

**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-018339**Date Inspected:** 14-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:** Xu Le Feng**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 & OBG Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#10

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 033 located on Façade Channel built-up assembly, ND1-SFSA4-90-4. Welder is identified as 057266.

ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 012 located on Façade Channel built-up assembly, ND1-SFSA4-710-1. Welder is identified as 057266. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 00 located on Façade Channel built-up assembly, ND1-SFSA4-90-4. Welder is identified as 057266. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

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Shielded Metal Arc Welding (SMAW):

Weld joint # 032 located on Façade Channel built-up assembly, ND1-SFSA4-90-4. Welder is identified as 050038.

ZPMC Quality Control (QC) Inspector is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2114. (See attached photo)

Weld joint # 014 located on Façade Channel built-up assembly, ND1-SFSA4-710-1. Welder is identified as 057220. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2114.

Weld joint # 002 located on Façade Channel built-up assembly, ND1-SFSA4-90-4. Welder is identified as 050038.

ZPMC Quality Control (QC) Inspector is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2114.

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#10

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 019 located on Bike Path, BK004A3 – 030. Welder is identified as 053869. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113.

Weld joint # 009 located on Bike Path, BK004A3 – 030. Welder is identified as 056200. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – P4 – F.

Weld joint # 169 located on Bike Path, BK004A7 – 033. Welder is identified as 052075. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 022 located on Bike Path, BK004A4 – 030. Welder is identified as 056364. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113.

Weld joint # 005 located on Bike Path, BK004A3 – 030. Welder is identified as 056200. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – P4 – F.

BAY#11

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#11

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 016 located on Bike Path, BK005B2 – 004. Welder is identified as 040723. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – L1b – F – 1. (See attached photo)

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Weld joint # 018 located on Bike Path, BK005B2 – 004. Welder is identified as 040723. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – L1b – F – 1.

## Shielded Metal Arc Welding (SMAW):

Weld joint # 121 located on Bike Path, BK005B8 – 004. Welder is identified as 202100. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2114.

Repair welding of weld joint # 020 located on Bike Path, BK004A – 053. Welder is identified as 040655. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 1G (1F) – Repair – 2.

## Plug Welding:

Weld joint # 17 located on Bike Path BK004A2 – 020. Welder is identified as 066326. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112 – PLUG.

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



## Summary of Conversations:

No Relevant Conversations.

## 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- 15002048250, who represents the Office of Structural Materials for your project.

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Inspected By: Kumar,Sandeep

Quality Assurance Inspector

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**Reviewed By:** Clifford,William

QA Reviewer