

**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-017633**Date Inspected:** 24-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 11, OBG BIKE PATH (NWIT # 07082)

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 (SEE BELOW NOTE)

BK004A3-025-010

BK004A5-025-002, 008

NOTE: The weld joint BK004A3-025-002 is CJP weld joint with steel backing having 16mm thickness. During Ultrasonic inspection UT class "A" (+9 dB rating) rejectable indication found in first leg at the depth of approximately 12mm from face A. As per discussion with lead QA inspector ZPMC performed excavation on the repair location and CT QA (B220) witness the excavation step by step of 1mm~2mm depth but did not find any discontinuity on the marked location. So as per discussion with lead QA no Incident report generated for this issue.

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ZPMC is ready to renotify us for further inspection of this weld joint.

BAY 10, OBG BIKE PATH (GREEN TAG NO. 13750)

This QA inspector performed green tagging for the weld joints of OBG bike path (Step # 4). The members are identified as OBG Components.

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

BAY 11

OBG BIKE PATH, BOTTOM COVER PLATE, PLUG WELDING REPAIR (B-CWR2085, Rev. 0)

SMAW welding of plug weld joints 014, 015, 017, 019 & 020 located on BK004A2-021.

Welder is identified as 040724. ZPMC QC is identified as Mr. Shao Hai Lang.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G(1F)-REPAIR.

TOWER BRACKET

SMAW welding of weld joint 006B located on ND1-BRSA5-2.

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

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

TOWER ANGLE CONNECTION PLATE

SMAW welding of weld joint 001A located on ND1-SA4-68-143M-3.

Welder is identified as 040614. ZPMC QC is identified as Mr. Mao Bin Bin.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U5b-1.

BAY 10

OBG BIKE PATH, END PLATE REPAIR

SMAW welding of weld joint 044 located on BK004A1-027.

Welder is identified as 057258. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G(1F)-REPAIR.

Unless otherwise noted, all work observed on this date appeared to generally comply with 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 Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Gaikwad,Umesh

Quality Assurance Inspector

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**Reviewed By:** Carreon,Albert

QA Reviewer