

**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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024187**Date Inspected:** 22-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**CWI Name:** Wang Yi Lang, Chen Shigang**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 R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

Trial Assembly Segments 13AE @ CB18E

This QA Inspector observed the ZPMC personnel performing bolt hole priming at 13AE @ CB18E, FB3108A, FB3122A, FB3109A, FB3125A, FB3121A, connection areas for bottom plate installation. All bolt holes to receive future M24 & M30 high strength bolting assemblies were being cleaned with medium grit sandpaper and brass wire brushes prior to primer application at each hole. This inspector also observed match drilling for connection plates attaching CB18W to 13AW and CB18E to 13EW.

Trial Assembly 13AE @ 13BE

SMAW welding of complete joint penetration welds located on Bottom Panel Splice area identified as Splice OBE13B-002 as identified on weld repair data sheet BWR-21047 for repaired complete joint penetration welds identified as weld no.(s): 002. Welder is identified as welder no. 067656. The welding variables recorded by ZPMC QC identified as Wang Yi Lang appeared to comply with applicable WPS(s) WPS-345-SMAW-4G(4F)-FCM-Repair-1.

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Bay Number 9

Performed verification VT for the component(s) identified as OBG Traveler Rail sub assembly for component listed as TR023-001-001~005-001 & 002, TR023-001-001~005-005 & 008, TR023-001-001~005-009 & 012, TR023-001-001~005-013 & 016, TR023-001-001~005-013 & 016, TR023-001-001~005-029 & 032, TR023-001-001~005-037 & 040, TR023-001-001~005-045 & 048, TR023-001-001~005-053 & 056, TR023-001-001~005-061 & 064. This QA inspector signed green tag #16077.

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. All components were as listed on NWIT notification no. 09209. The member(s) is/are identified as OBG Traveler Rail sub assembly components identified below with the following identifying weld no.(s):

1. TR023-001-001~005-001, 002.
2. TR023-001-001~005-005, 008.
3. TR023-001-001~005-009, 012.
4. TR023-001-001~005-013, 016.
5. TR023-001-001~005-013, 016.
6. TR023-001-001~005-029, 032.
7. TR023-001-001~005-037, 040.
8. TR023-001-001~005-045, 048.
9. TR023-001-001~005-053, 056.
10. TR023-001-001~005-061, 064.

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents



## Summary of Conversations:

Pertinent conversations are included in the body of the report.

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## 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 1500-0042-02372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hernandez,Rene	Quality Assurance Inspector
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<b>Reviewed By:</b>	Hall,Steven	QA Reviewer
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