

**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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022986**Date Inspected:** 06-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**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, Kelly Leavitt, was present during the times noted above for random 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 Wong Xiang Pin, CWI Wang Jun.

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; OBG 14 W

PCMK: DP3172-001

Weld No: 024

Welder: 067876

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

Components; OBG 14 W

PCMK: DP3172-001

Weld No: 303

Welder: 067611

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

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Components; OBG 14 W  
PCMK: SEG3020K  
Weld No: 004  
Welder: 066398  
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 14 W  
PCMK: SEG3020BB  
Weld No: 047  
Welder: 067829  
WPS-B-P-2214-TC-U4b-FCM-1

This QA Inspector observed the following work in progress for Bay 14.  
ZPMC was using the Flux Core Arc Welding (FCAW) process.  
ZPMC QC is identified as Wong Xiang Pin, CWI Wang Jun.  
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; OBG Traveler Rails  
PCMK: 3027TR2  
Weld No: 011  
Welder: 201215  
WPS-B-T-2232-ESAB

Components; OBG Traveler Rails  
PCMK: 3021TR2  
Weld No: 002,003  
Welder: 066734  
WPS-B-T-2232-ESAB

Components; OBG Traveler Rails  
PCMK: 3027TR2  
Weld No: 005,006  
Welder: 066695  
WPS-B-T-2232-ESAB

Components; OBG 14 E  
PCMK: SEG3020\*  
Weld No: 021  
Welder: 045143  
WPS-B-T-2232-ESAB

Components; OBG 14 E (see photo below)

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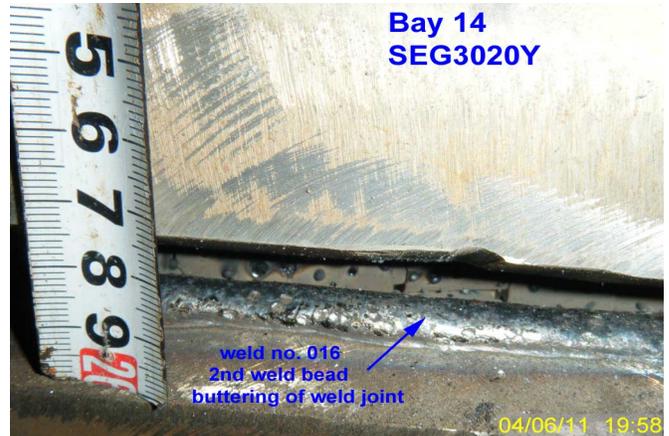
PCMK: SEG3020Y

Weld No: 016

Welder: 066673

WPS-B-T-2232-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 James Devey 1500026784, who represents the Office of Structural Materials for your project.

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**Inspected By:** Leavitt, Kelly

Quality Assurance Inspector

**Reviewed By:** Riley, Ken

QA Reviewer

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