

**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-017149**Date Inspected:** 22-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:** Li Ming Yang  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** 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**

FCAW welding of weld joint BK004A6-003-061, 065, 076 located on Bike Path BK004A-003. Welder is identified as 062755 (3G). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2333-Tc-P4-F.

FCAW welding of weld joint BK004A6-003-082, 086 located on Bike Path BK004A-003. Welder is identified as 062755 (3G). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2333-Tc-P4-F.

FCAW welding of weld joint BK004A8-003-096, 102, 086 located on Bike Path BK004A-003. Welder is identified as 058792 (3G). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2333-Tc-P4-F.

FCAW welding of weld joint BK004A8-003-092, 076, 082 located on Bike Path BK004A-003. Welder is identified as 058792 (3G). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2333-Tc-P4-F.

FCAW welding of weld joint BK004A6-002-165 located on Bike Path BK004A-002. Welder is identified as

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062808 (3G). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint BK004A6-002-164 located on Bike Path BK004A-002. Welder is identified as 062808 (2G). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

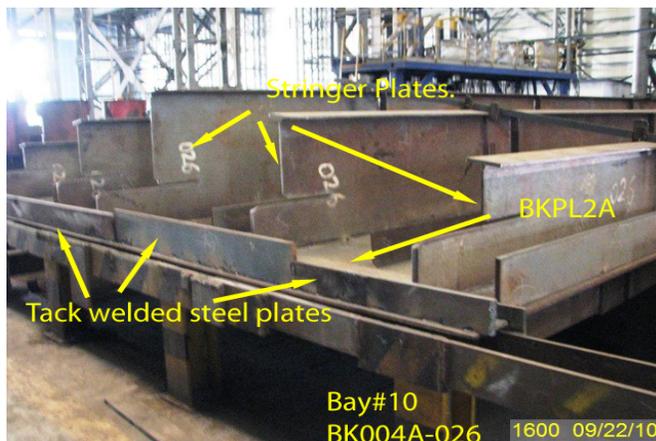
## Bay#10

During random visual inspection of the bike path component, this QA inspector observed the following issue.

- Temporary plates (attachments) were tack welded at the end of the Top Plate.
- The bike path is identified as BK004A-026 and BK004A-027.
- The Top Plate is identified as BKPL1A and BKPL2A.
- The material used for temporary plates are not identified.
- ZPMC QC personnel response for the use of temporary plates is to avoid distortion in the Top Plate during welding of the Stringer Plates to the Top Plate.
- Temporary tack welded plates are not shown in the approved shop drawings.
- ZPMC personnel required to perform Magnetic Particle Testing on the welded location after removing the temporary plates.

For further information, Please see attached pictures.

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



## 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
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<b>Reviewed By:</b>	McClendon, Timothy	QA Reviewer
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