

**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-024554**Date Inspected:** 11-May-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:** Li Yan Hua**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 joint identified as SEG3020T-123 located on floor beam to anchor plate stiffener of the OBG Segment 14W. The welder is identified as 066751. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-ESAB.

**Shielded Metal Arc Welding (SMAW)**

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SA3442-001-024 located on SA Stiffener of the OBG Segment 14W. The welder is identified as 069896. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3020AY-002 located on Edge plate of the OBG Segment 14W. The welder is identified as 037749. 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 joint identified as SEG3020W-034 located on anchor plate to floor beam of the OBG Segment 14W. The welder is identified as 067572. 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 joint identified as FB3316-001-109 located on floor beam stiffener of the OBG Segment 14W. The welder is identified as 066825. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2112-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3020AW-009 located on side plate stiffener of the OBG Segment 14W. The welder is identified as 037932. 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 joint identified as SEG3020M-225 located on floor beam of the OBG Segment 14W. The welder is identified as 066261. 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 joint identified as SEG3020N-025 located on side plate stiffener of the OBG Segment 14W. The welder is identified as 037748. 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.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3020W-209 located on floor beam of the OBG Segment 14W. The welder is identified as 040270. 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.

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

### **Summary of Conversations:**

No relevant conversations were reported on this date.

### **Comments**

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# WELDING INSPECTION REPORT

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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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