

**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-017382**Date Inspected:** 06-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-001 of BK004A8-005 for BK004A-005. 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-2333-Tc-P4-F.

FCAW welding of weld is identified as 2G-007 of BK006A8-002 for BK006A-002. The welder is identified as 062755. 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 BK006A6-002 for BK006A-002. The welder is identified as 062739. 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-002 of BK005A6-001 for BK005A-001. The welder is identified as 062808. 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 repair weld is identified as 2G-018 of SB020-088 for SB88E. The welder is identified as

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062783. ABF QC is identified as Mr. Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-2G-Repair and WR15694.

FCAW welding of repair weld is identified as 2G-055 of SB017-090 for SB90W The welder is identified as 062732. ABF QC is identified as Mr. Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-2G-Repair and WR15629.

ZPMC QC NDT UT personnel performing UT on suspender bracket and they found following rejection as follows.

|       | Total CJP | Reject | %  |
|-------|-----------|--------|----|
| SB90W | 17        | 14     | 82 |
| SB86W | 17        | 08     | 47 |
| SB88W | 17        | 12     | 70 |
| SB90E | 17        | 13     | 76 |
| SB88E | 17        | 15     | 88 |
| SB86E | 17        | 12     | 70 |
| Total | 102       | 74     | 72 |

Especially Weld no's are 004, 007 during repair work after back gouging ZPMC MT found lot of transverse cracks. ZPMC QC Mr.Xu tao said make CWR before go for further welding. All these welds are Non-SPCM. See the attached photos for more information.

This QA inspector performed MT 15% of 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-02

BK004A5-002-024,025,123,124,110,113,054,129,084,133

BK4SD1-002-005,006

This QA inspector performed UT 10% of weld areas 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 Bike path. The weld designations reviewed as follows

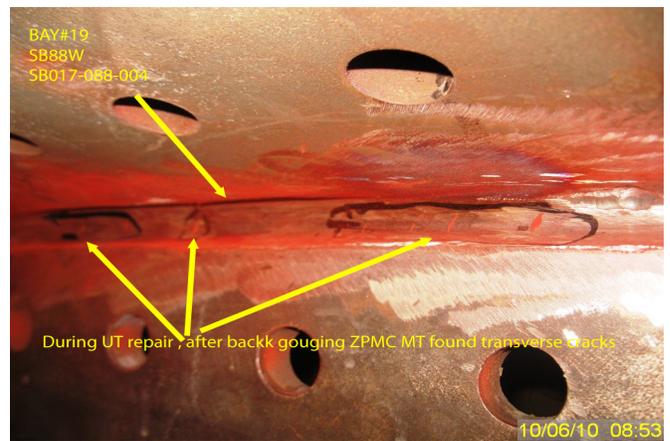
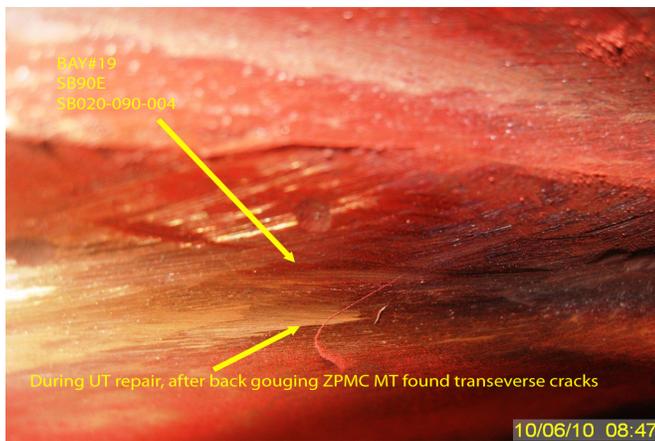
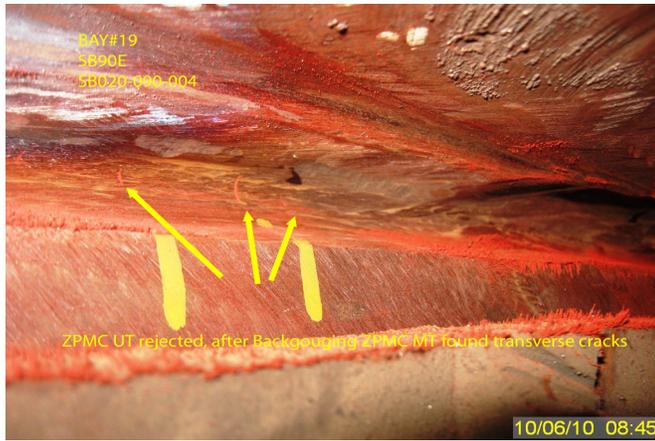
BK4SD1-012-05,06,18,21

BK004A1-012-006,008

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.

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

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