

**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-020598**Date Inspected:** 18-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), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Mr. Huang Min and Lil Jia	<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>
<b>Inspected CWI report:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
		<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Bridge No:</b>	34-0006	<b>Component:</b>	BAY 6 and 8 OBG	

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A. DeArmond was present during the time noted above and conducted observations relative to the work being performed.

OBG BAY 8

This QA Inspector observed the following work in progress:

FCAW welding of fillet weld joint(s) located on OBG Bike Paths components identified as BK004A5-062 weld number(s) 056 and 057. Welder is identified as welder no. 042218. The welding variables recorded by ZPMC QC identified as Mr. Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2132-3.

FCAW welding of fillet weld joint(s) located on OBG Bike Paths components identified as BK004A3-063 weld number(s) 025, 026, 051, and 052. Welder is identified as welder no. 500405. The welding variables recorded by ZPMC QC identified as Mr. Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2132-3.

FCAW welding of fillet weld joint(s) located on OBG Bike Paths components identified as BK004A4-063 weld number(s) 014, 015, 040, 041, 066, and 067. Welder is identified as welder no. 054459. The welding variables recorded by ZPMC QC identified as Mr. Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2132-3.

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# WELDING INSPECTION REPORT

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OBG BAY 8

Ultrasonic Testing (UT)

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel, by the lot method testing procedure. This QA Inspector generated an UT report for this date. All components were as listed on NWIT notification no. 07404. The member(s) is/are identified as OBG Bike Path. The weld designations reviewed are as follows:

BK004A1-061, 044 BK4ASD1-061, 005, 006, 018, and 021 BK004A1-057, 043

OBG BAY 6

HEAT STRAIGHTENING

This QA Inspector observed the following work in progress:

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) member identified as Lift 14 Sub-Assembly DP3168B-001, weld joint(s) 098, 099, 103, 104, 106, 107, 109, 110, 112, 113, 115, 116, 123, 139, 137, 138, 139, and 140. Distortion appeared to be caused by welding of the material. ZPMC Quality Control (QC) inspector identified as Mr. Li Jia was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report HSR1 (B)-433 dated 11-10-2010.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

**Summary of Conversations:**

As mentioned above 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 Jim Devy 150-002-6784, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	DeArmond,Robert	Quality Assurance Inspector
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<b>Reviewed By:</b>	Riley,Ken	QA Reviewer
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