

**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-013351**Date Inspected:** 30-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

<b>CWI Name:</b>	Zhou Cheng/Geng Wei/Sun Bo	<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>	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, BK6A and BK5A this QA inspector observed following issue. ZPMC personal performed carbon arc gouging of the parts of BK006A-001, BK005A-001. 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 because of cutting the welds. For further information, please see the attached pictures below.

**Bay#8**

During random in process inspection of Bike Path, BK4A, this QA inspector observed magnetic particle testing was performed by ZPMC MT technician on the tack welds. The weld is fillet weld joining stringer plate to X7F stiffener. The tack welds were made by FCAW welding process. ZPMC MT technician discovered 18 tack welds having transverse crack. ZPMC personal removed all the cracked tack welds and re welded by SMAW welding process. The weld is identified as:  
BK004A6-054-112, 113- BKX9A stringer plate to X7F stiffener

For further information, please see the attached pictures below.

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## WELDING INSPECTION REPORT

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Bay#8

SAW welding of weld joint BK004A1-054-009 located on BK004A-54. Welder is identified as 251393(1G). ZPMC QC is identified as Zhang Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-L2c-S-2.

Bay#14

FCAW welding of weld joint Seg3002M-018, 031 located on Seg12BE. Welder is identified as 044801(2G). ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint Seg3002M-046 located on Seg12BE. Welder is identified as 058551(2G). ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint Seg3002M-073, 074 located on Seg12BE. Welder is identified as 055564(2G). ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint Seg3002N-018, 031 located on Seg12BE. Welder is identified as 050242(2G). ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint Seg3002N-046 located on Seg12BE. Welder is identified as 044824(2G). ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

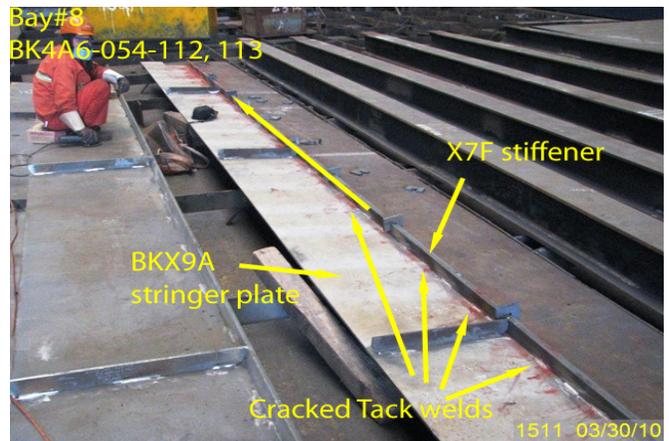
FCAW welding of weld joint Seg3002N-073, 074 located on Seg12BE. Welder is identified as 044795(2G). ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

SMAW welding of weld joint Seg3002F-007, 008 located on Seg12BE. Welder is identified as 200113(4G). ZPMC QC is identified as Zhong Guo Hui. 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.

# 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.

**Inspected By:** Patel, Hiranch

Quality Assurance Inspector

**Reviewed By:** McClendon, Timothy

QA Reviewer