

**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-018379**Date Inspected:** 27-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. Xu Le Fung.**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 10:

This QA Inspector performed randomly Visual Inspection and Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6028 (MT) report for this date. The member is identified as OBG Bike Path. The weld designations reviewed are as follows.

BK004A1-032-043

BK004A1-032-044

NDT Notification No-07518

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.

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

BK005B3-004-002, 010

BK005B5-004-002, 008, 112, 115, 118, 121, 122, 125, 128, 131

NDT Notification No-07512

This QA Inspector observed the following work in progress:

BAY 10:

OBG Bike path, FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 053869, 040533 Perform Flux Core Arc Welding (FCAW) on OBG Bike path bottom cover plate. Joint identified as BK004A2-026-002, 008, 013. ZPMC QC Identified as Lijun. 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 052075 Perform Flux Core Arc Welding (FCAW) on OBG Bike path bottom cover plate. Joint identified as BK004A2-026-014, 015. ZPMC QC Identified as Lijun. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132-2-Plug.

BAY 11:

Tower Lift 6, FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 205649, 040723, Perform Flux Core Arc Welding (FCAW) on lift 6 assembly plate. Joint identified as WSD1-FDSA6-4-7, 8. ZPMC QC Identified as Libin. 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 053316, Perform Flux Core Arc Welding (FCAW) on lift 6 assembly plate. Joint identified as ESD1-FGSA6-2-25A. ZPMC QC Identified as Libin. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2131-B-U3-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 040704, Perform Flux Core Arc Welding (FCAW) on lift 6 assembly plate. Joint identified as ESD1-FESA6-2-8, 15. ZPMC QC Identified as Libin. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2332-Tc-P4-F. For more information see below attached picture number 1.

Tower lift 5 Repair welding, SMAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 054460 Perform Shielded Metal Arc Welding (SMAW) on Lift 5 Bracket stiffener. Joint identified as ND1-BRSA5-2-6A/B. ZPMC CWI Identified as Xu Le Feng with Critical welding repair report CWR-T-CWR709. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-485-SMAW-2G (2F) Repair. For more information see below attached picture number 2.

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

---

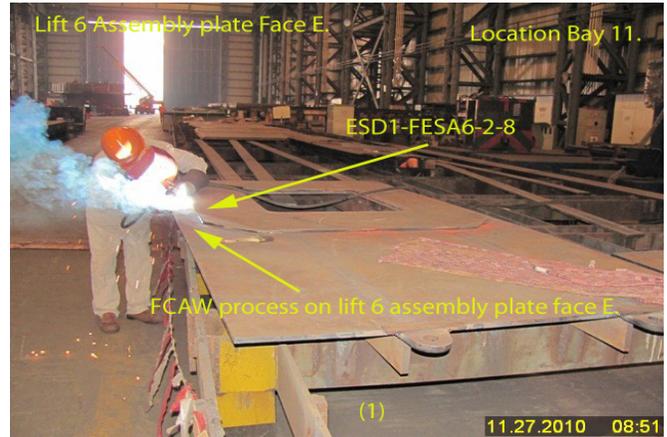
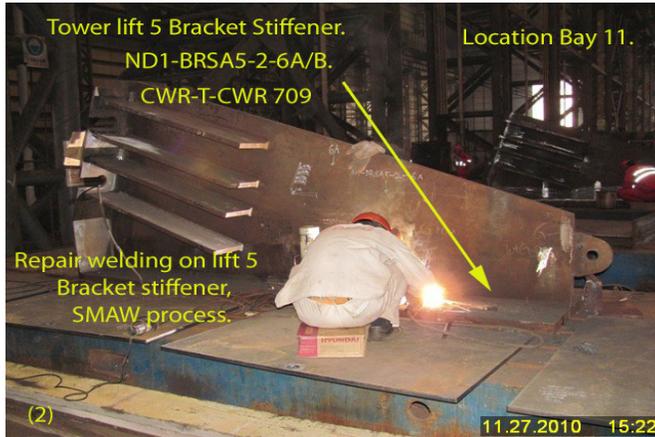
---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---



## 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.

---

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

---