

**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-017539**Date Inspected:** 12-Oct-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:** Qiu Wen**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 Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#10

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#10

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 17 located on Bike Path BK004A6 – 030. Welder is identified as 057180. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 66 located on Bike Path BK004A4– 031. Welder is identified as 040302. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 43 located on Bike Path BK004A6 – 030. Welder is identified as 053869. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

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Weld joint # 50 located on Bike Path BK004A7- 031. Welder is identified as 052075. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

BAY#11

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 006927

Visual Inspection Testing (VT)

This QA inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as OBG Component. The identified component designations reviewed are as follows:

BIKE PATH

BK004A6 – 021 – 5; 8; 10; 27; 37; 39; 153; 156; 157

BK004A4 – 021 – 50; 60; 61; 75; 76

BK004A3 – 021 – 35; 41; 42; 60; 61

BK004A8 – 021 – 8; 10; 23; 24; 28; 35; 36; 37; 38; 39; 124; 127; 128; 129

Magnetic Particle Testing (MT)

This QA inspector performed MT 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 TOWER Component. The weld designation reviewed as follows:

BIKE PATH

BK004A6 – 021 – 5; 8; 10; 27; 37; 39; 153; 156; 157

BK004A4 – 021 – 50; 60; 61; 75; 76

BK004A3 – 021 – 35; 41; 42; 60; 61

BK004A8 – 021 – 8; 10; 23; 24; 28; 35; 36; 37; 38; 39; 124; 127; 128; 129

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 044 located on Bike Path BK004A1 – 019. Welder is identified as 040759. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

Weld joint # 044 located on Bike Path BK004A1 – 019. Welder is identified as 040704. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

Shielded Metal Arc Welding (SMAW):

Weld joint # 26 located on Bike Path BK004A8 – 018. Welder is identified as 040690. ZPMC Quality Control (QC) Inspector is identified as Shang hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113.

Surface Welding by Shielded Metal Arc Welding (SMAW):

Surface welding / buttering being performed as per the weld repair report B-WR14884 located on bike path stringer plate, BK004A – 021 – 10A. Welder is identified as 040655. ZPMC Quality Control (QC) Inspector is

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identified as Shang Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 3G (3F) – Repair. (See attached photo)

BAY#12

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#12

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 05 located on U-rib splice plate SA3111C – 024. Welder is identified as 059403. ZPMC Quality Control (QC) Inspector is identified as Zhao Jian Hang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4b – F.

Weld joint # 06 located on U-rib splice plate SA3111D – 026. Welder is identified as 059443. ZPMC Quality Control (QC) Inspector is identified as Zhao Jian Hang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4b – F.

Weld joint # 05 located on U-rib splice plate SA3111C – 021. Welder is identified as 059403. ZPMC Quality Control (QC) Inspector is identified as Zhao Jian Hang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4b – F. (See attached photo)

Weld joint # 06 located on U-rib splice plate SA3111D – 030. Welder is identified as 059443. ZPMC Quality Control (QC) Inspector is identified as Zhao Jian Hang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4b – F.

Unless otherwise noted, all work 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 Michael Ng - 15921845703, who represents the Office of Structural Materials for

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your project.

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<b>Inspected By:</b>	Kumar,Sandeep	Quality Assurance Inspector
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<b>Reviewed By:</b>	Clifford,William	QA Reviewer
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