

**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-018947**Date Inspected:** 02-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:** 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.

**OBG TRIAL ASSEMBLY**

This QA Inspector observed the following work in progress

Critical Weld Repair (CWR) report verification for a D-Scan weld repair

This QA inspector verified CWR#B-CWR2343 (R0) report prior to the weld repair submitted by ZPMC for a weld joint#006 located on corner assembly CA090 of segment 11CD/11DE DP to EP-E2. ZPMC Certified Welding Inspector (CWI) is identified as Wang Li Yang. This QA Inspector generated a CWI tracker sheet for this date. The member is identified as OBG Component.

**BAY#10**

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 12 located on Tower Façade plate pad eye SD1 – SFSA4 – 71. Welder is identified as 040581. 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 – 2112.

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Weld joint # 01 located on Tower Façade plate pad eye SD1 – SFSA4 – 94. Welder is identified as 040581. 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 – 2112.

Fluxcored Arc Welding (FCAW):

Weld joint # 13 located on Lift-6 tower head component SSD1 – FCSA6 – 1. Welder is identified as 040302. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 02 located on Lift-6 tower head component SSD1 – FCSA6 – 1. Welder is identified as 052075. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. 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 SSD1 – FCSA6 – 1. Welder is identified as 040458. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

BAY#11

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 007585

Ultrasonic Testing (UT)

This QA inspector performed UT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as Tower Component. The weld designation reviewed as follows:

LIFT-6, TOWER

SSD1 – DPSA6 – 5 – 1A/B; 2A/B

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 19A located on Lift-6 Tower Head component ESD1 – TPSA6 – 2. Welder is identified as 040723. ZPMC Quality Control (QC) Inspector is identified as Li Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#11

This QA Inspector observed the following work in progress

Critical Weld Repair (CWR) report verification for a crack repair

This QA inspector verified CWR#B-CWR2341 (R0) report prior to the weld repair submitted by ZPMC for a weld joint#036 located on BK004A8-023. ZPMC Certified Welding Inspector (CWI) is identified as Xu Le Feng. This QA Inspector generated a CWI tracker sheet for this date. The member is identified as OBG Component.

Fluxcored Arc Welding (FCAW):

Weld joint # 07 located on Bike Path BK004A8 – 034. Welder is identified as 205649. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with

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the WPS – B – T – 2332 – Tc – P4 – F.

Weld joint # 02 located on Bike Path BK004A6 – 034. Welder is identified as 040736. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2332 – 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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<b>Inspected By:</b>	Kumar,Sandeep	Quality Assurance Inspector
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<b>Reviewed By:</b>	Clifford,William	QA Reviewer
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