

**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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013345**Date Inspected:** 23-Mar-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**CWI Name:** Zhou Cheng/Zhu Zhong Hai**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, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

**Bay#19**

During random in process inspection of Bike Path, BK4A, this QA inspector observed following issue. ZPMC personal performed cutting the parts of BK004A-003, BK004A-001 and BK004A-007. According to fit up procedure ZPMC personal remove the weld of the closure plate and interior diaphragm plates and longitudinal stiffeners from bike path. After removing the parts ZPMC personal performed grinding to make smooth surface. ZPMC personal will performed MT for surface cracks detection because of cutting the welds. The removed parts are identified as:

BKPL8- Closure plate,

BKX7P- Stiffener

BKX11E~G / BKX11EA~GA- Interior diaphragm plate.

For further information, please see the attached pictures below.

**Segment9AW**

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 member is identified as OBG Components. The weld designations reviewed are as follows:

-(SSD13-PP72-002)

# WELDING INSPECTION REPORT

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## Bay#08

FCAW welding of weld joint BKoo4A1-053-009 located on Bike Path BK4A. Welder is identified as 054460 (1G). ZPMC QC is identified as Zhang Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2331-B-U2-F.

## Bay#14

FCAW welding of weld joint Seg3006H-015, 016 located on Segment 12CW. Welder is identified as 201215 (3F). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233.

FCAW welding of weld joint Seg3006J-017, 016 located on Segment 12CW. Welder is identified as 204730 (3F). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233.

FCAW welding of weld joint Seg3006B-038~057 located on Segment 12CW. Welder is identified as 070212 (2F). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

SMAW welding of weld joint Seg3006M-007, 008 located on Segment 12CW. Welder is identified as 67571 (4G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint Seg3006N-007, 008 located on Segment 12CW. Welder is identified as 67572 (4G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

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



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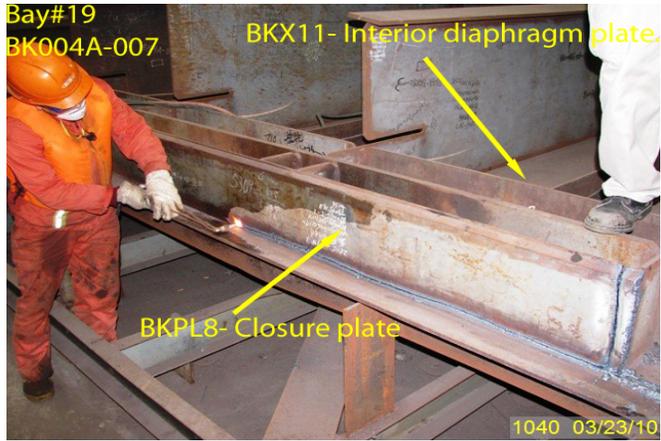
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# WELDING INSPECTION REPORT

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## 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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<b>Inspected By:</b>	Patel,Hiranch	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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