

**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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023364**Date Inspected:** 13-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shen Fu Yoo**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 Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

BAY 5

Travelers Rail

**Magnetic Particle Testing**

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the 10% area previously tested by ZPMC MT personnel. This QA Inspector generated a TL-6028 MT report on this date. The weld designation numbers is as follows:

1.22TR1-002 from Joint No. 001 to 010 Green Tag No.007211

2.22TR3-004 from Joint No. 001 to 010 Green Tag No.007210

3.22TR3-003 from Joint No. 001 to 010 Green Tag No.007212

4.22TR4-004 from Joint No. 001 to 010 Green Tag No.007209

In-progress Welding

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## WELDING INSPECTION REPORT

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This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) with metallic backing for Cantilever Welding. The weld joint no. BK001-015-002 is in progress. The welder is identified as 217291. Welder was welding in 3G (Vertical) position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2231-Tc-U4c-F-1.

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) with metallic backing for Cantilever Welding. The weld joint no. BK001-018-001 is in progress. The welder is identified as 205390. Welder was welding in 3G (Vertical) position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2231-Tc-U4c-F-1.

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Cross Beam No.6 Welding. The weld joint no. FB-204-012-059 and 060 is in progress. The welder is identified as 215250. Welder was welding in 2G (Horizontal) position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2132-B-U2-F.

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Cross Beam No.6 Welding. The weld joint no. FB-205-012-025 and 026 is in progress. The welder is identified as 217562. Welder was welding in 2G (Horizontal) position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2132-B-U2-F.

The designated ZPMC CWI for the West Line is Mr. Li Yang and QC Mr. Zheng Zhi Wai and Mr. Chen Shi Ming.

Unless otherwise noted, all work observed on this date appeared to generally comply with 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>	Math,Manjunath	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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