

**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-017950**Date Inspected:** 24-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 tao**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 Components**Summary of Items Observed:**

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

BAY#19

FCAW welding of critical repair weld cut and re-weld is identified as 2F-004 of BP025-015 for FL-3. The welder is identified as 062738. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132 and B-CWR2067.

FCAW welding of critical repair weld cut and re-weld is identified as 2F-005 of BP025-015 for FL-3. The welder is identified as 062749. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132 and B-CWR2067.

FCAW welding of critical repair weld is identified as 1G-019 of BK004A2-010 for BK4A-010. The welder is identified as 202338. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-1G(1F)- repair and B-CWR2082.

FCAW welding of weld is identified as 1G-003 of SB22-104 for SB104E. The welder is identified as 062752. ABF QC is identified as Mr. Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-Tc-U4b-F.

FCAW welding of weld is identified as 1G-003 of SB22-106 for SB106E. The welder is identified as 260562.

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ABF QC is identified as Mr. Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-Tc-U4b-F.

FCAW welding of weld is identified as 2F-038 of BK005A1-001 for BK05A-001. The welder is identified as 062739. ABF QC is identified as Mr. Li ming yang. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132.

Flatness correction of following bike path BK006A-002, BK004-005 and BK005A-001 weld is identified as 016, 018 is carried out by ZPMC personnel as approved report HSR1 (B)-9501.

Visual inspection of Cope holes carried out in following suspender bracket SB86W and SB90W. locations need additional grinding and welding marked and repaired by ZPMC personnel.

This QA inspector performed MT 15% of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as OBG Suspender bracket. The weld designations reviewed as follows.

SB017-090-009, 010,012,013,014,026,037,067,055

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



## Summary of Conversations:

No relevant Conversation.

## 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-15--0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By: Kumar, Chadra

Quality Assurance Inspector

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**Reviewed By:** McClendon, Timothy

QA Reviewer