

**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-024226**Date Inspected:** 04-Jun-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**Summary of Items Observed:**

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

**Trial Assembly**

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

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhan Hal Fang.

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.

Components; OBG 13BE (see photos)

PCMK: CA3013A

Weld No: 009~011,014~016

Welder: 050977

WPS-B-T-2231-ESAB

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

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

ZPMC QC is identified as Zhang Lin.

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.

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Components; OBG 14W  
PCMK: SEG3020Q  
Weld No: 112,117  
Welder: 066881  
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14W  
PCMK: SEG3020AG  
Weld No: 006  
Welder: 067275  
Repair No, B-WR20428  
WPS-345-SMAW-4G(4F)-FCM-Repair-1

Components; OBG 14W  
PCMK: SEG3015BD  
Weld No: 001,009  
Welder: 068917  
Repair No, B-WR21176  
WPS-345-SMAW-1G(1F)-FCM-Repair-1

Components; OBG 13AW  
PCMK: SEG3013AH  
Weld No: 098  
Welder: 047864  
WPS-B-P-2211-TC-U4b-FCM-1

Components; OBG 14W  
PCMK: FB3329-001  
Weld No: 095,096  
Welder: 070009  
WPS-B-P-2112-TC-U4b-FCM-1

Components; OBG 13AW  
PCMK: SEG3013AH  
Weld No: 076  
Welder: 066674  
Repair No, B-WR20703  
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Components; OBG 13AW  
PCMK: SEG3013Y  
Weld No: 376  
Welder: 066673

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# WELDING INSPECTION REPORT

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Repair No, B-WR20965  
WPS-345-SMAW-2G(2F)-FCM-Repair-1

This QA Inspector observed the following work in progress for Trial Assembly.  
ZPMC was using the Flux Core Arc Welding (FCAW) process.  
ZPMC QC is identified as Zhang Lin.  
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.

Components; OBG 14W  
PCMK: SEG3020L  
Weld No: 015  
Welder: 067876, 037705  
WPS-B-T-2232-ESAB

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



### 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 1500026784, who represents the Office of Structural Materials for your project.

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

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