

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-017951**Date Inspected:** 26-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>	Zhang Zhong	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes	No N/A
		<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	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 weld is identified as 1G-003 of SB22-104 for SB104W. 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 SB106W. The welder is identified as 260562. 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.

Visual inspection of internal welds and surface cleaning carried out before install the bottom cover plate, the bike path is identified as BK004A-007 and BK004A-009. Locations where need additional grinding and cleaning marked and repaired work carried out ZPMC personnel.

During inprocoess visual inspection it is found that in following bike paths BK004A-005 and BK004A-006,

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Flatness correction carried out by ZPMC personnel. This is informed to ZPMC QC Mr. Li ming yang to carry out NDT on those locations.

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 Bike path. The weld designations reviewed as follows.

BK004A-008

BK004A2-008-018,019,020,021,008.

BK004A6-008-001,002,007,165.

BK4ASD1-008-025,026.

BK004A-009

BK4ASD1-009-005,006,008,021.

Bike path trail assembly ZPMC personnel assemble following bike paths as follows

BK006A-002/BK005A-001/BK004A-012/002/011/005.

While ZPMC QC MT personnel performing MT of bottom cover plate found lot of linear indications, and cracks. This is informed to ZPMC QC Mr. Li ming yang to raise CWR for Further repair welding.

Green tag issued following suspender brackets after NDT carried out successfully.

SB88E-012272.

SB90E-012259.

Green tag issued following suspender brackets after NDT carried out successfully with comments.

SB86W-012261.

SB88W-012260.

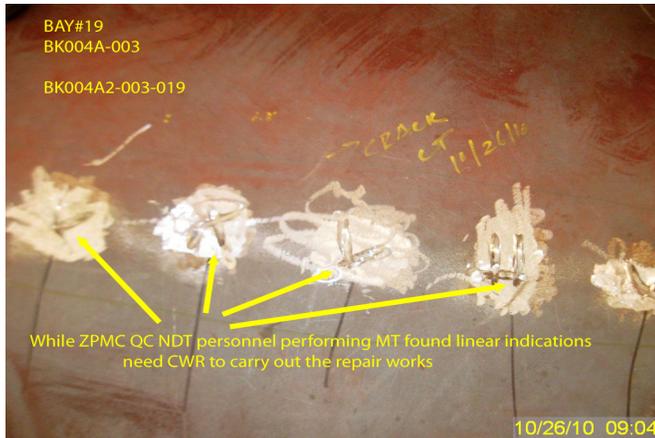
SB90W-012271.

Above suspender brackets need required documentation to close NCR.

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 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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<b>Inspected By:</b>	Kumar, Chadra	Quality Assurance Inspector
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<b>Reviewed By:</b>	McClendon, Timothy	QA Reviewer
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