

**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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023935**Date Inspected:** 11-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Lv Li Qing**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 12CW, 13AW, 14E, Tower**Summary of Items Observed:**

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

**DOCK SHIP 18**

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 09101 from ZPMC for Trial Assembly Yard. This QA inspector performed magnetic particle testing (MT) verification of welds after ZPMC had performed their MT inspection. The segment is identified as Tower. The weld designations reviewed are as follows.

WSD1-CSA6-37-008, 009

WSD1-CSA6-47-004~006

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 09106 from ZPMC for Ship 18. This QA inspector performed ultrasonic, and magnetic particle testing (UT & MT) verification of welds after ZPMC had performed their UT/MT inspection. The segment is identified as 12CW. The weld designations reviewed are as follows.

SEG3006C-134, 139, 144

SEG3006B-145, 151, 156, 167

SEG3006C-161

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

### TRIAL ASSEMBLY YARD

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

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

ZPMC QC is identified as Wang Xiang Pin.

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.

Component: I Rib Stiffener to DP Diaphragm

PCMK: SEG3013R

Weld Number: 032

Welder: 205098

WPS-B-T-3213

### BAY 11

This QA Inspector observed the following work in progress for Bay 11.

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

ZPMC QC is identified as Wang Xiang Pin.

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.

Component: Tower Crain Jib

PCMK: ESD1-TBSA7-3

Weld Number: 003, 004

Welder: 041271

WPS-345-SMAW-4G-FCM-Repair-1

B WR-20498

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

---

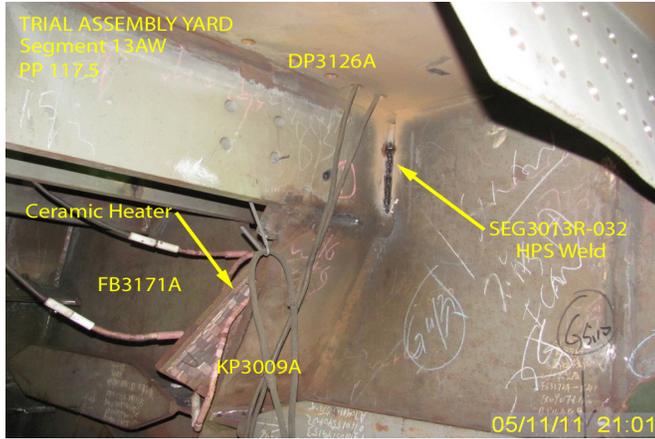
---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---



## 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 15000026784, who represents the Office of Structural Materials for your project.

---

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

---