

**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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017970**Date Inspected:** 29-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 and 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.

Bay 16

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint W5-SB25-001-094 and 095 located on OBG steel barrier. ZPMC Welder is identified as 066751. ZPMC Quality Control (QC) is identified as Mr. Guo Pan. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

FCAW welding of weld joint W5-SB25-001-079 and 080 located on OBG steel barrier. ZPMC Welder is identified as 066751. ZPMC Quality Control (QC) is identified as Mr. Guo Pan. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2133.

FCAW welding of weld joint W5-SB1-044-112~114 located on OBG steel barrier. ZPMC Welder is identified as 068856. ZPMC Quality Control (QC) is identified as Mr. Guo Pan. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

FCAW welding of weld joint W5-SB1-044-032~043 located on OBG steel barrier. ZPMC Welder is identified as 068856. ZPMC Quality Control (QC) is identified as Mr. Guo Pan. The welding variables recorded by QC

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appeared to comply with the Applicable WPS -B-T-2133.

FCAW welding of weld joint W5-SB1-054-075~078 located on OBG steel barrier. ZPMC Welder is identified as 070217. ZPMC Quality Control (QC) is identified as Mr. Guo Pan. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

FCAW welding of weld joint W5-SB1-054-063~074 located on OBG steel barrier. ZPMC Welder is identified as 070217. ZPMC Quality Control (QC) is identified as Mr. Guo Pan. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2133.

FCAW welding of weld joint W5-SB1-050-044~047 located on OBG steel barrier. ZPMC Welder is identified as 201074. ZPMC Quality Control (QC) is identified as Mr. Guo Pan. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

FCAW welding of weld joint W5-SB1-050-079 and 80 located on OBG steel barrier. ZPMC Welder is identified as 201074. ZPMC Quality Control (QC) is identified as Mr. Guo Pan. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2133.

This QA inspector observed ABF personnel performed Magnetic Particle Testing on steel barrier of OBG Component W5- SB8-002 and W5- SB3A-001

This QA inspector observed ZPMC personnel performed Ultrasonic Testing on steel barrier of OBG Component W5- SB5B-001.

Bay 19

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint BK004A5-006-064, 065, 084 and 085 located on OBG of Bike Path. Welder is identified as 062786. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2133.

FCAW welding of weld joint BK004A5-006-123, 124, 126 and 127 located on OBG of Bike Path. Welder is identified as 062786. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

ZPMC personnel performing heat straightening on bottom cover plate of OBG bike path member identified as BK004A-006-014~021. Distortion appeared to be caused by mishandling of the welding/material. ZPMC Quality Control (QC) inspector identified as Mr. Xu Tao was present to monitor the heat straightening process. The heat straightening appeared to comply with HSR1 (B) number 9501. See the attached pictures.

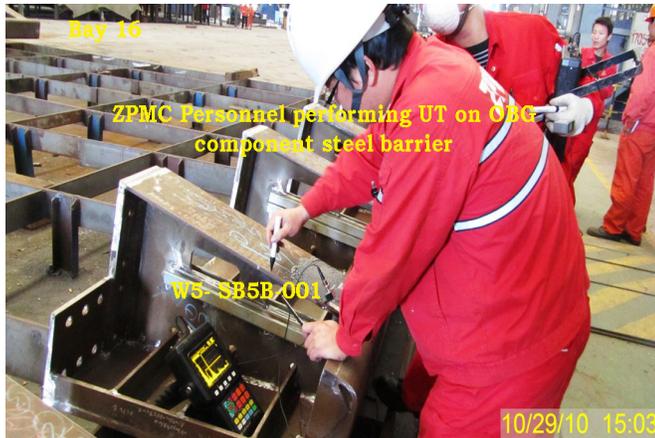
Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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## 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.

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**Inspected By:** Kumar,Vibin

Quality Assurance Inspector

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**Reviewed By:** McClendon,Timothy

QA Reviewer