

**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-017554**Date Inspected:** 07-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:** Mr. Yu Dong Ping**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:** Tower**Summary of Items Observed:**

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

Heavy Dock #Tower Trial assembly

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 2, 3- located on Manhole cover plate hinges of North shaft, Lift 3 –DA3-5. Welder is identified as 040365. ZPMC Quality Control Inspector (QC) is identified as Fu Wei min. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

Weld joint # 3, 4- located on Manhole cover plate hinges of South shaft, Lift 3 –DA3-5. Welder is identified as 040365. ZPMC Quality Control Inspector (QC) is identified as Fu Wei min. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

This QA inspector, performed following measurement readings

East shaft, Lift 3 &4 – located on Heavy Dock, Tower trial assembly.

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Misalignment, Vertical and Horizontal Flatness, Gap measurements of exterior splice plates of Skin A, B, C, D and E and Distance from edge of the splice plate to corner of the skin . This measurement of gap and misalignment was carried out along with QA Inspector Mr. Sandeep Kumar whose lot no. is B 227. All the reading taken has handed over to Task Leader.

West shaft, Lift 3 &4 – located on Heavy Dock, Tower trial assembly.

Misalignment, Vertical and Horizontal Flatness, Gap measurements of exterior splice plates of Skin A, B, C, D and E and Distance from edge of the splice plate to corner of the skin . This measurement of gap and misalignment was carried out along with QA Inspector Mr. Sandeep Kumar whose lot no. is B 227. All the reading taken has handed over to Task Leader.

South shaft, Lift 3 &4 – located on Heavy Dock, Tower trial assembly.

Misalignment, Vertical and Horizontal Flatness, Gap measurements of exterior splice plates of Skin A, B, C, D and E and Distance from edge of the splice plate to corner of the skin . This measurement of gap and misalignment was carried out along with QA Inspector Mr. Sandeep Kumar whose lot no. is B 227. All the reading taken has handed over to Task Leader.

North shaft, Lift 3 &4 – located on Heavy Dock, Tower trial assembly.

Misalignment, Vertical and Horizontal Flatness, Gap measurements of exterior splice plates of Skin A, B, C, D and E and Distance from edge of the splice plate to corner of the skin . This measurement of gap and misalignment was carried out along with QA Inspector Mr. Sandeep Kumar whose lot no. is B 227. All the reading taken has handed over to Task Leader.

This QA inspector, performed following measurement readings

East, North and West Shaft, Interior splices

Misalignment, Skin A, & D in East shaft Lift 3 & 4, Skin C, & D in North shaft Lift 3 & 4, Skin D in West shaft Lift 3 & 4. This measurement of misalignment have been informed to Task Leader.

Bay #11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 14B, located on Lift-5 Bracket SD1 – BRSA5 – 1. Welder is identified as 046769. ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – Tc – U4b.

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Weld joint # 10B, located on Lift-5 Bracket SD1 – BRSA5 – 1. Welder is identified as 041271. ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – Tc – U4b.

Weld joint # 7A, located on Lift-5 Bracket SD1 – BRSA5 – 1. Welder is identified as 040614. ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – Tc – U4b.

Weld joint # 11A, located on Lift-5 Bracket SD1 – BRSA5 – 1. Welder is identified as 040610. ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – Tc – U4b.

Fluxcored Arc Welding (FCAW):

ORTHOTROPIC BOX GIRDER (OBG)

Weld joint # 10, located on Bike Path BK004A3– 021. Welder is identified as 053316. ZPMC Quality Control Inspector (QC) is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231- TC-U4C-F.

Weld joint # 002, located on Bike Path BK004A5– 021. Welder is identified as 040704. ZPMC Quality Control Inspector (QC) is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231- TC-U4C-F.

Weld joint # 13,14, located on Bike Path BK005B– 004. Welder is identified as 054460. ZPMC Quality Control Inspector (QC) is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 41, 42 located on Bike Path BK005B– 004. Welder is identified as 049220. ZPMC Quality Control Inspector (QC) is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Bay #10

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 07, located on 109 mtr., Skin E of North shaft, ND1-SFSA3-23. Welder is identified as 053829. ZPMC Quality Control Inspector (QC) is identified as Wang Hao. The welding variables recorded by QC

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appeared to comply with the WPS – B – P-2112.

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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 Micheal Ng (15921845703), who represents the Office of Structural Materials for your project.

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**Inspected By:** Baskar, Govindarajan

Quality Assurance Inspector

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**Reviewed By:** Clifford, William

QA Reviewer