

**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-017543**Date Inspected:** 26-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 Le Feng, Qiu Wen**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/TOWER**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 10, OBG BIKE PATH (NWIT # 07103)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an 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 Components. The weld designations reviewed are as follows.

BK004A3-025-002 (GREEN TAG NO. 13784)

BAY 10, OBG BIKE PATH (NWIT # 07111)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area 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 Components. The weld designations reviewed are as follows.

BK004A3-025-002 (GREEN TAG NO. 13784)

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

BAY 10, OBG BIKE PATH (NWIT # 07112)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area 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 Components. The weld designations reviewed are as follows.

BK008A1-001-009 (GREEN TAG NO. 13753)

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 11

OBG BIKE PATH

FCAW welding of weld joints 049 & 050 located on BK005A6-003.

Welder is identified as 053316. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

FCAW welding of weld joints 104 & 105 located on BK005A6-003.

Welder is identified as 053316. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joint 043 located on BK004A1-023.

Welder is identified as 040704. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4C-F.

PLUG WELDING OF BOTTOM COVER PLATE OF OBG BIKE PATH

FCAW welding of weld joints 019 & 020 located on BK004A2-018.

Welder is identified as 202340. ZPMC QC is identified as Mr. Shao Hai Lang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132-2-PLUG.

TOWER BRACKET

SMAW welding of weld joint 006A located on ND1-BRSA5-002.

Welders are identified as 041271 & 040690. ZPMC QC is identified as Mr. Zhao Mao Mao.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b.

TOWER BRACKET REPAIR (T-WR3732)

SMAW welding of weld joint 011B located on SD1-BRSA5-001.

Welder is identified as 040723. ZPMC QC is identified as Mr. Zhao Mao Mao.

The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G(2F)-REPAIR-1.

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:

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 Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Gaikwad,Umesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

---