

**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-017177**Date Inspected:** 18-Sep-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. Geng Wei  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** Yes No N/A  
**Approved WPS:** Yes No N/A  
**Delayed / Cancelled:** Yes No N/A

**Bridge No:** 34-0006**Component:** OBG Bike Path and 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.

Magnetic Particle Testing (MT) – NWIT Document No's: 006693- Side B

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 OBG Segment Corner Assembly. The weld designations reviewed are as follows:

1. CA3016C-163~190
2. CA3016A-066~093
3. CA3015C-163~190
4. CA3015B-163~190

Magnetic Particle Testing (MT) – NWIT Document No's: 006701

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 OBG Bike Path. The weld designations reviewed are as follows:

1. BK004A4-003-004,019,031,045,057,071,061,035

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2. BK004A3-003-002,021,030,045,056,017,041,061
3. BK004A6-003-023,035,036
4. BK004A8-003-024,035,037
5. BK004A5-003-005

### Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 067876 perform Flux Core Arc Welding (FCAW) Welding on the V-plate of OBG Segment 13AE, weld joint identified as VP3004-001- 013. ZPMC QC is identified as Mr. Guo Xing Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 066439 perform Flux Core Arc Welding (FCAW) Welding on the V-plate of OBG Segment 13AE, weld joint identified as VP3004-001- 026. ZPMC QC is identified as Mr. Guo Xing Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 202122 perform FCAW welding on Segment 13AW, weld joint identified SEG3013-005. ZPMC QC is identified as Mr. Xiu Chun Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-U2-F.

This QA inspector observed ZPMC qualified welding personnel identified as 044795 perform FCAW Welding on the K-plate of OBG Segment 13AE, weld joint identified as KP3005-001-004. ZPMC QC is identified as Mr. Guo Xing Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F, which is used as per Critical Welding Repair Report (CWR) B-CWR-1928.

### Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 058792 perform FCAW on Bike Path, weld joint identified as BK004A6-010-078. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2334-Tc-P4-F.

This QA inspector observed ZPMC qualified welding personnel identified as 208633 perform FCAW on Bike Path, weld joint identified as BK004A8-010-078. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2334-Tc-P4-F.

This QA inspector observed ZPMC qualified welding personnel identified as 058792 perform FCAW on Bike Path, weld joint identified as BK004A6-011-076 and 086. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

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This QA inspector observed ZPMC qualified welding personnel identified as 208632 perform FCAW on Bike Path, weld joint identified as BK004A8-011-076 and 082. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062707 perform FCAW on Bike Path, weld joint identified as BK004A3-013-025 and 026. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

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

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