

**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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017158**Date Inspected:** 06-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**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 Segments**Summary of Items Observed:**

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

Ultrasonic Testing (UT) – Document No: 006595

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 11DE repaired areas. The weld designations reviewed are as follows:

1. SEG072A-002
2. SEG072A-008
3. SEG072B-055
4. EP160-001-028

Magnetic Particle Testing (MT) - Document No's: 006592

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG SBDP. The weld designations reviewed are as follows:

1. SBDP-P3-034-001, 002

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2. SBDP-P3-035-001, 002
3. SBDP-P3-036-001, 002
4. SBDP-P3-037-001, 002
5. SBDP-P3-038-001, 002
6. SBDP-P3-039-001, 002
7. SBDP-P3-040-001, 002
8. SBDP-P3-041-001, 002
9. SBDP-P3-042-001, 002
10. SBDP-P3-043-001, 002
11. SBDP-P3-044-001, 002
12. SBDP-P3-045-001, 002
13. SBDP-P3-046-001, 002
14. SBDP-P3-047-001, 002
15. SBDP-P3-048-001, 002
16. SBDP-P3-049-001, 002
17. SBDP-P3-050-001, 002
18. SBDP-P3-051-001, 002
19. SBDP-P3-052-001, 002
20. SBDP-P3-053-001, 002
21. SBDP-P3-054-001, 002

Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 062814 perform Shielded Metal Arc Welding (SMAW) welding on suspender bracket, repair weld joint identified as SB020-080-004. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair, which is used as per Critical Welding Repair Report (CWR) B-WR1882.

This QA observed ZPMC personnel performing heat straightening on OBG Bike Path BK004A-004 deck panel to deck panel CJP weld, which is used as per HSR(1)-5725. The joining deck panels are identified as BKPL1 and BKPL2. The joint number is identified as BK004A-004-009. See the attached pictures.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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 , who represents the Office of Structural Materials for your project.

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**Inspected By:** Kumar,Vibin

Quality Assurance Inspector

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**Reviewed By:** McClendon,Timothy

QA Reviewer