

**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-024774**Date Inspected:** 07-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 Components**Summary of Items Observed:**

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

**OBG Trial Assembly Area**

In response to ZPMC NDT Inspection Notification Sheet #09392 for magnetic particle testing (MT) inspection of the following:

This QA Inspector performed random visual testing (VT) and then MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members were identified as follows:

OBG Segment 13AW, SEG3013Q. The weld designations reviewed were: 115, 118, 119, 177, 182, 184, 189, 195, 200, 205, 210. No apparent MT indications were observed. However, the cope holes at the ends of weld numbers SEG3013Q-115, 182, 189, 205, 210 were visually unacceptable due to shape and rough surfacing. See photo below of the cope at the end of weld number SEG3013Q-205. Weld number SEG3013Q-113 was inaccessible with less than 30mm clearance from the floor beam I-rib above.

This QA Inspector also randomly observed the following work in progress in the OBG Trial Assembly Area:

SMAW welding of weld joints SEG3019AZ-017; OBE14G-005 located on PCMK OBG 14E. Welder was identified as 216086. QC was identified as ZPMC CWI Li Peng Fei (QC1). Assisting QC1 at this location and

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# WELDING INSPECTION REPORT

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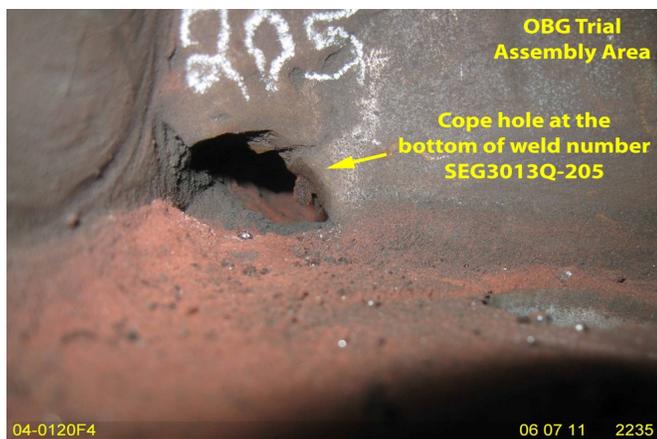
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appearing to be monitoring the welding operation and recording data was ZPMC QC Xie Ming Feng (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2212-FCM-1 as verbally identified by QCA1.

SMAW welding of weld joint OBE14G-003 located on PCMK OBG 14E. Welder was identified as 216086. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2112-FCM-1 as verbally identified by QCA1.

SMAW welding of weld joints OBE14G-001, 002 located on PCMK OBG 14E. Welder was identified as 068859. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2112-TC-U4b-FCM-1 and WPS-B-P-2114-TC-U4b-FCM-1 as verbally identified by QCA1.

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



### Summary of Conversations:

As noted above.

### 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>	Goulet, George	Quality Assurance Inspector
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<b>Reviewed By:</b>	Riley, Ken	QA Reviewer
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