

**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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017059**Date Inspected:** 29-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, Qiu Wen**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 END DIAPHRAGM PLATE (NWIT # 06797)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

BK004A8-017-104, 106, 108, 053, 055, 059

BK004A6-017-104, 106, 108, 054, 056, 060

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

BAY 10

TOWER FACADE SUBASSEMBLY

SMAW welding of weld joint 007 located on SD1-SFSA3-24-1.

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Welder is identified as 057220. ZPMC QC is identified as Mr. Wang Hao.  
The welding variables recorded by QC appeared to comply with WPS-B-P-2114.

FCAW welding of weld joint 009 located on SD1-SFSA3-24-1.  
Welder is identified as 053869. ZPMC QC is identified as Mr. Wang Hao.  
The welding variables recorded by QC appeared to comply with WPS-B-t-2132.

SMAW welding of weld joint 002 located on SD1-SFSA3-26.  
Welder is identified as 056364. ZPMC QC is identified as Mr. Wang Hao.  
The welding variables recorded by QC appeared to comply with WPS-B-P-2114.

## OBG BIKE PATH BK004A-032

During random in process inspection this QA inspector observed that ZPMC personnel performing fit up of the stringer plate to deck plate of above mentioned bike path. The welders are identified as 061398 and 054547. ZPMC QC is identified as Mr. Yuan Hui Gang. The welding variables recorded by QC appeared to comply with WPS-B-P 2112. The members are identified as OBG components.

## OBG BIKE PATH BK004A-025

During random in process inspection this QA inspector observed that ZPMC personnel performing surface repair on the weld joints of the stringer plate to deck plate of above mentioned bike path. The welder is identified as 053829. ZPMC QC is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G(2F)-REPAIR. The members are identified as OBG components.

## NORTH TOWER LIFT 5, SKIN A

SMAW welding of weld joint 017A/B(Repair) located on NSD1-TL5-3B-F.  
Welder is identified as 040582. 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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**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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<b>Inspected By:</b>	Gaikwad,Umesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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