

**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-017187**Date Inspected:** 26-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 Bike Path and Segment**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.

Magnetic Particle Testing (MT) - Document No's: 006771

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 Segment Bike Path. The weld designations reviewed are as follows:

1. BK004A8-005-076,086,096,102,090,078,098,073
2. BK004A5-005-008,005
3. BK004A3-005-019,032
4. BK004A2-005-001,004
5. BK004A3-005-065,100,067,101,068,102,069,103,070,104,071,105
6. BK004A4-005-080,100,083,102,082,101,085,103,086,104,087,105
7. BK005A4-001-006,033,059
8. BK005A8-001-072,073,102,092,070,088,063,153,125
9. BK005A5-001-003,006,008
10. BK005A2-001-003,005
11. BK005A6-001-004,006,009,011,003,005,008,010,025,027,037,039
12. BK005A8-001-004,006,009,011,025,027,037,039

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### Bay 16

This QA inspector observed ZPMC qualified welding personnel identified as 020009 perform Flux Core Arc Welding (FCAW) welding on steel barrier of OBG Component, weld joint identified as W5-SB12-001-013, 014, 015 and 016. ZPMC QC is identified as Mr. Ma Qian Li. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 066746 perform FCAW welding on steel barrier of OBG Component, weld joint identified as W5-SB06-001-013, 014, 015 and 016. ZPMC QC is identified as Mr. Ma Qian Li. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 067876 perform FCAW welding on steel barrier of OBG Component, weld joint identified as W5-SB08-001-020, 021, 022, 023, 024 and 025. ZPMC QC is identified as Mr. Ma Qian Li. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2132.

### Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 058792 perform Flux Core Arc Welding (FCAW) welding on Suspender bracket, weld joint identified as SB021-94-007. ABF QC is identified as Mr. Peng Wen Jun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062749 perform FCAW welding on Suspender bracket, weld joint identified as SB018-94-007. ABF QC is identified as Mr. Peng Wen Jun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062755 perform FCAW welding on Bike path, weld joint identified as BK004A8-014-019, 020, 021 and 022. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2133.

This QA inspector observed ZPMC qualified welding personnel identified as 062783 perform FCAW welding on Bike path, weld joint identified as BK004A8-014-041 and 042. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 062762 perform FCAW welding on Bike path, weld joint identified as BK004A6-014-019, 020, 115 and 116. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2133.

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This QA inspector observed ZPMC qualified welding personnel identified as 062755 perform FCAW welding on Bike path, weld joint identified as BK004A7-014-123 and 124. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2133.

Visual Inspection after Blast

OBG Segment 11CE

This QA Inspector performed a preliminary random visual inspection on OBG Segment 11CE, after the grit blast of the interior components of the deck panel, floor beams and corner assemblies 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. See the attaches pictures.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



### 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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<b>Inspected By:</b>	Kumar,Vibin	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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