

**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-018382**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:** 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:** 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

**ORTHOTROPIC BOX GIRDER (OBG) AT BAY#10**

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 013 located on Bike Path BK004A2 – 026. 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 – T – 2132. (See attached photo)

Weld joint # 008 located on Bike Path BK004A2 – 026. Welder is identified as 040533. 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.

Plug Welding by FCAW:

Weld joint # 14 located on Bike Path BK004A – 026. 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

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WPS – B – T – 2132 – 2 – PLUG.

Weld joint # 17 located on Bike Path BK004A – 026. 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 – 2 – PLUG.

BAY#11

This QA Inspector observed the following work in progress

Sub-merged Arc Welding (SAW):

Weld joint # 25A located on Lift-6 Tower Head component ESD1 – FGSA6 – 2. Welder is identified as 053316. ZPMC Quality Control (QC) Inspector is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – U3c – S – 2.

Weld joint # 26A located on Lift-6 Tower Head component ESD1 – FGSA6 – 2. Welder is identified as 053316. ZPMC Quality Control (QC) Inspector is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – U3c – S – 2.

Fluxcored Arc Welding (FCAW):

Weld joint # 07 located on Lift-6 Tower Head component WSD1 – FDSA6 – 4. Welder is identified as 205649. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 04 located on Lift-6 Tower Head component WSD1 – FFSA6 – 4. Welder is identified as 044541. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#11

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 113 located on Bike Path BK004A5 – 019. Welder is identified as 042218. 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 – 2132. (See attached photo)

Weld joint # 090 located on Bike Path BK004A6 – 019. Welder is identified as 046769. 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 – 2232 – Tc – P4 – F.

Weld joint # 127 located on Bike Path BK004A5 – 019. Welder is identified as 046769. 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 – 2132.

Weld joint # 063 located on Bike Path BK004A8 – 019. Welder is identified as 042218. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the

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# WELDING INSPECTION REPORT

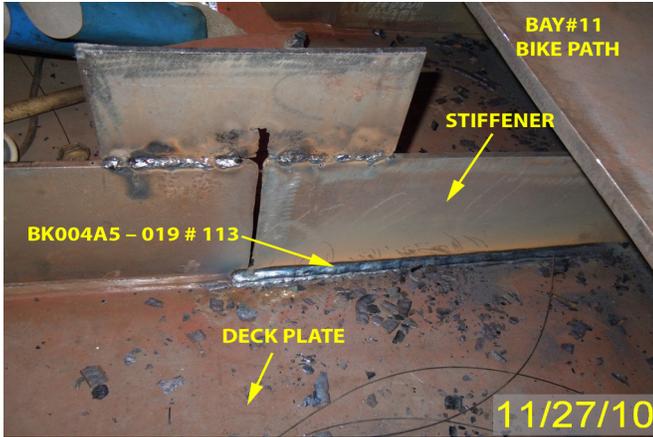
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WPS – B – T – 2232 – Tc – P4 – F.

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

**Reviewed By:** Clifford,William

QA Reviewer

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