

**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-018342**Date Inspected:** 18-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng, Guo Yan Fei**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:** 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 10, OBG BIKE PATH (NWIT # 07397)

This QA inspector performed random Visual Testing (VT) of an area previously tested and accepted by ZPMC Quality Control personnel. The members are identified as OBG Components. The weld designations reviewed are as follows.

BK004A-025 (GREEN TAG NO. 13772, STEP # 10)

BAY 14, OBG Segment 13BW-13CW

This QA Inspector performed verification Ultrasonic Testing (ABF Request No: 11182010-2) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as weld between two side panels and two bottom panels at intersection of OBG segment 13BW & 13CW. The weld designations were as;

OBW13C-001 (13BW-13CW, BP-D14)

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# WELDING INSPECTION REPORT

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OBW13C-002 (13BW-13CW, SP-E7)

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

BAY 10

## U-RIB SPLICE PLATE REPAIR

FCAW welding of weld joint 002 located on GGL-MQ-1958-28.

Welder is identified as 052763. ZPMC QC is identified as Mr. Deng Zhi Bing.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-REPAIR.

## U-RIB SPLICE PLATE

FCAW welding of weld joints 001 & 002 located on GGL-MQ-2021-42.

Welder is identified as 057180. ZPMC QC is identified as Mr. Li Peng Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-F.

## OBG BIKE PATH, BOTTOM COVER PLATE PLUG WELD

FCAW welding of weld joints 015, 019 & 020 located on BK004A2-028.

Welders are identified as 040302, 053869 & 052075 respectively. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132-2-plug.

BAY 11

## OBG BIKE PATH, CLOSURE BOX

FCAW welding of weld joints 001~004 located on BK4ASD1-020.

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-2231-Tc-U4c-F.

FCAW welding of weld joints 022~024 & 027 located on BK4ASD1-020.

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-2231-Tc-U4c-F.

## TOWER LIFT 6, SKIN PLATE SUBASSEMBLY

FCAW welding of weld joint 023A located on ESD1-FESA6-2.

Welder is identified as 205649. ZPMC QC is identified as Mr. Shao Hai Lang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-U2.

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

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## WELDING INSPECTION REPORT

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

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