

**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-018504**Date Inspected:** 09-Dec-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:** Li yuan hua**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 Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#19

FCAW welding of repair weld is identified as 3G-009 of BK004B3-001 for BK004B-001. The welder is identified as 208641. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2233-ESAB.

FCAW welding of weld is identified as 1G-005 of SBK022-104 for SB104W. The welder is identified as 058792. ABF QC is identified as Mr. Peng wen jun. The welding variables recorded by QC are not appeared to comply with the WPS-B-T-2231-ESAB. Measured values are V=32, I=328 as per WPS we need V=22.9~26.6, I=256~320. This is informed to ABF QC to maintain the required value. He agreed and corrected that same.

FCAW welding of weld is identified as 1G-005 of SBK023-106 for SB106E. The welder is identified as 062732. ABF QC is identified as Mr. Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-ESAB.

FCAW welding of weld is identified as 1G-004 of SBK023-104 for SB104E. The welder is identified as 062783. ABF QC is identified as Mr. Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-ESAB.

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FCAW welding of weld is identified as 1G-004 of SBK022-106 for SB106W. The welder is identified as 062762. ABF QC is identified as Mr. Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-ESAB.

This QA inspector performed UT 10% of weld areas 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 Bike path. The weld designations reviewed as follows.

BK004A7-014-079,142,031.

BK004A7-013-013,019,140,142,073,079,091,218,220.

During Quality Assurance random in-process observations of the fabrication of OBG Lift 11 Suspender brackets SB104W and SB106E, this Caltrans Quality Assurance (QA) inspector discovered the following issue:

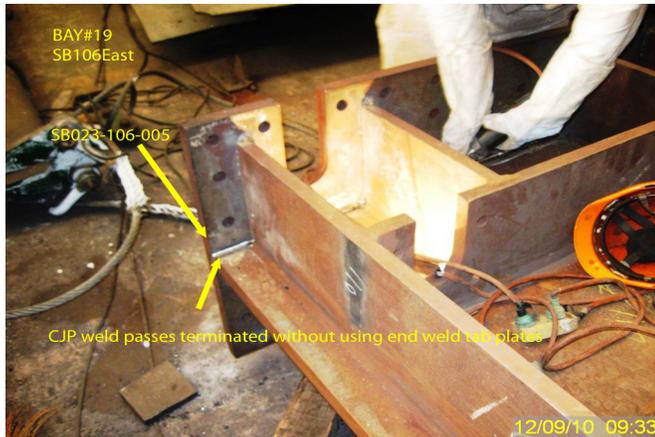
- ZPMC Welding personnel performing welding of CJP joint without using weld tabs (extension bars and run off plates).

-The weld joints are identified as SB022-104-005 of SB104W and SB023-106-005 of SB106E.

For more information please see the Incident report,

04-0120F4\_TL-15\_B247\_12-09-10\_SB104W&SB106E\_for\_Lift11\_not\_\_using\_run\_off\_tabs.

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



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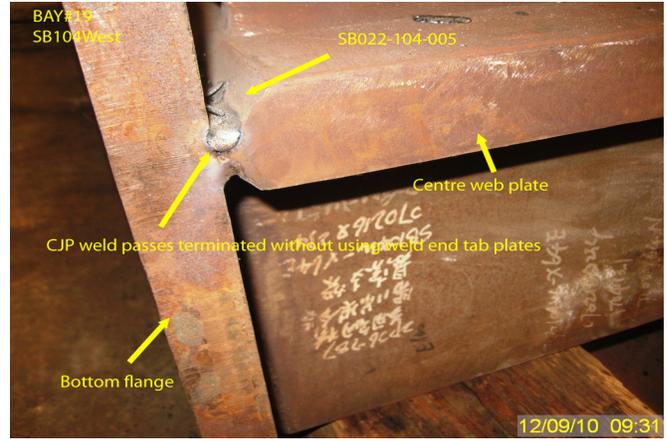
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## Summary of Conversations:

No relevant Conversation.

## 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-15--0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Kumar, Chadra

Quality Assurance Inspector

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**Reviewed By:** Patel, Hiranch

QA Reviewer