

**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-023366**Date Inspected:** 15-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shen Fu Yoo**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 Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath. Math. was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

BAY 14

Deck Panel

Flux Cored Arc Welding (FCAW) for Deck floor diaphragm to Deck plate for weld Joint No. DP 227-010, 011, 025, 026, 039, 040, 052, 053, 065, 066 in progress. Welder is identified as 067184. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2122; WPS-B-T-2133 and WPS -B-T-2233-TC-U4b-F.

Flux Cored Arc Welding (FCAW) for Deck floor diaphragm to Deck plate for weld Joint No. DP 115-010, 011, 021, 022, 026, 017 and 025 in progress. Welder is identified as 205091. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2122; WPS-B-T-2133 and WPS -B-T-2233-TC-U4b-F.

Flux Cored Arc Welding (FCAW) Deck plate DP116A to DP143A Weld Joint No. SEG037\*-003 in progress. Welder is identified as 201215. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr.

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Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the B-T-2231-B-U2-F.

Submerged Arc Welding (SAW) Deck plate DP089A to DP116A Weld Joint No. SEG037\*-002 in progress. Welder is identified as 045265. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the B-T-2221-B-L2C-S-2.

Flux Cored Arc Welding (FCAW) for Deck floor diaphragm to Deck plate for weld Joint No. DP-277-001-008, 009, 028, 029, 037, 038, 014, 015, 023, 024 and 042 in progress. Welder is identified as 205091. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS-B-T-2122; WPS-B-T-2133.

Flux Cored Arc Welding (FCAW) for Deck floor diaphragm to Deck plate for weld Joint No. DP 198-001-014, 015, 029, 030, 039, 020, 021, 038, 039, 027 and 028 in progress. Welder is identified as 066155 and 204730. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS-B-T-2122; WPS-B-T-2133 and WPS –B-T-2233-TC-U4b-F.

Flux Cored Arc Welding (FCAW) for Deck floor diaphragm to Deck plate for weld Joint No. DP 117-001-058, 059, 061, 062, 100, 102, 056, 047, 052, 057 in progress. Welder is identified as 066155 and 204730. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS-B-T-2122; WPS-B-T-2133 and WPS –B-T-2233-TC-U4b-F.

Flux Cored Arc Welding (FCAW) for Deck floor diaphragm to Deck plate for weld Joint No. DP 196-001-077, 078, 085, 086, 074 and 075 in progress. Welder is identified as 067947. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS-B-T-2122; WPS-B-T-2133 and WPS –B-T-2233-TC-U4b-F.

Flux Cored Arc Welding (FCAW) for Deck floor diaphragm to Deck plate for weld Joint No. DP 144-001, 012, 013, 032, 037, 051, 059, 069, 070 and 077 in progress. Welder is identified as 067947. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS-B-T-2122; WPS-B-T-2133 and WPS –B-T-2233-TC-U4b-F.

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

## Summary of Conversations:

No relevant conversations were 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 15000422372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Math,Manjunath

Quality Assurance Inspector

**Reviewed By:** Miller,Mark

QA Reviewer