

**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-017875**Date Inspected:** 26-Sep-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:** Gong Wai**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 COMPONENT**Summary of Items Observed:**

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

In process Inspection

Bay#14

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG segment 13CE, weld No.VP3007-001-064. The welder is identified as #070478. ZPMC QC is identified as Mr.Lv Li Qing. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4B-F.

FCAW in the 2G position for the OBG segment 13AE, UT repair weld No.VP3004-001-013. The welder is identified as #044774. ZPMC QC is identified as Mr. Lv Li Qing .The welding variables recorded by QC appear to comply with WPS-345-FCAW-2G(2F)-FCM-REPAIR. The weld repair report is identified as WB-15271.

FCAW in the 2G position for the OBG segment 13AE, UT repair weld No.VP3004-001-027. The welder is identified as #044795. ZPMC QC is identified as Mr. Lv Li Qing .The welding variables recorded by QC appear to comply with WPS-345-FCAW-2G(2F)-FCM-REPAIR. The weld repair report is identified as WB-15265.

Bay#19

This QA Inspector observed the following work in progress:

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FCAW in the 2F position for the OBG bike path, weld No. BK004A1-013-006. The welder is identified as #062783. ZPMC QC is identified as Mr.Xu Tao. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

FCAW in the 3F position for the OBG bike path, weld No. BK004A8-013-019/020. The welder is identified as #062783. ZPMC QC is identified as Mr.Xu Tao. The welding variables recorded by QC appear to comply with WPS-B-T-2133.

FCAW in the 2F position for the OBG bike path, weld No. BK004A8-013-041/042. The welder is identified as #208632. ZPMC QC is identified as Mr.Xu Tao. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

Ultrasonic Testing (UT) for Segment 13BE and 13CE

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as bike Path weld joints.

The welds designation reviewed are as follows:

SEG3007AC-001

SEG3007AC-002

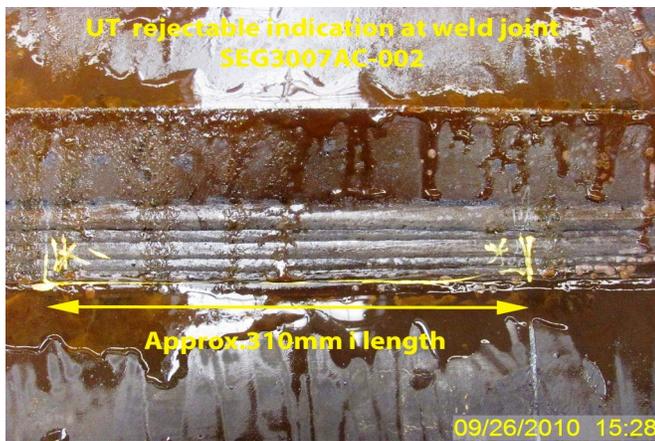
During random in-process visual inspection of welds located on Orthotropic Box Girder (OBG) segment 13BE and 13CE, this Quality Assurance Inspector (QA) discovered the following issues that ZPMC personnel (W-058100) performing Submerged Arc Welding (SAW) at wet surface for bottom plate splice joint joining between Segments 13BE to 13CE. The weld is identified as OBE13C-001. The Weld is Complete Joint Penetration (CJP) butt joint. The Weld is Seismic Performance Critical Members (SPCM). The Y distance for the exposed area 8000mm from bike path edge of the bottom plate. The bottom plates are located at bay #14.

This QA inspector generated an incident report for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with 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 Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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# WELDING INSPECTION REPORT

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<b>Inspected By:</b>	Bera,Subhasis	Quality Assurance Inspector
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<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer
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