

**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-017716**Date Inspected:** 18-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:** Xu Le Feng**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 & 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#11

**ORTHOTROPIC BOX GIRDER (OBG) AT BAY#11**

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 51 located on Bike Path BK005A3 – 003. Welder is identified as 042218. ZPMC Quality Control (QC) Inspector is identified as Li Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 72 located on Bike Path BK004A8 – 018. Welder is identified as 054460. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 01 located on Bike Path BK004A2 – 018. Welder is identified as 04541. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

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Weld joint # 73 located on Bike Path BK004A8 – 018. Welder is identified as 054460. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 52 located on Bike Path BK005A3 – 003. Welder is identified as 049220. ZPMC Quality Control (QC) Inspector is identified as Li Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Shielded Metal Arc Welding (SMAW):

Weld joint # 021 located on Bike Path, BK004A6 – 022. Welder is identified as 040655. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113.

Weld joint # 116 located on Bike Path, BK004A6 – 022. Welder is identified as 041271. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113.

## BLAST SHOP#2

This QA Inspector observed the following work in progress

During the Quality Assurance Inspection of Visual testing (VT) of Pre blasting inspection, this Quality Assurance Inspector (QA) discovered the following issue:

- Two (2) areas that required further grinding/welding at skins A, B, C, D, & E of North Shaft, Lift 3:
  - a. Cluster of Porosity found at 108.58 metre elevation on the doubler plate of Skin E.
  - b. Base metal cavity found at 114 metre elevation on Skin E, Edge- Top side. This is approx. 755 mm from Skin A/E corner. (See attached photos)

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



## Summary of Conversations:

No Relevant Conversations.

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## 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 Thomas Ho- 15002048250, who represents the Office of Structural Materials for 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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