

**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-017182**Date Inspected:** 24-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 & Mr. Xu Tao**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 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.

Ultrasonic Testing (UT) – NWIT Document No: 006752

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 OBG Segment at Bay 14. The weld designations reviewed are as follows:

1. CA3016-013, 025, 041, 061
2. CA3015-009, 029, 041, 045
3. SEG3004Z-092, 098, 099
4. SEG3004Y-087, 092

Ultrasonic Testing (UT) – NWIT Document No: 006757

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 OBG Segment at Bay 14. The weld designations reviewed are as follows:

1. SA3369 - 001, 005, 0011, 017, 023, 029, 031

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Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 044771 perform Submerged Arc Welding (SAW) Welding on OBG Segment 13AE, weld joint identified as SEG3007-003. ZPMC QC is identified as Mr. Zhong Guo Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 066763 perform Flux Core Arc Welding (FCAW) welding on vertical plate of OBG Segment 13AE, weld joint identified as VP3005-001-021. ZPMC QC is identified as Mr. Zhong Guo 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 067079 perform FCAW welding on vertical plate of OBG Segment 13CE, weld joint identified as VP3007-001-063. ZPMC QC is identified as Mr. Zhong Guo 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 044795 perform FCAW welding on vertical plate of OBG Segment 13AE, weld joint identified as VP3005-001-006. ZPMC QC is identified as Mr. Zhong Guo 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 ABF personnel performing Magnetic particle Testing (MT) on OBG Segment 13AE Bottom plate temporary attachment areas. The the bottom plates are identified as BP3030, BP3031, BP3032 and BP3033.

This QA inspector observed ZPMC personnel performing Ultrasonic Testing (UT) on OBG Segment 13AW Bottom plate (60mm thk) to Bottom plate (100mm thk) splice joint. The weld joint is identified as SEG3013AC-001. ZPMC QC is identified as Mr. Geng Wei. See the attached picture.

This QA inspector observed ZPMC qualified welding personnel identified as 045270 perform SAW Welding on OBG Segment 13BW, weld joint identified as SEG3014\*-004. ZPMC QC is identified as Mr. Zhong Guo Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 045280 perform FCAW welding on anchor plate of OBG Segment 14W, weld joint identified as AP3017-001-014, 015. ZPMC QC is identified as Mr. Li Jie. 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 040344 perform FCAW welding on anchor plate of OBG Segment 14W, weld joint identified as AP3020-001-024, 025. ZPMC QC is identified as Mr. Li Jie. The welding parameters as measured using QC's calibrated instruments appeared to be in general

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compliance with WPS -B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 201215 perform FCAW welding on anchor plate of OBG Segment 14W, weld joint identified as AP3018-001-041, 042. ZPMC QC is identified as Mr. Li Jie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2132.

Bay 16

This QA inspector observed ZPMC qualified welding personnel identified as 066751 perform FCAW welding on steel barrier of OBG Component, weld joint identified as W5-SB12-001-001~012. ZPMC QC is identified as Mr. Guo Pan. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2133.

This QA inspector observed ZPMC qualified welding personnel identified as 068765 perform FCAW welding on steel barrier of OBG Component, weld joint identified as W5-SB6A-001-017 and 018. ZPMC QC is identified as Mr. Guo Pan. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2133.

This QA inspector observed ZPMC qualified welding personnel identified as 068494 perform FCAW welding on steel barrier of OBG Component, weld joint identified as W5-SB11-001-097 and 111. ZPMC QC is identified as Mr. Guo Pan. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2333-Tc-P4-F.

OBG Segment 12CE

This QA inspector observed ZPMC qualified welding personnel identified as 043661 perform Shielded Metal Arc Welding (SMAW) Welding on the Lifting lug of OBG Segment 12CE, weld joint identified as SEG3006M-232 and 242. 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 043661 perform SMAW Welding on the Lifting lug of OBG Segment 12CE, weld joint identified as SEG3006M-236 and 246. 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-2232-Tc-U4b-F.

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

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## 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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**Inspected By:** Kumar,Vibin

Quality Assurance Inspector

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**Reviewed By:** McClendon,Timothy

QA Reviewer