

**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-022823**Date Inspected:** 06-Apr-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:** Li yan hua**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 1G-080 of SA6031-001 for SA6031. The welder is identified as 062749. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-ESAB.

FCAW welding of Repair weld is identified as 3G-016 of SA6530-001 for SA6530. The welder is identified as 058792. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2233-ESAB-Repair and B-WR20597.

FCAW welding of Repair weld is identified as 3G-075 of SA6530 for SA6530. The welder is identified as 062749. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2233-ESAB-Repair and B-WR20597.

FCAW welding of critical repair welding (Buttering) of base metal web plate identified as X6551B of SA6531. The welder is identified as 062783. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-2G-ESAB-Repair and B-WR2872.

ZPMC personnel performing Heat straightening of MEP component which is connecting BKX12H to BKX12F of

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

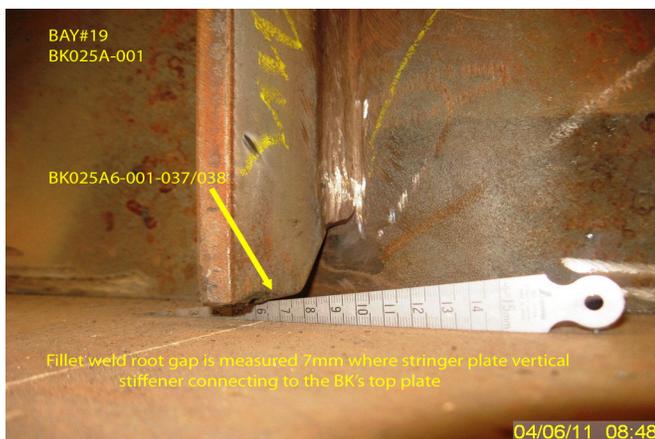
BK005A-002 in progress as per HSR1 (B)-10231.

ABF QC NDT MT personnel performing MT after back gouging of CJP weld is identified as SA6031-001-080 of SA6031 is in progress.

During in process visual inspection it is found that fit-up of stringer plates vertical stiffener is identified as BKX91K of stringer plates BKX90B and BKX89A is connecting the top plate of bike path BK0025A-001 , the fillet weld root gap is measured more than 5mm. the weld joint is identified as BK025A6-001-007/008, 067/068 and 037/038. This is marked near by the weld joint and informed to ZPMC QC Mr.Li ping for change of joint configuration approval from engineer.

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 Cable bracket. The weld designations reviewed as follows SA6529-002-101,104,108,102,106,105,109.

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



## Summary of Conversations:

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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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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<b>Inspected By:</b>	Kumar,Chadra	Quality Assurance Inspector
<b>Reviewed By:</b>	Patel,Hiranch	QA Reviewer

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