

**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-018105**Date Inspected:** 11-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 Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 (UT) report for this date. The member is identified as OBG Bike Path. The weld designations reviewed are as follows.

BK5BSD1-004-005, 006, 018, 021

BK005B1-004-44

NDT Notification No-07308

BAY 10

This QA Inspector performed randomly Visual Inspection and Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 (UT) report for this date. The member is identified as North Tower lift 5 Grillage cover plate. The weld designations reviewed are as follows.

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 4 )

---

---

NSD1-TL5-3B/F-68A/B, 50A/B, 47A/B, 66A/B, 45A/B, 81A/B, 58A/B, 72A/B, 54A/B, 64A/B, 55A/B, 43A/B, 73A/B

NDT Notification No-07311

BAY 10

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.

BK004A3-026-065, 067, 068, 100, 101, 102, 069, 070, 071, 103, 104, 105

BK004A4-026-080, 082, 083, 100, 101, 102, 085, 086, 087, 103, 104, 105

NDT Notification No-07301

This QA Inspector observed the following work in progress:

BAY 11

OBG Bike path, SMAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040723, 202100 Perform Shielded Metal Arc Welding (SMAW) on OBG bike path. Joint identified as BK005B3-004-019, 020, 032, 033. 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-P-2113.

OBG Bike path, FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 053316, Perform Flux Core Arc Welding (FCAW) on OBG Bike path. Joint identified as BK005B6-004-072, 073. 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-2132.

This QA Inspector observed ZPMC qualified welding personnel identified as 040723, Perform Flux Core Arc Welding (FCAW) on OBG Bike path. Joint identified as BK005B3-004-002. 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. For more information see below attached picture number 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 BK005B5-004-002. 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.

Tower lift 6, FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 042218, 205649, Perform Flux Core Arc Welding (FCAW) on Tower lift 6 face A plate. Joint identified as WSD1-FASA6-4-3, 4. 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-2132.

Ultrasonic Testing:

---

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 4 )

---

---

This QA Inspector observed ZPMC Ultrasonic Testing Inspector, performed UT on OBG Bike path. Joint identified as BK004C1-024-044. For more information see below attached picture number 2.

### BAY 10

#### OBG SMAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 500363 Perform Shielded Metal Arc Welding (SMAW) on OBG Bike path. Joint identified as BK004A8-031-117, 118, 043, 044. 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-P-2113.

#### OBG FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040302, 053869 Perform Flux Core Arc Welding (FCAW) on OBG Bike path. Joint identified as BK004A6-031-045, 046, 104, 105 and BK004A8-031-045, 046, 104, 105. 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-2132.

This QA Inspector observed ZPMC qualified welding personnel identified as 057258 Perform Flux Core Arc Welding (FCAW) on OBG Bike path. Joint identified as BK004A6-026-063, 080, 090, 100. 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.

This QA Inspector observed ZPMC qualified welding personnel identified as 040533 Perform Flux Core Arc Welding (FCAW) on OBG Bike path. Joint identified as BK004A8-026-063, 080, 090, 100. 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.

### BAY 11, Green Tagging

This QA inspector performed Visual Inspection for Green Tagging which were previously tested and accepted by ZPMC Quality Control personnel Mr. Yu Dong Ping and ABF QA personnel Mr. Zhao Xian He. The members are identified as OBG Bike Path, BK005B1-004-43, 44. The green Tag number is identified as # 13843.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

---

# WELDING INSPECTION REPORT

( Continued Page 4 of 4 )

---



## 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.

---

**Inspected By:** Gaikwad,Shailesh

Quality Assurance Inspector

---

**Reviewed By:** Clifford,William

QA Reviewer