

**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-023511**Date Inspected:** 16-Apr-2011**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:** Geng Wei**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 Structure**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Mr. Manuel Teall was present during the times noted above for observations relative to the work being performed at ZPMC

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On this day CALTRANS OSM Quality Assurance (QA) Inspector Manuel Teall was present during the times noted above for observations relative to the fabrication of the Self-Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 14

OBG Seg 14W:

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## WELDING INSPECTION REPORT

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Repair welding of weld joint no: SEG3020AQ-025 [Top Anchorage Plate PL3519A to Side Panel (SP) 3144B, Complete Joint Penetration (CJP) weld in between panel point (PP) 125 to PP126]. The welders are identified as 066361 and 045246 and were observed welding in the 1G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Mr. Liu Fang. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-1G(1F)-FCM-Repair-1. Repair welding was done as per Critical Welding Repair (CWR) Report: B-CWR 2923 Rev-0.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020BB-048 [Vertical Shear Plate extension plate X5062A to Anchor Plate (AP) 3032A, complete joint penetration (CJP) weld at PP 126]. The welder is identified as 066261 and was observed welding in 4G position. ZPMC Quality Control (QC) was identified as Mr. Liu Fang. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): B-P-2214-Tc-U4b-FCM-1.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020BB-066 [Vertical Shear Plate extension plate X5064A to AP 3032A, complete joint penetration (CJP) weld at PP 126]. The welder is identified as 037932 and was observed welding in 4G position. ZPMC Quality Control (QC) was identified as Mr. Liu Fang. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): B-P-2214-Tc-U4b-FCM-1.

The SMAW process on weld joint no: SEG3020M-009 [Deck Panel (DP) diaphragm X4817D of DP 3174A to Floor Beam (FB) 3328A, CJP weld at PP127]. The welder is identified as 067580 and was observed welding in 2G position. ZPMC QC was identified as Mr. Liu Fang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-B-U2-FCM-1.

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3020H-010 [DP diaphragm X4856M of DP 3171A to DP diaphragm X4857G of DP 3172A, CJP weld at PP127.5]. The welder is identified as 066881 and was observed welding in 3G position. ZPMC QC was identified as Mr. Liu Fang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

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

On this date Caltrans OSM Quality Assurance (QA) Inspector, Mr. Manuel Teall was present during the times noted above for observations relative to the work being performed at ZPMC.

### **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

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## WELDING INSPECTION REPORT

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remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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