

**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-024500**Date Inspected:** 21-Jun-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:** An Qing Xiang**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.

NDT

BAY 14

This QA inspector witnessed and performed approximately 15% Magnetic Particle Testing (MT) of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

SEG3020Z-108, 109, 112, 113.

SEG3020AA-029, 030, 033, 034, 031, 032, 035, 036, 001, 002, 003, 037, 038, 039, 040, 041, 042, 043, 044, 014, 004, 005, 006, 019, 020, 021, 007, 008, 045, 046, 049, 050, 047, 048, 051, 052, 015, 009, 010, 053, 054, 057, 058, 055, 056, 059, 060, 016, 018, 065, 062, 061, 063, 064.

**BLAST INSPECTION**

This QA Inspector observed the following work in progress:

Blast Shop 1

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## WELDING INSPECTION REPORT

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This QA Inspector performed random interior and exterior visual inspection of bottom panels, deck panels, side panels and anchor plate of OBG Crossbeam CB19 after Grit/Shot blasting. Areas marked up for weld repairs were recorded on the weld map for future repair and NDT. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

### WELDING

This QA Inspector observed the following work in progress:

#### BAY 14

This QA Inspector observed ZPMC qualified welding personnel identified as 067656 perform welding by Shielded Metal Arc Welding (SMAW), on Deck panel I stiffener plate to Sub Assembly part SA3416C stiffener plate weld of OBG Segment 14W. Weld joint is identified as SEG3020AA-011. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2213-B-U2-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 067947 perform welding by Shielded Metal Arc Welding (SMAW), on Deck panel I stiffener plate to Sub Assembly part SA3416A stiffener plate weld of OBG Segment 14W. Weld joint is identified as SEG3020Y-011. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2213-B-U2-FCM-1. See attached pictures.

This QA Inspector observed ZPMC qualified welding personnel identified as 067904 perform welding by Shielded Metal Arc Welding (SMAW), on Floor beam I Rib stiffener to longitudinal diaphragm weld of OBG Segment 14W. Weld joint is identified as SEG3020D-066. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2211-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 067571 perform welding by Shielded Metal Arc Welding (SMAW), on Floor beam I Rib stiffener to Sub Assembly part SA3416A weld of OBG Segment 14W. Weld joint is identified as SEG3020D-022/023. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2113-FCM-1.

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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**Inspected By:** Upadhye, Anand

Quality Assurance Inspector

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**Reviewed By:** Clifford, William

QA Reviewer