

**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-023404**Date Inspected:** 23-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:** Feng Hai Jun**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 Assembly # BAY 19

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a MT report of this date. The member is identified as BP026-006-004 ~023 and BP026-006-044~053, Total 32 Welds.

OBG Assembly # BAY 14

Segment No. 6CW

Shielded Metal Arc Welding (SMAW) of weld joint – SSD10B-PP44-228,221; 241,251 and 230,231 in progress. Welder is identified as 067103 and 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 B-T-2231-TC-U4C-FCM.

Segment No. 6CW

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## WELDING INSPECTION REPORT

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Shielded Metal Arc Welding (SMAW) of weld joint – SEC 027B-609 and 026 in progress. Welder is identified as 051348 and 066326. 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-TC-U4b-FCM.

Shielded Metal Arc Welding (SMAW) of weld joint – SP-517-001-061 to 066 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.

Deck Panels for 7DW

Submerged Arc Welding (SAW) of weld joint SEG No. 039\*-002 for Deck Plated DP144A to DP117A. 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 WPS B-T-2221-B-L2C-S-2.

Segment No. 6CW

Flux Core Arc Welding (FCAW) of weld joint – DP167-X17-19 and 20 in progress. Welder is identified as 066882. 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-2231-B-U2-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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<b>Inspected By:</b>	Math,Manjunath	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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