

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-017383**Date Inspected:** 07-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 BK004A8-010 for BK004A-010. 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-2333-Tc-P4-F.

FCAW welding of weld is identified as 2G-007 of BK005A8-001 for BK005A-001. 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 3G-001 of BK004A8-008 for BK004A-008. 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 1G-016 of BK004A2-007 for BK004A-007. The welder is identified as 062734. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2331-B-L1b-F-1.

FCAW welding of weld is identified as 1G-018 of BK004A2-009 for BK004A-009. The welder is identified as

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

062755. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2331-B-L1b-F-1

FCAW welding of critical repair weld is identified as 2G-004 of SB017-088 for SB88W. The welder is identified as 062752. 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 CWR2010.

Internal cleaning of bike path before install bottom cover plate of BK004A-012 is carried out along with CT QA inspectors Mr. Vibin, the locations where needs additional grinding and cleaning marked and repaired by ZPMC personnel.

This QA inspector performed (Re-MT) MT 15% of the 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.

BK006A-001

BK006A3-001-025,026.

BK006A4-001-014,015,067.

BK004A6-001-150,151,029,041.

BK006A8-001-123,125,126,029.

BK004A-001

BK004A3-001-025,026.

BK004A4-001-066.067.

BK006A6-001-151,155,041,121.

BK006A8-001-126,029,041,121.

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.

BK005A-001

BK005A2-001-016,018.

BK005A-005

BK004A5-005-014,015,111,024,123,035,044,127,116,064,129,130,084,132,133

BK4ASD1-005-005,006

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

---

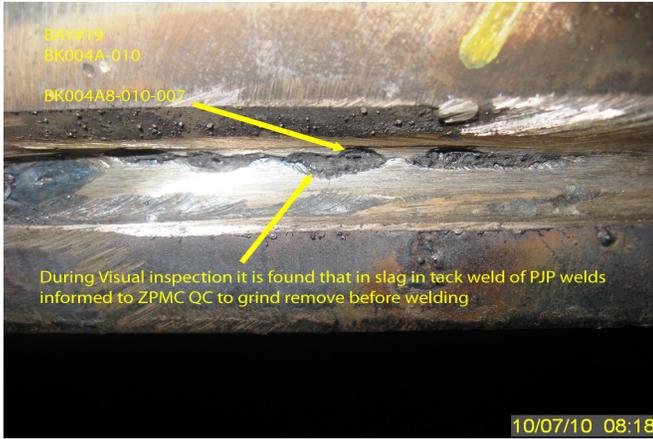
---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---



## 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