

**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-023282**Date Inspected:** 02-May-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:** Mr. Shi Lei**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 Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

Trial Assembly / OBG segment 12CW

This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated MT report for this date. The member is identified as Counterweight side holdback welds as per ZPMC notification # 09009.

The weld designations reviewed are as follows:

DP3071-001-013, 014

EP3012-001-013, 015, 017, 018

SP3057-001-034, 0350, 40, 041

SP3056-001-017, 018, 023, 024

SP3055-001-017, 018, 023, 024, 072, 073

BP3029-001-003, 004, 007, 008

Trial Assembly / OBG segment 13BE

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## WELDING INSPECTION REPORT

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This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated MT report for this date. The member is identified as OBG 13BE welds as per ZPMC notification # 09011.

The weld designations reviewed are as follows:

SEG3009D-064, 096

SEG3009S-004, 005, 015, 016, 017, 018, 028, 029, 037, 038, 046, 047

SEG3009D-066, 071, 076, 081, 086, 091, 098, 103, 113, 118, 123, 128, 133, 138, 143, 148, 153

Trial Assembly / OBG segment 13AW

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 3F position of weld # SEG3013B-236. The welder is identified as 037779. Quality Control (QC) is identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS-B-P-2113-FCM-1.

Trial Assembly / OBG segment 13AW

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 3G position of repair weld # SEG3013M-188, as per B-WR # 20695. The welder is identified as 066109. Quality Control (QC) is identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G(3F)-FCM-Repair.

Trial Assembly / OBG segment 13AW

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of repair weld # SEG3013M-093, as per B-WR # 20695. The welder is identified as 067864. Quality Control (QC) is identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-FCM-Repair.

Trial Assembly / OBG segment 13CW

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4F position of weld # SEG3015K-207. The welder is identified as 066179. Quality Control (QC) is identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-FCM-1.

Trial Assembly / OBG segment 13BW

This QA Inspector observed the following work in progress:

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## WELDING INSPECTION REPORT

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Shielded Metal Arc Welding (SMAW) in the 4F position of weld # SEG3014S-002. The welder is identified as 045196. Quality Control (QC) is identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-FCM-1.

Trial Assembly / OBG segment 13W

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 1G position of deck panel weld # SA3126-004. The welder is identified as 045143. Quality Control (QC) is identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS- B-T-2231-ESAB.

**Summary of Conversations:**

No relevant conversations reported on this date.

**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 (+86) 15000026784 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Gade,Ramesh	Quality Assurance Inspector
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<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer
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