

**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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017381**Date Inspected:** 05-Oct-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), Changxing Island **Location:** Shanghai, China**CWI Name:** 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 Components**Summary of Items Observed:**

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

BAY#19

FCAW welding of weld is identified as 3G-130 of BK004A8-012 for BK004A-012. The welder is identified as 062783. ZPMC QC is identified as Mr. Liu dao feng. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2333-Tc-P4-F.

FCAW welding of weld is identified as 2G-001 of BK004A6-012 for BK004A-012. The welder is identified as 062806. ZPMC QC is identified as Mr. Liu dao feng. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2332-Tc-P4-F.

FCAW welding of weld is identified as 2G-002 of BK004A8-002 for BK004A-002. The welder is identified as 062732. ZPMC QC is identified as Mr. Liu dao feng. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2332-Tc-P4-F.

FCAW welding of weld is identified as 3G-165 of BK004A6-002 for BK004A-002. The welder is identified as 062762. ZPMC QC is identified as Mr. Liu dao feng. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2333-Tc-P4-F.

FCAW welding of weld is identified as 1G-008 of BK004A1-003 for BK004A-003. The welder is identified as

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062755 & 208632. ZPMC QC is identified as Mr. Liu dao feng. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-B-U2-F.

SMAW welding of Critical repair plug weld is identified as 1G-014.015 of BK004A1-004 for BK004A-004. The welder is identified as 202338. ZPMC QC is identified as Mr.Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-1G(1F)-Repair and B-CWR1989. As per CWR ZPMC needs to do Post weld heat treatment (PWHT)

But because of 6mm in thickness of bottom cover plate ZPMC not performed PWHT.

This is informed to SMR Mr.Jim Simmons, after discussion he agreed to change CWR and no need to PWHT upon condition.

During in process visual inspection it is observed that ZPMC cannot perform welding of fillet Weld in following location where Bearing plate connects with stringer plate, this is because of No access to perform welding. The bike path is identified as BK004A-007. The weld no is identified as, and this is identical to all bike paths. For more information see attached photos.

BK004A3-007-035.

BK004A3-007-018.

This QA inspector performed (Re-MT) MT 15% of Heat straightened weld areas 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 as follows.

BK004A-008

BK004A3-008-025

BK004A4-008-014,015,067

BK004A6-012-150,151,155,041

BK004A8-012-121,125,041,029

BK004A-005

BK004A3-005-026,025

BK004A4-005-015,066,067

BK004A6-005-150,155,041

BK004A8-005-121,125,126,029

BK005A-001

BK005A3-001-0025,026

BK005A4-001-015,066,067

BK005A6-001-150,155,029

BK005A8-001-123,125,126,041

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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## Summary of Conversations:

No relevant Conversation.

## 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-15--0042-2372, who represents the Office of Structural Materials for your project.

**Inspected By:** Kumar,Chadra

Quality Assurance Inspector

**Reviewed By:** McClendon,Timothy

QA Reviewer