

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-023736**Date Inspected:** 11-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**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**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

**Trial Assembly**

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Xie Ming Feng and ABF QA Sha Zhi.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14E

PCMK: SEG3009V

Weld No: 020,021

Welder: 058102

Weld Repair No. B-WR20879

WPS-345-SMAW-1G(1F)-FCM-Repair-1

Components; OBG 14E

PCMK: SEG3019AE

Weld No: 007,014,021,028

Welder: 044779

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 4 )

---

---

WPS-B-P-2213-TC-U4b-FCM-1

Components; OBG 14E

PCMK: SEG3019AE

Weld No: 007,014,021,028

Welder: 215553

WPS-B-P-2213-TC-U4b-FCM-1

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Xie Ming Feng and ABF QA Sha Zhi.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14E

PCMK: SEG3007B

Weld No: 230,232,234

Welder: 055564

WPS-B-T-2233-ESAB

Components; OBG 13CE

PCMK: SEG3011E

Weld No: 259,262

Welder: 050977

WPS-B-T-2233-ESAB

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Shen Jian Bo and ABF QA Sha Zhi.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14E

PCMK: SEG3013AH

Weld No: 035

Welder: 066019

Weld Repair No. B-WR20703

WPS-345-SMAW-1G(1F)-FCM-Repair-1

Components; OBG 13AW

PCMK: SEG3013AH

Weld No: 177

Welder: 070432

WPS-B-P-2214-FCM-1

---

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 4 )

---

---

Components; OBG  
PCMK: SEG3013G  
Weld No: 086,087,088  
Welder: 069683  
Weld Repair No. B-WR20604  
WPS-345-SMAW-3G(3F)-FCM-Repair-1

Components; OBG  
PCMK: SEG3013D  
Weld No: 094,099  
Welder: 037779  
Weld Repair No. B-WR20606  
WPS-345-SMAW-4G(4F)-FCM-Repair-1

This QA Inspector observed the following work in progress for Trial Assembly.  
ZPMC was using the Flux Core Arc Welding (FCAW) process.  
ZPMC QC is identified as Shen Jian Bo and ABF QA Sha Zhi.  
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).  
Listed below are the locations that were identified by this QA inspector.

Components; OBG  
PCMK: SEG3013H  
Weld No: 037  
Welder: 048433  
Weld Repair No. B-CWR2836  
WPS-345-FCAW-3G(3F)-FCM-Repair-1

Components; OBG  
PCMK: SA3126-001  
Weld No: 001  
Welder: 048240  
WPS-B-T-2231-ESAB

Components; OBG 13BW  
PCMK: SEG3014W  
Weld No: 118,114,122,126  
Welder: 045143  
WPS-B-T-2132-ESAB

Components; OBG 13BW  
PCMK: SEG3014H  
Weld No: 207  
Welder: 066673

---

---

# WELDING INSPECTION REPORT

( Continued Page 4 of 4 )

---

---

Weld Repair No. B-CWR20907

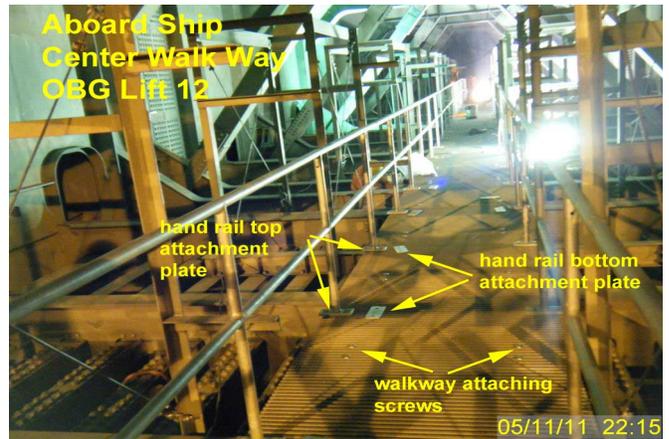
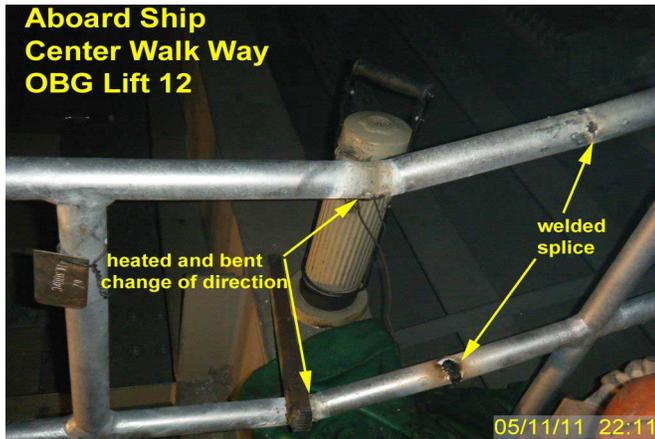
WPS-345-FCAW-3G(3F)-FCM-Repair-1

Heavy Dock, Loaded On Ship

This QA Inspector observed the following work in progress for Heavy Dock location, using Shielded Metal Arc Welding (SMAW) with TL-508 welding rod on PCMK RL3003B. Welder was identified as 049769. The two welds ZPMC completed in this area were hand rail non-structural pipe splices. (see photo below)

This Caltrans QA Inspector observed ZPMC performing bolting and attaching internal hand rails RL3003B and RL3004A, and walk way grading in OBG Lift 12W. (see photo below)

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



### Summary of Conversations:

"No relevant conversations."

### 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 James Devey 1500026784, who represents the Office of Structural Materials for your project.

---

**Inspected By:** Leavitt, Kelly

Quality Assurance Inspector

**Reviewed By:** Riley, Ken

QA Reviewer

---