

**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-024058**Date Inspected:** 17-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 Components**Summary of Items Observed:**

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

**OBG Trial Assembly Area**

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

SMAW repair welding of weld joint SEG3019AW-096 located on PCMK OBG 14E. Welder was identified as 044779. QC was identified as ZPMC CWI Sha Zhi (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Xie Ming Feng (QCA1), who was not a CWI.

Weld variables recorded by QCA1 appeared to comply with WPS-345-SMAW-2G(2F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-WR21012 as presented to this QA Inspector and verbally identified by QCA1.

FCAW welding of weld joints SA3063-001~007-001, 005 located on PCMK OBG 13CE. Welder was identified as 050977. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2231-ESAB as verbally identified by QCA1.

SMAW welding of weld joint SEG3011L-271 located on PCMK OBG 13CE. Welder was identified as 051359. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with

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WPS-B-P-2214-TC-U4b-FCM-1 as verbally identified by QCA1.

SMAW welding of weld joints SEG3011K-111, 121 located on PCMK OBG 13CE. Welder was identified as 051359. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2213-TC-U4b-FCM-1 as verbally identified by QCA1.

SMAW welding of temporary alignment plates located at PCMK OBG 13CE/14E transverse joint deck plates. Welder was identified as 044760. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2212-FCM-1 as verbally identified by QCA1.

FCAW welding of weld joints BP3043-001-049~058; BP3080-001-001~010 located at the PCMK OBG 13CE/14E transverse joint, holdback welds. Welder was identified as 055564. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2232-ESAB as verbally identified by QCA1. See photo below of typical bottom plate to bottom plate I-rib holdback welds as welded as noted above.

FCAW welding of weld joint OBE13AD-001 located at the PCMK OBG 13AE/13BE transverse joint. Welder was identified as 050242. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA1.

SMAW welding of weld joint SP3117-001-109 located on PCMK OBG 14E. Welder was identified as 044779. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2214-FCM-1 as verbally identified by QCA1.

SMAW welding of weld joint SP3117-001-110 located on PCMK OBG 14E. Welder was identified as 501946. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2214-FCM-1 as verbally identified by QCA1. See photo below of the two above noted welders performing SMAW welding at adjacent weld joints.

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

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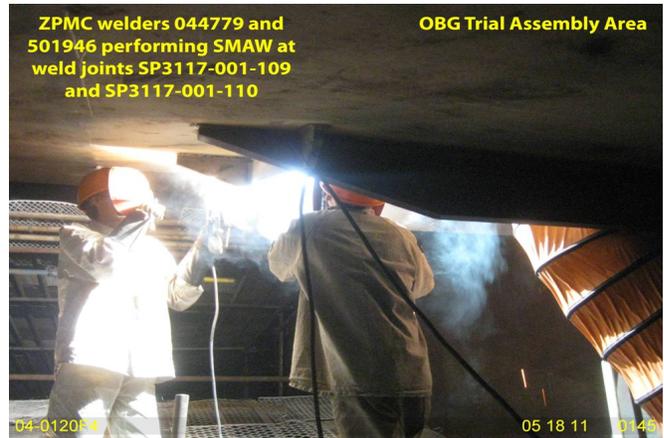
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## Summary of Conversations:

As noted above.

## 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.

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**Inspected By:** Goulet, George

Quality Assurance Inspector

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**Reviewed By:** Riley, Ken

QA Reviewer