

**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-018313**Date Inspected:** 25-Nov-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 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: 007491

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 Segment 12CE. The weld designations reviewed are as follows:

1. SEG3003A-005, 013

Bay 19

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of welds joint SB025-108-003 and 004 located on OBG Suspender Bracket SB108E. ZPMC Welder is identified as 062762. 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-2233-Tc-U4b-F

FCAW welding of welds joint SB025-108-003 and 004 located on OBG Suspender Bracket SB108W. ZPMC Welder is identified as 062762. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-U4b-F

FCAW welding of weld joint BK005A3-001-002, 003, 007 and 016 located on OBG Bike Path. ZPMC Welder is identified as 062732. 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-2331-Tc-P4-F.

FCAW welding of weld joint BK005A5-001-002, 003, 006 and 008 located on OBG Bike Path. ZPMC Welder is identified as 062808. 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-2331-Tc-P4-F.

FCAW welding of weld joint BK005A5-001-004 and 007 located on OBG Bike Path. ZPMC Welder is identified as 062761. 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-2333-Tc-P4-F.

FCAW welding of weld joint BK005ASD1-002-006 and 007 located on OBG Bike Path. ZPMC Welder is identified as 062808. 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-2232-B-U2-F.

FCAW welding of weld joint BK005A6-002-023, 024 located on OBG Bike Path. ZPMC Welder is identified as 260562. 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-2134.

FCAW welding of weld joint BK005A8-002-072, 073 located on OBG Bike Path. ZPMC Welder is identified as 062808. 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-2134.

Visual Inspection after Blast

OBG Segment 12BW

This QA Inspector performed a preliminary random visual inspection on OBG Segment 12BW, after the grit blast of the interior components top side of the deck plates, floor beams, side plates and corner assemblies of this segment panel point PP113 to P115. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

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

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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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:** Patel,Hiranch

QA Reviewer