

**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-023926**Date Inspected:** 22-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 performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member was identified as OBG 13BE and 13CE. The weld designations reviewed are as follows:

DP3089-001-019,020,022,023,025,026,028,029

DP3102-001-243,244,246,247,249,250,252,253,255, 256

SEG3011M-001~020

SEG3009K-001~016

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member was identified as OBG 13AW. The weld designations reviewed are as follows:

SEG3013S-086,084,082,080,078,076,074,072,070,068,066,064,062,060,157,090,168,172,176,180,185, 189,193, 197,201,205

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 Wong Xiang Pin and ABF QA Sha Zhi.

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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: SEG3019\*  
Weld No: 015  
Welder: 066733  
Weld Repair No. B-WR21051  
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Components; OBG 14E  
PCMK: SEG3019AA  
Weld No: 003  
Welder: 040769  
Weld Repair No. B-WR20923  
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Components; OBG 14E  
PCMK: SEG3019D-1  
Weld No: 146  
Welder: 058102  
Weld Repair No. B-WR21066  
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Components; OBG 13BE  
PCMK: KP3005-001  
Weld No: 001  
Welder: 037723  
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 13BE  
PCMK: KP3007-001  
Weld No: 005  
Welder: 037723  
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 13AW  
PCMK: SEG3013B  
Weld No: 320  
Welder: 066398  
WPS-B-P-2213-TC-U4b-FCM-1

Components; OBG 14W  
PCMK: SP3131-001

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Weld No: 057,066  
Welder: 070008  
WPS-B-P-2112-FCM-1

Components; OBG  
PCMK: SEG3015B  
Weld No: 244,245,248,249,252,253  
Welder: 070008  
WPS-B-P-2112-FCM-1

Components; OBG 14W  
PCMK: VP3018-001  
Weld No: 001~003  
Welder: 068917  
WPS-B-P-2114-FCM-1

Components; OBG 14W  
PCMK: VP3019-001  
Weld No: 007~009  
Welder: 068917  
WPS-B-P-2114-FCM-1

Components; OBG 13CW  
PCMK: VP3015-001  
Weld No: 001,011,012  
Welder: 067829  
WPS-B-P-2114-FCM-1

Components; OBG 14W  
PCMK: VP3014-001  
Weld No: 012,020,031  
Welder: 067829  
WPS-B-P-2114-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 Wong Xiang Pin 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 13AW  
PCMK: LD3034-001  
Weld No: 148,149,124,125,127,128  
Welder: 067275, 067876, 067520

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WPS-B-T-2132-ESAB

Components; OBG 13AW

PCMK: LD3035-001

Weld No: 148,149,124,125,127,128

Welder: 067275, 067876, 067520

WPS-B-T-2132-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 Sun Tian Liang and An Qing Ziang.

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: SEG3013Y

Weld No: 419

Welder: 066674

Weld Repair No. B-WR19836

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

Components; OBG

PCMK: SEG3013AH

Weld No: 168

Welder: 067588

WPS-B-P-2214-B-U2-FCM-1

Components; OBG 13AW

PCMK: SEG3013AH

Weld No: 156

Welder: 067904

WPS-B-P-2214-B-U2-FCM-1

Components; OBG

PCMK: SEG3013Y

Weld No: 423

Welder: 066673

WPS-B-P-2214-B-U2-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 Sun Tian Liang and An Qing Ziang.

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.

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Components; OBG 14W  
PCMK: SEG3020AJ  
Weld No: 012,034,043,061,081,087,092  
Welder: 037705, 070101  
WPS-B-T-2233-ESAB

Components; OBG 13BW  
PCMK: SA3134-002  
Weld No: 001,002  
Welder: 045143  
WPS-B-T-2231-ESAB

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.

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<b>Inspected By:</b>	Leavitt, Kelly	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley, Ken	QA Reviewer

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