

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-025399**Date Inspected:** 24-Jul-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.

Vessel Zhenhua #19

**WELDING**

This QA Inspector randomly observed the following work in progress:

**Shielded Metal Arc Welding (SMAW)**

This QA Inspector observed the welding operation per the SMAW process on a weld joints identified as SEG3011C-246 located on the OBG Segment 13CE. The welder is identified as 216086. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. 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 SEG3011V-014 located on the OBG Segment 13CE. The welder is identified as 058102. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to comply with WPS-B-P-2113-FCM-1.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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This QA Inspector observed the welding operation per the SMAW process on a weld joints identified as SEG3011C-247 located on the OBG Segment 13CE. The welder is identified as 204730. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. 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 DP3126-001-101 located on the OBG Segment 13BW. The welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Ling. The welding variables recorded by QC appeared to comply with WPS-B-P-4314-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

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>  | Riley, Ken    | QA Reviewer                 |

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