

**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-021761**Date Inspected:** 09-Mar-2011**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 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 Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#19

FCAW welding of weld is identified as 2F-039 of BK025A7-001 for BK0025A-001. The welder is identified as 062806. ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132-ESAB.

FCAW welding of weld is identified as 2F-057 of BK025A7-001 for BK0025A-001. The welder is identified as 062734. ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132-ESAB.

SMAW welding of fit-up tack weld is identified as 2G-043 of SA6529 of er bracket SA6529. The welder is identified as 259629. ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-P-2112.

ZPMC personnel start fit-up of cable bracket SA6529, SA6532 for Lift 12 (PP112, 114,116) centre plates to Edge and bottom plates is in progress as per approved drawing.

SMAW welding of critical repair plug weld is identified as 1G-014,015,017 of BK0004B2-001 for BK004B-001. The welder is identified as 259906. ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded

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by QC are appeared to comply with the WPS-345-SMAW-1G(1F)-Repair and Approved CWR2855.

FCAW welding of weld is identified as 2F-026 of SA6530 for SA6530. The welder is identified as 062749. ZPMC QC is identified as Mr.Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132-ESAB.

FCAW welding of weld is identified as 2G-040 of SA6529 for SA6529. The welder is identified as 062783. ZPMC QC is identified as Mr.Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2332-ESAB.

FCAW welding of weld is identified as 2F-079 of SA6529 for SA6529. The welder is identified as 062783. ZPMC QC is identified as Mr.Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132-ESAB.

During FCAW welding of SA6529, ZPMC personnel wrongly added a fillet weld other side of the PJP weld without approval from engineer. As per approved drawing this is only PJP weld is identified as SA6529-043. The length of the additionally added weld length in 150mm. this is informed to ABF QC and ZPMC CWI to inform CT engineer for further action.

ZPMC personnel performing FCAW welding of Bike path stringer plates is identified as BKX99A to flange BKX97 and stiffener plate BKX96J without having weld map of BK023-001, this is informed to ZPMC QC Mr. Guo xing hui he asked ZPMC QA and stopped their welding.

This QA inspector performed MT 15% of weld areas 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 Bike path. The weld designations reviewed as follows

BK005A2-002-014,015,017,019,020

BK005A2-002-016,018

BK004B-001-013,021,002,008

BK004B6-001-001,165,002,007

BK004B8-001-001,130,002,007

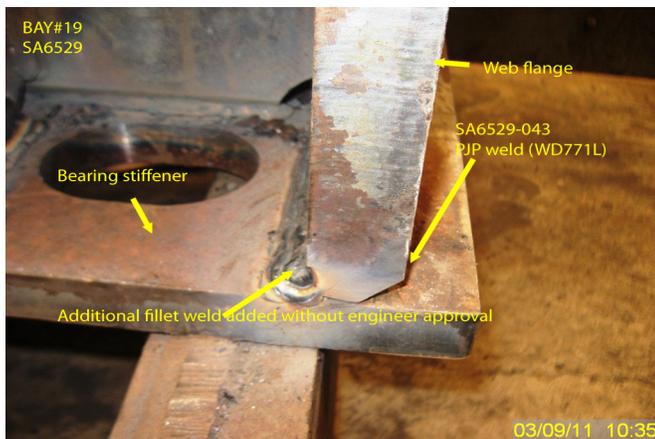
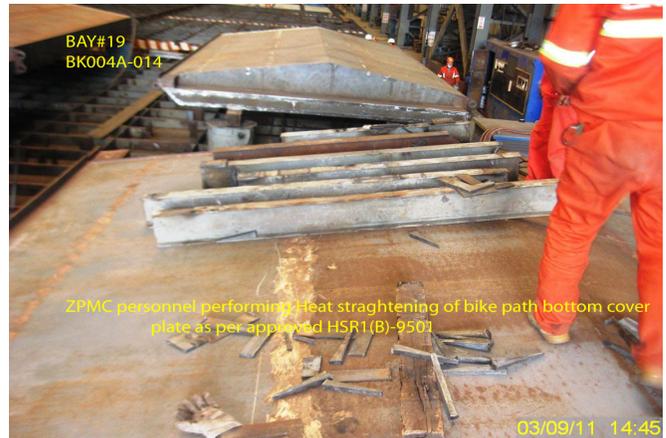
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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## Summary of Conversations:

No relevant Conversation.

## 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-15--0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Kumar,Chadra

Quality Assurance Inspector

**Reviewed By:** Patel,Hiranch

QA Reviewer

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