspector observed the following work in progress for Bay 11.

ZPMC was using the Shield Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Mao Bin Bin.

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

Components: Traveler Rail

PCMK: 28TR1-002-008

Welder: 040614

WPS-B-P-2212-TC-U5b

PCMK: 32TR1-001-008,009

Welder: 046704

Report: B-WR20595

WPS-345-SMAW-2G (2F)-FCM-Repair

PCMK: 32TR1-001-013,014

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 4 )

---

Welder: 046769  
Report: B-WR20595  
WPS-345-SMAW-2G (2F)-FCM-Repair

Trial Assembly Yard

This QA Inspector observed the following work in progress for Trial Assembly Yard.

ZPMC was using the Shield Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Liu Hua Jie.

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

Components: 13AE  
PCMK: SEG3009-010  
Welder: 200113  
Report: B-WR20567  
WPS-345-SMAW-4G (4F)-FCM-Repair-1

PCMK: SEG3007L-006,010  
Welder: 068924  
Report: B-WR20507  
WPS-345-SMAW-3G (3F)-FCM-Repair-1

PCMK: SEG3007-007  
Welder: 068924  
WPS-B-P-2213-B-U2-FCM-1

Components: 13AW  
PCMK: SEG3013-012  
Welder: 067609  
WPS-B-P-2214-B-U2-FCM-1

PCMK: SEG3013AD-008  
Welder: 066443  
Report: B-WR20534  
WPS-345-SMAW-3G (3F)-FCM-Repair-1

PCMK: SEG3013AA-110,116,117  
Welder: 069683  
Report: B-WR20525  
WPS-345-SMAW-4G (4F)-FCM-Repair-1

This QA Inspector observed the following work in progress for Trial Assembly Yard.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Lui Hua Jie.

# WELDING INSPECTION REPORT

( Continued Page 3 of 4 )

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: 13AW

PCMK: SEG3013E-116, 146

Welder: 048433

WPS-B-P-2214-B-U2-FCM-1

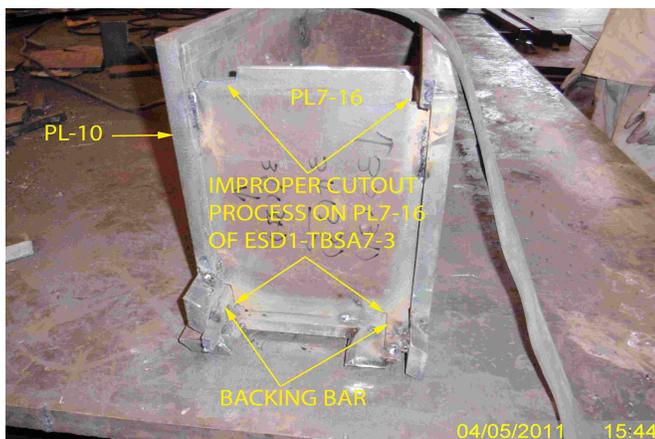
PCMK: SEG3013D-116, 150

Welder: 048696

Report: B-WR20577

WPS-345-FCAW-3G (3F)-ESAB-FCM-Repair

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



## Summary of Conversations:

No relevant conversations

---

---

# WELDING INSPECTION REPORT

( Continued Page 4 of 4 )

---

---

## 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 15000422372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Shin,DJ	Quality Assurance Inspector
----------------------	---------	-----------------------------

---

<b>Reviewed By:</b>	Riley,Ken	QA Reviewer
---------------------	-----------	-------------