

**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-018075**Date Inspected:** 15-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 Xian Ping**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

OBG # BAY 8

This QA inspector received ZPMC notification 06963 to perform Visual Inspection the area previously tested and accepted by ZPMC Quality Control Personnel. The member is identified as Bike Path. The weld tested is identified as follows:

(BK004A6-055-035,160,041,042,117,118,104~109)

(BK004A8-055-035,036,041,042,117,118,104~109)

This QA Inspector randomly observed the following work in progress:

OBG # BAY 6

This QA observed ZPMC qualified welding personnel identified as 053609 perform Flux Cored Arc Welding (FCAW) Process on weld joint CB3002J-002-045. ZPMC Quality Control Personnel (QC) identified as Mr. Shen jian guo was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-TC-U4b-F.

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OBG # BAY 7

This QA observed ZPMC qualified welding personnel identified as 054458 perform Submerged Arc Welding (SAW) Process on weld joint CB3003C-019-002. ZPMC Quality Control Personnel (QC) identified as Mr. Xu hai yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2C-S-2.

OBG # BAY 8

This QA observed ZPMC qualified welding personnel identified as 500405 / 054459 perform Flux Cored Arc Welding (FCAW) Process on weld joint BK004A4-064-014,015. ZPMC Quality Control Personnel (QC) identified as Mr. Feng ya jun was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

During the Caltrans Quality Assurance in-process observations of the fabrication of Bike Path, this Quality Assurance Inspector (QA) discovered the following issues. The over sized cope holes were observed in the Stiffener, BKX11B. According to the shop drawings, the Cope Hole radius was 25mm or 25mmx25mm snip corner. ZPMC personnel trimmed the corners up to approximately 46mmX25mm. The stiffener is connected to the side plate BKPL3A and the bearing plate BKPL7A/B. The affected Bike Paths are identified as BK004A-053, BK004A-054 & BK004A-055. This QA notified ZPMC QC identified as Mr. Feng ya jun of this issue and that an incident report would be generated. See attached pictures.

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



## Summary of Conversations:

As mention above

## 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 150-00422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Sukanthan,Dhanasingh	Quality Assurance Inspector
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<b>Reviewed By:</b>	Hall,Steven	QA Reviewer
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