

**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-017115**Date Inspected:** 15-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:** Gong Wai**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 COMPONENT**Summary of Items Observed:**

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

In process Inspection

Out Side Yard

This QA Inspector observed the following work in progress:

SMAW in the 4F position for the OBG segment 12BE, weld No. CA6502B-051/052. The welder is identified as #043661. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2114-FCM-1.

Bay#14

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG segment 13BE, weld No. KP3008-001-008. The welder is identified as #067079. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4B-F.

FCAW in the 2G position for the OBG segment 13AE, weld No. KP3002-001-002. The welder is identified as #066236. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4B-F.

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 4 )

---

---

Bay#16

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG segment 14E, weld No. BP3101-001-002. The welder is identified as #201917. ZPMC QC is identified as Mr. Guo Pan. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

Magnetic Particle Testing (MPT) for Bike Path

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for OBG bike path weld. This QA inspector generated a (MT) report for this date. This area was previously tested and accepted by ZPMC QC MT technicians.

The Weld Designations are as follows

BK004A4-011-004,005,030,031

BK004A4-011-023,024,075,076

BK004A6-011-023,024,035,036

BK004A8-011-023,024,035,036

BK004A4-008-060,061,049,050

BK004A8-008-023,024,035

BK004A6-008-023,024,035,036

BK004A4-008-019,020,056,057

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on OBG Bike Path BK004A-008, this Quality Assurance (QA) Inspector discovered the following issues that One (1) Transverse Crack like indication measuring approximately 5 mm in length. The Weld number is identified as BK004A8-008-036. The indication is clearly marked on the material near the weld. The "Y" distance from Side Plate (BKPL3A) is 1760mm. The weld is designated as Non Seismic Performance Critical Material (Non SPCM). The weld is fillet weld joining between 25mm Center Plate (X11K) to Bearing Plate (BKPL7). OBG Bike Path BK004A-008 is located in Bay#19. The Notice of Witness Inspection Number (NWIT) is 06674. The indication is located within an area that has been previously tested by ZPMC Quality Control (QC) personnel.

This QA Inspector generated an incident report for this date.

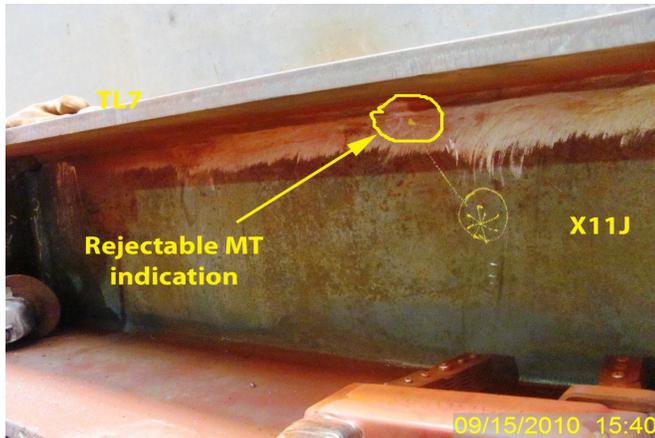
Visual Inspection after Blast at 11BE

This Quality Assurance (QA) Inspector performed random visual inspection of OBG segment 11BE internal Edge panel, deck panel and floor beam surfaces after grit blasting in. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

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

# WELDING INSPECTION REPORT

( Continued Page 3 of 4 )



## 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.

---

---

# WELDING INSPECTION REPORT

*( Continued Page 4 of 4 )*

---

---

<b>Inspected By:</b>	Bera,Subhasis	Quality Assurance Inspector
----------------------	---------------	-----------------------------

<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer
---------------------	------------------	-------------