

**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-023314**Date Inspected:** 19-Mar-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. Geng Wei  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** 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.

**OBG Segment 13CE / Bay 14**

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 3G position of weld # SEG3011C-198. The welder is identified as 066422. Quality Control (QC) is identified as Wang Xu. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-B-U2-FCM-1. See attached photograph Pic\_001.

**OBG Segment 13BE / Bay 14**

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 1G position of weld # SEG3009V-012. The welder is identified as 020663. ZPMC Quality Control (QC) is identified as Wang Xu. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-ESAB.

**OBG Segment 13BE / Bay 14**

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This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 1G position of weld # SEG3009V-022. The welder is identified as 044824. ZPMC Quality Control (QC) is identified as Wang Xu. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-ESAB.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

During in process inspection this QA Inspector observed ZPMC personnel performing back gauging on CB side LD to BP weld # SEG3019Y-053, as per B-WR # 19719.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of Edge panel repair weld # SEG3019AG-050, as per B-WR # 20408. The welder is identified as 043661 and 044779. Quality Control (QC) is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS-SMAW-345-4G(4F)-FCM-Repair.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 3G position of weld # SEG3019BB-148. The welder is identified as 215553. Quality Control (QC) is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-B-U2-FCM-1.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 3G position of weld # SEG3019BB-221. The welder is identified as 215553. Quality Control (QC) is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-B-U2-FCM-1. See attached photograph Pic\_002.

Note: - This QA found above weld # SEG3019BB-221 welded without run up tab, and brought in to notice of available ZPMC QC.

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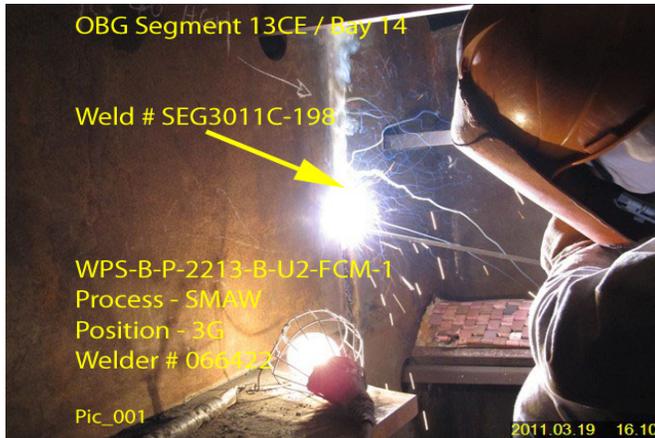
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# WELDING INSPECTION REPORT

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## 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.

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

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