

**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-024609**Date Inspected:** 09-Jan-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:** Qiu Wei**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**

OBG Bay 14

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 Seg3020M-145 located on Floor Beam to Bottom Plate of the OBG Segment 14W. The welder is identified as 201215. ZPMC Quality Control (QC) is identified as Mr. Liming Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3020R-034 located on Floor Beam of the OBG Segment 14W. The welder is identified as 067421. ZPMC Quality Control (QC) is identified as Mr. Liming Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

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This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3020AL-037/039 located on Floor Beam to Side Plate of the OBG Segment 14W. The welder is identified as 066734. ZPMC Quality Control (QC) is identified as Mr. Liming Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3020Y-030 located on Longitudinal Diaphragm of the OBG Segment 14W. The welder is identified as 066239. ZPMC Quality Control (QC) is identified as Mr. Liming Yang. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G (2F)-ESAB-FCM-Repair and B-CWR2664.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3020X-013 located on Longitudinal Diaphragm of the OBG Segment 14W. The welder is identified as 066239. ZPMC Quality Control (QC) is identified as Mr. Liming Yang. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G (2F)-ESAB-FCM-Repair and B-CWR2662.

### Submersed Arc Welding (SAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SA-3231-026 located on Deck Panel to Deck Panel of the OBG Segment 13AW. The welder is identified as 045265. ZPMC Quality Control (QC) is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3C-S-2.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SA-3231-011 located on Deck Panel to Deck Panel of the OBG Segment 13AW. The welder is identified as 045265. ZPMC Quality Control (QC) is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3C-S-2.

### Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020K-031 located on Floor Beam to Longitudinal Diaphragm of the OBG Segment 14W. The welder is identified as 037780. ZPMC Quality Control (QC) is identified as Mr. Liming Yang. The welding variables recorded by QC appeared to comply with WPS-B-P-2211-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020R-135 located on Floor Beam at PP126 of the OBG Segment 14W. The welder is identified as 066421. ZPMC Quality Control (QC) is identified as Mr. Liming Yang. The welding variables recorded by QC appeared to comply with WPS-B-P-2211-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020AB-100 located on Bottom Plate to Longitudinal Diaphragm of the OBG Segment 14W. The welder is identified as 067610. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-FCM-1.

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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**

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, 15000422372, 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>	Patterson, Rodney	QA Reviewer

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