

**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-017169**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:** Mr. Xu Tao/Lv Li Qing**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**Summary of Items Observed:**

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

Magnetic Particle Testing:-

Bay #19

This QA inspector performed Magnetic Particle Testing (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 member is identified as Bike Path. The weld designation reviewed is as follows:

BK004A8-011-076,082,096,102,080,100,078,098,072,073

BK004A5-011-003,008

BK004A3-011-058,059

BK004A2-011-007,011

BK004A4-011-021,022,047,048

In process Inspection

Bay #19

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

This QA Inspector observed the following work in progress:

FCAW in the 3F position for the Bike Path, weld No: BK004A3-006-043/044. The welder is identified as #062755. ZPMC QC is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2133.

This QA Inspector observed the following work in progress:

FCAW in the 4F position for the Bike Path, weld No: BK004A3-007-046. The welder is identified as #208641. ZPMC QC is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2134.

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the Suspender Bracket, weld No: SB017-086-043. The welder is identified as #062786. ABF QA is identified as Mr. Peng Wen jun. The welding variables recorded by QC appear to comply with WPS-B-T-2232-TC-U4b-F. Please see the attached picture.

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the Suspender Bracket, weld No: SB017-090-007. The welder is identified as #062761. ABF QA is identified as Mr. Peng Wen jun. The welding variables recorded by QC appear to comply with WPS-B-T-2232-TC-U4b-F.

Bay #14

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG Segment 13AE, weld No: VP3007-001-011. The welder is identified as #067079. ZPMC QC is identified as Mr. Zhong Guo Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2232-TC-U4b-F. Please see the attached picture.

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG Segment 13BE, weld No: VP3004-001-022. The welder is identified as #066439. ZPMC QC is identified as Mr. Zhong Guo Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2232-TC-U4b-F.

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG Segment 13BE, weld No: VP3005-001-008. The welder is identified as #044795. ZPMC CWI is identified as Mr. Lv Li Qing. The welding variables recorded by QC appear to comply with WPS-B-T-2232-TC-U4b-F.

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 13BW Deck Panel, weld No: SEG3014-007. The welder is identified as #045270. ZPMC QC is identified as Mr. Li Jie. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2C-S-2. Please see the attached picture.

Visual Inspection after Blast

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

## Segment 11CW

This QA Inspector performed a preliminary random visual inspection after the grit blast of the Interior components of the Side panels and Bottom panel of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

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



### Summary of Conversations:

No Relevant Conversation.

### 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.

---

<b>Inspected By:</b>	Pillai,Pandaram	Quality Assurance Inspector
----------------------	-----------------	-----------------------------

---

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