

**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-023300**Date Inspected:** 21-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

<b>CWI Name:</b>	Mr.			<b>CWI Present:</b>	Yes	No	
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006			<b>Component:</b>	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 13AE

This QA inspector performed Ultrasonic Testing (UT) approximately 10% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated UT report for this date. The member is identified as OBG 13AE welds as per ZPMC notification # 08895.

The weld designations reviewed are as follows:

SEG3007S-001  
SEG3007R-005  
SEG3007P-032  
DP3072-001-043, 044, 045

Trial Assembly / OBG segment 13AW

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 1G position of weld # EP3023-029. The welder is identified as 067611. Quality Control (QC) is identified as Li Yang. The welding variables recorded by QC appeared to

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

comply with WPS-2211-B-U2-FCM-1.

Trial Assembly / OBG segment 12CW

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 1G position of weld # CA3010-005. The welder is identified as 067829. Quality Control (QC) is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-2214-TC-U4b-FCM-1.

Trial Assembly / OBG segment 13AW

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of weld # SEG3013-221. The welder is identified as 66673. Quality Control (QC) is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS- B-T-2233-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 Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

---

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

---