

**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-017371**Date Inspected:** 23-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:** 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 Components**Summary of Items Observed:**

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

BAY#19

FCAW welding of weld is identified as 1G-005 of SB017-086 for SB86W. The welder is identified as 062761. ABF QC is identified as Mr. Peng wen jun . The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-Tc-U4b-F.

FCAW welding of weld is identified as 1G-005 of SB017-086 for SB86W. The welder is identified as 062786. ABF QC is identified as Mr. Peng wen jun . The welding variables recorded by QC are appeared to comply with the WPS-B-T-22321-Tc-U4b-F.

FCAW welding of weld is identified as 1G-005 of SB017-088 for SB88W. The welder is identified as 062752. ABF QC is identified as Mr. Peng wen jun . The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-Tc-U4b-F.

FCAW welding of weld is identified as 4F-046 of BK004A3-007 for BK004A-007. The welder is identified as 208641. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2134-F.

This QA inspector performed MT 15% of weld areas previously tested and accepted by ZPMC Quality Control

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## WELDING INSPECTION REPORT

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personnel. This QA inspector generated an MT report for this date. The members are identified as OBG Bike path. The weld designations reviewed as follows.

BK004A-010

BK004A3-010-019,044

BK004A4-010-006,032

BK004A8-010-082,102,080,090,100,078,088,073,072

BK004A8-010-092, Transverse crack found

BK004A-012

BK004A3-012-020

BK004A4-012-006,007,058

BK004A8-012-061,065,082,092,102,063,080,090,100,070,078,072,073

This QA inspector performed VT of welds areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated a VT report for this date. The members are identified as OBG Bike path. The weld designations reviewed as follows.

Bk004A-010

BK004A3-010-065,100,067,101,068,102,069,103,070,104,071,105.

BK004A4-010-080,100,083,102,082,101,085,103,086,104,087,105.

BK004A-012

BK004A6-012-004,006,009,011,003,005,008,010,025,027,037,039.

BK004A8-012-004,006,009,011,025,027,037,039.

During the Quality Assurance (QA) Magnetic particle Testing (MT) review of welds located on OBG Bike path BK004A-010, this Quality Assurance Inspector (QA) discovered the following issue:

- One transverse crack that measured approximately 10mm in length.
- The weld is identified as BK004A8-010-092.

For more information please see the Incident report

04-0120F4\_TL-15\_B247\_09-23-10\_BK004A-010\_ Missed MT indication

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

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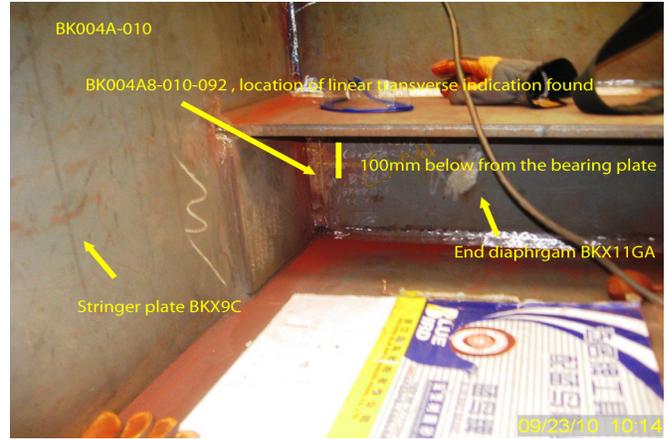
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# WELDING INSPECTION REPORT

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## 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-15--0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Kumar, Chadra

Quality Assurance Inspector

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**Reviewed By:** McClendon, Timothy

QA Reviewer