

**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-017744**Date Inspected:** 03-Nov-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. 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:** Tower and Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

NDT

BAY 11

This QA Inspector performed randomly Visual Inspection and Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6028 (MT) report for this date. The member is identified as Tower Top plate. The weld designations reviewed are as follows.

G TSA5-B/G-3B, 6B, 1B, 2B, 9B, 10B

NDT Notification No-07220

BAY 11

This QA Inspector performed randomly Visual Inspection and Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6028 (MT) report for this date. The member is identified as OBG Bike Path. The weld designations reviewed are as follows.

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BK004A2-053-013, 021, 002, 008

NDT Notification No-07212

BAY 11

This QA Inspector performed randomly Visual Inspection of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as OBG Bike Path. The weld designations reviewed are as follows.

BK004A3-020-065, 068, 067, 070, 071, 069, 100, 102, 101, 104, 105, 103

BK004A4-020-080, 083, 082, 087, 086, 085, 100, 102, 101, 105, 104, 103

NDT Notification No-07217

BAY 10

This QA Inspector observed the following work in progress:

BAY 10, SAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 0503060 Perform Submerged Arc Welding (SAW) on Tower lift 5 cover plate. Joint identified as SSD1-TL5-1B/F-42B, 75B, 59B. ZPMC QC Identified as Li Peng Fei. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3221-B-U3c-S-1.

OBG Bike path plate FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040583, Perform Flux Core Arc Welding (FCAW) on OBG bike path plate. Joint identified as BK004A6-025-092, 096, 098, 102. ZPMC QC Identified as Yu Zhi Lai. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2332-Tc-P4-F, and WPS-B-T-2333-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 057180, Perform Flux Core Arc Welding (FCAW) on OBG bike path plate. Joint identified as BK004A8-025-092, 096, 098, 102. ZPMC QC Identified as Yu Zhi Lai. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2332-Tc-P4-F, and WPS-B-T-2333-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 052075, Perform Flux Core Arc Welding (FCAW) on OBG bike path plate. Joint identified as BK004A4-026-008, 009, 034, 035, 060, 061. ZPMC QC Identified as Yu Zhi Lai. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2332-Tc-P4-F.

Magnetic Particle Testing:

This QA Inspector observed AB/F Magnetic Particle Testing Inspector, performed MT on OBG Bike path cover plate. Joint identified as BK004A2-028-016, 018. For more information see below attached picture number 1.

BAY 11

SMAW Process, Repair welding:

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This QA Inspector observed ZPMC qualified welding personnel identified as 044541, 040655 Perform Shielded Metal Arc Welding (SMAW) on OBG bike path. Joint identified as BK005B-004-043. ZPMC CWI Identified as Yu Dong Ping with temporary repair report. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F) –Repair.

## OBG Bike Path, FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040704, 054460, Perform Flux Core Arc Welding (FCAW) on OBG Bike path Railing base plate. Joint identified as BK004ASD1-053-022, 023, 024, 027. ZPMC CWI Identified as Yu Dong Ping. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231-Tc-U4c-F.

## SAW process:

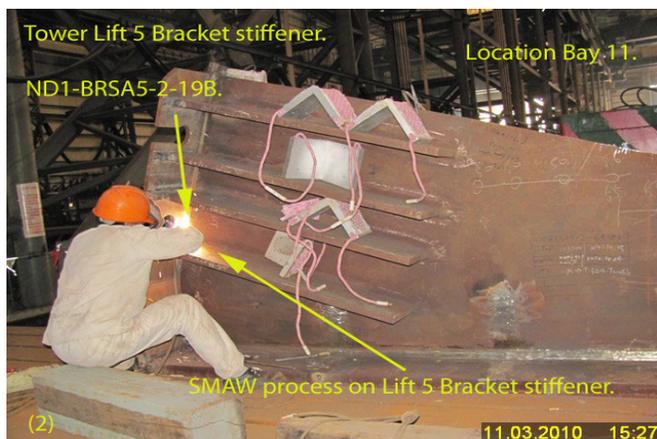
This QA Inspector observed ZPMC qualified welding personnel identified as 040699 Perform Submerged Arc Welding (SAW) on Tower lift 5 cover plate. Joint identified as ESD1-TL5-2B/F-73B, 45B, and WSD1-TL5-4B/F-59B. ZPMC QC Identified as Xu Jie. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3221-B-U3c-S-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 040723, Perform Flux Core Arc Welding (FCAW) on OBG Bike path. Joint identified as BK004C1-024-044. ZPMC CWI Identified as Yu Dong Ping. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2232-Tc-U4c-F.

## Tower SMAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040724, Perform Shielded Metal Arc Welding (SMAW) on Tower Bracket Stiffener lift 5. Joint identified as ND1-BRSA5-2-19B. ZPMC QC Identified as Xu Jie. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3213-Tc-U5b. For more information see below attached picture number 2.

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:**

Only general conversation was held between QA and QC concerning this project.

**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 phone : 150002048250, who represents the Office of Structural Materials for your project.

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

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