

**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-023994**Date Inspected:** 17-May-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:** Liu Hua Jie**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 Components**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector, Anand Upadhye was present during the times noted above for observations relative to the work being performed.

**WELDING**

This QA Inspector observed the following work in progress:

**Outside Yard – OBG Trial Assembly**

This QA Inspector observed ZPMC qualified welding personnel identified as 066416 perform repair welding by Shielded Metal Arc Welding (SMAW), on Floor beam Stiffener weld of OBG Segment 13AE. Weld joint is identified as SEG3007U-188. ZPMC Quality Control (QC) Inspector identified as Liu Hua Jie was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-1G-FCM-Repair-1, which is used as per Welding repair report B-WR20987.

This QA Inspector observed ZPMC qualified welding personnel identified as 066416 perform repair welding by Shielded Metal Arc Welding (SMAW), on Floor beam Stiffener weld of OBG Segment 13AE. Weld joint is identified as SEG3007U-202. ZPMC Quality Control (QC) Inspector identified as Liu Hua Jie was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1, which is used as per Welding repair report B-WR20987.

This QA Inspector observed ZPMC qualified welding personnel identified as 043611 perform repair welding by

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Shielded Metal Arc Welding (SMAW), on Deck panel to Deck panel diaphragm weld of OBG Segment 13AE. Weld joint is identified as SEG3007J-013. ZPMC Quality Control (QC) Inspector identified as Liu Hua Jie was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1, which is used as per Welding repair report B-WR20872.

This QA Inspector observed ZPMC qualified welding personnel identified as 037743 perform repair welding by Shielded Metal Arc Welding (SMAW), on Deck panel I Rib to Floor beam diaphragm plate weld of OBG Segment 13AE. Weld joint is identified as SEG3007H-020. ZPMC Quality Control (QC) Inspector identified as Liu Hua Jie was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1, which is used as per Welding repair report B-WR20872.

This QA Inspector observed ZPMC qualified welding personnel identified as 068501 perform welding by Flux Cored Arc Welding (FCAW), on Side plate to diaphragm plate X3490A weld of OBG Segment 13AE. Weld joint is identified as SEG3007Q-072, 081. ZPMC Quality Control (QC) Inspector identified as Liu Hua Jie was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2233-ESAB. See attached picture.

This QA Inspector observed ZPMC qualified welding personnel identified as 066258 perform welding by Shielded Metal Arc Welding (SMAW), on Deck panel I Rib to I Rib weld. Weld joint is identified as OBE13G-001, 004, 007. ZPMC Quality Control (QC) Inspector identified as Wang Li Yang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-3213-B-U3b.

This QA Inspector observed ZPMC qualified welding personnel identified as 040378 perform weld build up by Shielded Metal Arc Welding (SMAW), on Deck panel I Rib stiffeners. Deck panel I Rib stiffeners are identified as RS3113A and RS3113C. ZPMC Quality Control (QC) Inspector identified as Wang Li Yang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-485-SMAW-3G (3F)-Repair, which is used as per Welding repair report B-WR20962.

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

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

No significant 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 remedial efforts please contact Eric Tsang, phone: 15000422372 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Upadhye, Anand	Quality Assurance Inspector
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<b>Reviewed By:</b>	Clifford, William	QA Reviewer
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