

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-024119**Date Inspected:** 19-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 Liu Yang (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. See photo below of repair welding apparently completed.

SMAW welding of weld joint SEG3019E-1-411, 413 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-2213-TC-U4b-FCM-1 as displayed on ZPMC Weld Repair Report B-WR21012 as presented to this QA Inspector and verbally identified by QCA1.

SMAW repair welding of weld joint SEG3019AW-100 located on PCMK OBG 14E. Welder was identified as 215553. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding

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operation and recording data was 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 and presented to this QA Inspector and verbally identified by QCA1.

FCAW welding of weld joints SEG3007C-216, 327 located on PCMK OBG 13AE. 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-2231-ESAB and WPS-B-T-2233-ESAB as verbally identified by QCA1.

SMAW repair welding of weld joints SEG3009B-067, 071, 075, 079 located on PCMK OBG 13BE. Welder was identified as 055491. 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-345-SMAW-3G(3F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-WR21038 and presented to this QA Inspector and verbally identified by QCA1.

SMAW repair welding of weld joint SEG3011K-066, 071, 076, 081, 086, 091 located on PCMK OBG 13BE. Welder was identified as 055491. 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-345-SMAW-3G(3F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-WR21038 and presented to this QA Inspector and verbally identified by QCA1.

SMAW repair welding of weld joint SEG3019C-001 located on PCMK OBG 14E. Welder was identified as 216086. 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-345-SMAW-2G(2F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-WR21037 and presented to this QA Inspector and verbally identified by QCA1.

FCAW welding of weld joints SEG3007C-209, 211, 212, 213 located on PCMK OBG 13AE. 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-2132-ESAB as verbally identified by QCA1.

FCAW welding of weld joints BP3082-001-001~012 located on PCMK OBG 13CE/14E, 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-2132-ESAB as verbally identified by QCA1.

FCAW welding of weld joints BP3083-001-018, 019, 026, 027, 034, 035, 042, 043, 050, 051, 058, 059 located at PCMK OBG 13CE/14E, holdback welds. 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-2132-ESAB as verbally identified by QCA1.

SMAW welding of weld joints SEG3011A-003; SEG3019A-001 located on PCMK OBG 13CE/14E, holdback

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welds. Welder was identified as 058102. 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-TC-U4b-FCM-1 as verbally identified by QCA1.

FCAW repair welding of weld joint SEG3011H-067, 071, 075, 079, 083, 087 located on PCMK OBG 13CE. Welder was identified as 052696. 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-345-FCAW-3G(3F)-ESAB-repair as displayed on ZPMC Weld Repair Report B-WR21038 and presented to this QA Inspector and verbally identified by QCA1.

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



### 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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<b>Inspected By:</b>	Goulet, George	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley, Ken	QA Reviewer

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