

**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-017057**Date Inspected:** 27-Sep-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:** Yu Dong Ping, Liu Yang**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/TOWER**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 11, OBG BIKE PATH (NWIT # 06779)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated UT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

BK004A1-031-009

BK007A1-001-009

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 10

Tower Splice Plate (T-WR3550)

During random in process inspection this QA inspector observed that ZPMC personnel performing buttering on the edge of splice plate SA5-5, SA5-6, SA5-10, SA5-11 of tower for 146M elevation level by using Shielded

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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Metal Arc Welding (SMAW) process. Welders are identified as 050289, 050038, 056364 and 052930. ZPMC QC is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G(2F)-REPAIR.

### BIKE PATH

FCAW welding of weld joint 036 located on BK004A5-029.

Welder is identified as 057266. ZPMC QC is identified as Mr. Yuan Hui Gang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joint 042 located on BK004A5-029.

Welder is identified as 057180. ZPMC QC is identified as Mr. Yuan Hui Gang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joint 056 located on BK004A5-029.

Welder is identified as 054069. ZPMC QC is identified as Mr. Yuan Hui Gang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joint 062 located on BK004A5-029.

Welder is identified as 053116. ZPMC QC is identified as Mr. Yuan Hui Gang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joint 009(Repair) located on BK004A1-030.

Welder is identified as 053869. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G(1F)-REPAIR.

### NORTH TOWER LIFT 5(T-WR3671)

SMAW welding of weld joint 014A/B(Repair) located on NSD1-TL5-3F-F.

Welders are identified as 057258 and 052493. ZPMC QC is identified as Mr. Li Peng Fei.

The welding variables recorded by QC appeared to comply with WPS-385-SMAW-3G(3F)-REPAIR.

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

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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## Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

## 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 : 15000422372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Gaikwad,Umesh

Quality Assurance Inspector

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**Reviewed By:** Carreon,Albert

QA Reviewer