

**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-023396**Date Inspected:** 22-Apr-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:** Lu Li Qing**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:

OBG ASSMEBLY # BAY 14

Segment No. 6BW

Flux Core Arc Welding (FCAW) of weld joint –SEG-029B-018 and 019 in progress. Welder is identified as 067103. 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-2132-3.

Segment No. 6CW

Flux Core Arc Welding (FCAW) of weld joint – SSD12A-PP-46 in progress. Welder is identified as 067949. 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 –T-2132-3.

Shielded Metal Arc Welding (SMAW) of weld joint – SSD12A-PP-47 in progress. Welder is identified as 067765. 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-P-2114-FCM.

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# WELDING INSPECTION REPORT

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Segment No. 7CW

Flux Core Arc Welding (FCAW) Welding of weld joint – SEG SSD14-PP-53-135 in progress. Welder is identified as 201215. 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-2233-B-U2-F.

Flux Core Arc Welding (FCAW) Welding of weld joint – SEG SSD14A-PP-53-131 in progress. Welder is identified as 201215. 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-2233-B-U2-F.

Segment No. 6AW

Shielding Metal Arc Welding (SMAW) Welding of weld joint – SEG 027B-024 in progress. Welder is identified as 066361. 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-P-2214-T-C-U4B-FCM and WPS B-T-2233-TC-U4B-FCM.

SEGMENT ASSEMBLY # BAY 19

Magnetic Particle Testing (MT)

Against the NDT Inspection Notification Sheet Document No. 002743 Dated April 22, 2009.

The MT was not performed for Bike Path, as ZPMC has not completed the MT.

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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<b>Inspected By:</b>	Math,Manjunath	Quality Assurance Inspector
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<b>Reviewed By:</b>	Miller,Mark	QA Reviewer
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