

**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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017407**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) Chanxing Island **Location:** Shanghai, China**CWI Name:** 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 Segment & Bike Path**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: 006876

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 Bike path. The weld designations reviewed are as follows:

1. BK5ASD1-001-005,006,018,021
2. BK005A1-001-006,008
3. BK005A3-001-005,009
4. BK005A5-001-004,007
5. BK4ASD1-005-005,006,018,021
6. BK004A1-005-006,008
7. BK004A3-005-005,009
8. BK004A5-005-004,007

Ultrasonic Testing (UT) – NWIT Document No: 006881

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

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 are as follows:

1. BK004A5-005-112,122,115,125,118,121,131

This QA Inspector observed the following work in progress:

Bay 19

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) repair welding of weld joint SB020-090-004 located on Suspender Bracket. Welder is identified as 062749. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS -345-FCAW-2G (2F)-Repair and which is used as per Critical Welding Repair Report (CWR) B-CWR-2010.

FCAW repair welding of weld joint SB017-088-004 located on Suspender Bracket. Welder is identified as 062752. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS -345-FCAW-2G (2F)-Repair and which is used as per Critical Welding Repair Report (CWR) B-CWR-2010.

FCAW repair welding of weld joint SB020-088-004 located on Suspender Bracket. Welder is identified as 0627683. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS -345-FCAW-2G (2F)-Repair and which is used as per Critical Welding Repair Report (CWR) B-CWR-2010.

FCAW welding of weld joint BK004ASD1-012-008 located on Bike Path. Welder is identified as 062734. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2332-Tc-P4-F.

FCAW welding of weld joint BK004ASD1-012-007 and 013 located on Bike Path. Welder is identified as 062734. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2333-Tc-P4-F.

FCAW welding of weld joint BK005A6-001-001 and 165 located on Bike Path. Welder is identified as 062808. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2333-Tc-P4-F.

FCAW welding of weld joint BK005A8-001-002, 007 located on Bike Path. Welder is identified as 062808. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2332-Tc-P4-F.

Bay 14

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

This QA Inspector observed the following work in progress:

Submerged Arc Welding (SAW) welding of weld joint SEG3015-002 located on the deck plate to deck plate splice joint of OBG Segment 13CW. Welder is identified as 250050. ZPMC Quality Control (QC) is identified as Mis. Lv Yun. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-L2c-S-2. See the attached photos.

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.

---

<b>Inspected By:</b>	Kumar,Vibin	Quality Assurance Inspector
----------------------	-------------	-----------------------------

---

<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer
---------------------	-------------------	-------------

---