

**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-023682**Date Inspected:** 15-May-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. Lv Li Qing  
**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.

Trial Assembly / OBG Segment 13BE

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of BK side temporary attachment removed area, as per B-CWR # 2880. The welder is identified as 044772. ZPMC Quality Control (QC) is identified as Lv Li Qing. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(42F)-FCM-Repair. See attached photograph Pic\_001.

Trial Assembly / OBG Segment 13AE -13BE

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 1G position of Deck Panel weld # OBE13-002. The welder is identified as 067184. ZPMC Quality Control (QC) is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS-2211-B-U2-FCM-1.

Trial Assembly / OBG Segment 14W

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# WELDING INSPECTION REPORT

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This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2G position of weld # SA7514-003. The welder is identified as 045240. ZPMC Quality Control (QC) is identified as An Qing Xian. The welding variables recorded by QC appeared to comply with WPS-2212-TC-U4b-FCM-1.

Trial Assembly / OBG Segment 14W

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4F position of weld # FB3237-001-005. The welder is identified as 066479. ZPMC Quality Control (QC) is identified as An Qing Xian. The welding variables recorded by QC appeared to comply with WPS-2114-FCM-1.

Trial Assembly / OBG Segment 14E

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 3G position of weld # SEG3019Q-2-195. The welder is identified as 037997. ZPMC Quality Control (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-2213-TC-U4b-FCM-1.

Trial Assembly / OBG Segment 14E

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 2G position of weld # SEG3019U-072. The welder is identified as 066419. ZPMC Quality Control (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-2212-TC-U4b-FCM-1.



## 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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# WELDING INSPECTION REPORT

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