

**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-024538**Date Inspected:** 05-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Changxing Island **Location:** Shanghai, China**CWI Name:** Shi Lei**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, Vikram Singh was present during the times noted above for observations relative to the work being performed at ZPMC.

**WELDING**

TA-Yard

This QA Inspector randomly observed the following work in progress:

**Flux Cored Arc Welding (FCAW)**

This QA Inspector observed the welding operation per the FCAW process on a weld joints identified as SEG3020V-034 located on the OBG Segment 14W. The welder is identified as 066421. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joints identified as SEG3020L-015 located on the OBG Segment 14W. The welder is identified as 037705. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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### Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joints identified as SEG3020BB-077 located on the OBG Segment 14W. The welder is identified as 066361. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joints identified as SEG3020L-001 located on the OBG Segment 14W. The welder is identified as 066326. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joints identified as SEG3020X-068 located on the OBG Segment 14W. The welder is identified as 066479. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joints identified as SEG3020D-228 located on the OBG Segment 14W. The welder is identified as 066239. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joints identified as SEG3020AE-134 located on the OBG Segment 14W. The welder is identified as 066459. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joints identified as SEG3020Q-121 located on the OBG Segment 14W. The welder is identified as 068493. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair and B-WR21174.

This QA Inspector observed the welding operation per the SMAW process on a weld joints identified as AH3002A-049 located on the OBG Segment 13BW. The welder is identified as 069866. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-FCM-1. For more details please see attached photo below:

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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## Summary of Conversations:

No relevant 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 James Devey-15000026784, who represents the Office of Structural Materials for your project.

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

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