

**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-017559**Date Inspected:** 14-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

<b>CWI Name:</b>	Mr. Qiu Wen		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	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.

Bay #10

This QA Inspector observed the following work in progress

**Shielded Metal Arc Welding (SMAW):**

Repair of Weld joint # 044, located on Bike Path BK004A6- 025. Welder is identified as 052493. ZPMC Quality Control Inspector (QC) is identified as Yu Zhi Hai. The welding variables recorded by QC appeared to comply with the WPS - 345-SMAW -1G (1F) -Repair.

This QA Inspector observed the following work in progress

**Fluxcored Arc Welding (FCAW):****ORTHOTROPIC BOX GIRDER (OBG)**

Repair of Weld joint # 044, located on Bike Path BK004A6- 025. Welder is identified as 040302. ZPMC Quality

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Control Inspector (QC) is identified as Yu Zhi Hai. The welding variables recorded by QC appeared to comply with the WPS – 345-FCAW -1G (1F) -Repair.

Weld joint # 014, 015- located on Bike Path BK007A4– 001. Welder is identified as 057180. ZPMC Quality Control Inspector (QC) is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 025, 026- located on Bike Path BK007A7– 001. Welder is identified as 057258, 057180. ZPMC Quality Control Inspector (QC) is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 031, 032- located on Bike Path BK007A7– 001. Welder is identified as 053869, 052075. ZPMC Quality Control Inspector (QC) is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 51- located on Bike Path BK007A3– 001. Welder is identified as 053869, 057180. ZPMC Quality Control Inspector (QC) is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Bay #11

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

ORTHOTROPIC BOX GIRDER (OBG)

Weld joint # 019, 20- located on Bike path component BK 004A3-017. Welder is identified as 049270. ZPMC Quality Control Inspector (QC) is identified as Shao Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

Weld joint # 032, 033- located on Bike path component BK 004A3-017. Welder is identified as 049270. ZPMC Quality Control Inspector (QC) is identified as Shao Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

Weld joint # 129, 144- located on Bike path component BK 004A5-022. Welder is identified as 040736. ZPMC Quality Control Inspector (QC) is identified as Shao Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B –T – 2133.

Weld joint # 063, 070- located on Bike path component BK 004A8-021. Welder is identified as 042218. ZPMC Quality Control Inspector (QC) is identified as Shao Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B –T – 2332-TC-P4-F.

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Weld joint # 080, 078- located on Bike path component BK 004A8-021. Welder is identified as 053316. ZPMC Quality Control Inspector (QC) is identified as Shao Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B –T – 2332-TC-P4-F.

Bay #12

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

ORTHOTROPIC BOX GIRDER (OBG)

Weld joint # 003, 004- located on U Rib Splice plate component SA 3111B -031. Welder is identified as 062259. ZPMC Quality Control Inspector (QC) is identified as Guo Jiang Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 –TC-U4B-F.

Weld joint # 003, 004- located on U Rib Splice plate component SA 3111B -032. Welder is identified as 062259. ZPMC Quality Control Inspector (QC) is identified as Guo Jiang Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 –TC-U4B-F.

Weld joint # 003- located on U Rib Splice plate component SA 3061B -005. Welder is identified as 062259. ZPMC Quality Control Inspector (QC) is identified as Guo Jiang Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 –TC-U4B-F.

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.

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## 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