

**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-018333**Date Inspected:** 13-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:** Yu Dong Ping  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** Yes No N/A  
**Approved WPS:** Yes No N/A  
**Delayed / Cancelled:** Yes No N/A

**Bridge No:** 34-0006**Component:** OBG/TOWER**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh 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:

BAY 11, OBG BIKE PATH (NWIT # 07337)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of an area 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 Components. The weld designations reviewed are as follows.

BK008A1-002-009 (GREEN TAG NO. 13844)

BAY 10, OBG BIKE PATH (NWIT # 07338)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

BK004A3-030-002, 010

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

BK004A5-030-002, 008

BAY 11, OBG BIKE PATH (NWIT # 07339)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

BK005ASD1-003-005, 006, 018, 021

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 10

**OBG BIKE PATH, CLOSURE PLATE**

FCAW welding of weld joints 002 & 007 located on BK004A8-028.

Welder is identified as 040533. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P4-F.

FCAW welding of weld joints 001 & 130 located on BK004A8-028.

Welder is identified as 053869. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2333-Tc-P4-F.

**OBG BIKE PATH, CENTRE PLATE**

FCAW welding of weld joints 222 & 226 located on BK004A7-032.

Welder is identified as 052075. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joints 129 & 144 located on BK004A7-032.

Welder is identified as 052075. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

BAY 11

**OBG BIKE PATH, BOTTOM COVER PLATE**

FCAW welding of weld joint 013 located on BK004A2-020.

Welder is identified as 205649. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

**OBG BIKE PATH, PLUG WELD OF BOTTOM COVER PLATE**

SMAW welding of weld joint 015 & 020 located on BK004A2-020.

Welders are identified as 066155 & 66326. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112-PLUG.

---

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

OBG BIKE PATH, END DIAPHRAGM PLATE

FCAW welding of weld joints 014 & 015 located on BK004A5-022.

Welder is identified as 053316. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

FCAW welding of weld joints 054 & 055 located on BK004A5-022.

Welder is identified as 040723. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

FCAW welding of weld joints 116 & 117 located on BK004A5-022.

Welder is identified as 053316. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joints 129 & 130 located on BK004A5-022.

Welder is identified as 040723. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joints 034 & 035 located on BK005B4-004.

Welder is identified as 042218. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joints 019 & 020 located on BK005B4-004.

Welder is identified as 205649. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joints 070 & 078 located on BK004A8-022.

Welder is identified as 040723. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P4-F.

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

### 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 Eric Tsang : 15000422372/ Thomas Ho - 150002048250, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Gaikwad,Umesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

---