

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-026225**Date Inspected:** 02-Sep-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1200**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China

**CWI Name:** Guo Xing Hui  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** Yes No N/A  
**Approved WPS:** Yes No N/A  
**Delayed / Cancelled:** Yes No N/A

**Bridge No:** 34-0006**Component:** Bike Path, Traveler Rail**Summary of Items Observed:**

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

Bay 19

This QA Inspector observed the following work in progress for Bay 19.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Guo Xing Hui.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: Bike Path

PCMK: BK9003A1

Weld Number: 011, 012

Welder: 062749

WPS-B-T-2132-ESAB

Component: Bike Path

PCMK: BK9003A1

Weld Number: 004, 005

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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Welder: 062734

WPS-B-T-2132-ESAB

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 09954 from ZPMC for Bay 19. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as Bike Path. The weld designations reviewed are as follows.

BK9003A1-001-067

BK9003A6-001-284, 287, 291, 294

Bay 9

Heat straightening of Traveler Rail 3017TR1 under approved Heat Straightening procedure HSR 10426. The in process temperature was observed as 250°C. The ZPMC QC was identified as Zhu Zhung Jie. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 5 mm.

This QA Inspector observed the following work in progress for Bay 9.

ZPMC was using the Flux Cored Arc Welding(FCAW) process.

ZPMC QC is identified as Zhu Zhung Jie.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: Traveler Rail

PCMK: 3018TR2

Weld Number: 030

Welder: 059378

WPS-B-T-2231-ESAB

Component: Traveler Rail

PCMK: 3018TR2

Weld Number: 030

Welder: 203805

WPS-B-T-2231-ESAB

Component: Traveler Rail

PCMK: 3018TR2

Weld Number: 030

Welder: 059443

WPS-B-T-2231-ESAB

Component: Traveler Rail

PCMK: 3018TR2

Weld Number: 030

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

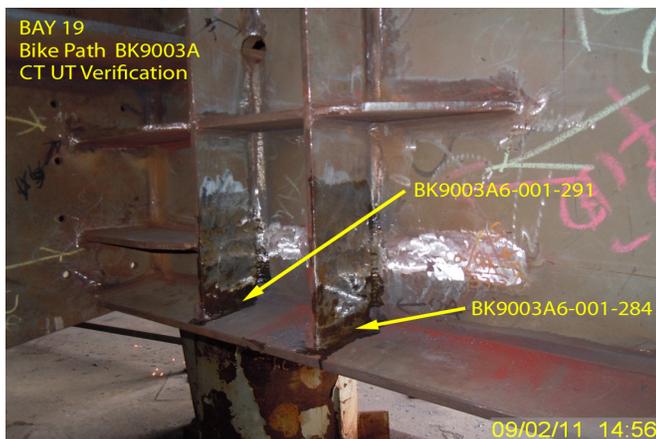
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Welder: 062265

WPS-B-T-2231-ESAB

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



## Summary of Conversations:

No relevant conversations.

## 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 150-0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Combs,Dennis

Quality Assurance Inspector

**Reviewed By:** Riley,Ken

QA Reviewer