

**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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015346**Date Inspected:** 01-Jul-2010**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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. 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 Segment**Summary of Items Observed:**

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

Ultrasonic Testing (UT) – Document No: 006095

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as Bike Path. The weld designations reviewed are as follows:

1. BK004A3-004-002, 010

Magnetic Particle Testing (MT) - Document No's: 006095

This QA inspector performed 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 are identified as Bike Bath. The weld designations reviewed are as follows:

1. BK004A3-004-002, 010

OBG Segment 11CE

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This QA inspector observed ZPMC qualified welding personnel identified as 049339 perform Shielded Metal Arc Welding (SMAW) Welding on OBG Segment 11CE, weld joint identified as OBE11D-046, 047. ZPMC QC is identified as Mr. Wang Wei Ming. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2214-Tc-U4b-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 044772 perform Shielded Metal Arc Welding (SMAW) Welding on OBG Segment 11CE, weld joint identified as OBE11E-028, 031 and 032. ZPMC QC is identified as Mr. Wang Wei Ming. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2214-Tc-U4b-FCM-1.

### Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 062904 perform Flux Cored Arc Welding (FCAW) welding on Bike Path, weld joint identified as BK006A8-001-023, 024, 035 and 036. ZPMC QC is identified as Mr. Zhou Cheng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 500909 perform Flux Cored Arc Welding (FCAW) welding on Bike Path, weld joint identified as BK006A6-001-023, 024, 035 and 036. ZPMC QC is identified as Mr. Zhou Cheng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2134.

### Outside Yard 11DE

This QA inspector observed ZPMC qualified welding personnel identified as 067589 perform SMAW Welding on OBG Segment, weld joint detail identified as SEG072\*-034. ZPMC QC is identified as Mr. Tang Ya Jun. The approved Welding Repair Report (WRR) is identified as B-WWR12769. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-4G (4F) Repair.

### Bay 16

This QA inspector observed ZPMC qualified welding personnel identified as 045270 perform Submerged Arc Welding (SAW) Welding on OBG Segment 13AW bottom plate, weld joint identified as BP3074-001-004. ZPMC QC is identified as Mr. Xia Chun Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-U3c-S-2.

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

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### 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 , who represents the Office of Structural Materials for your project.

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# WELDING INSPECTION REPORT

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<b>Inspected By:</b>	Kumar, Vibin	Quality Assurance Inspector
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<b>Reviewed By:</b>	McClendon, Timothy	QA Reviewer
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