

**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-018983**Date Inspected:** 27-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:** Mr. Liu Fa Wen**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 date Caltrans OSM Quality Assurance (QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #8

This QA Inspector observed the following work in progress

Orthotropic Box Girder (OBG)

Flux cored Arc welding (FCAW)

Weld joint # 080 located on Bike path, OBG Component BK 004A1 -060. Welder is identified as 054459. ZPMC Quality Control (QC) Inspector is identified as Liu Fa Wen. The welding variables recorded by QC appeared to comply with the WPS – B –T -2132-Esab.

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint # 043 as per CWR no. B-CWR 2481, located on Bike path, OBG Component BK 004A1 -062. Welder is identified as 069894. ZPMC Quality Control (QC) Inspector is identified as Liu Fa Wen. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -2G (2F) -Repair.

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Bay #19

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint # 045 as per WRR no. B-WR-19305, located on OBG Component, Suspender Bracket SB023-106. Welder is identified as 066002. ZPMC Quality Control (QC) Inspector is identified as Guo Xing hui. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -2G (2F) –Esab -Repair.

Flux cored Arc welding (FCAW)

Repair welding of Weld joint # 004 as per WRR no. B-WR-19284, located on OBG Component, Suspender Bracket SB023-104. Welder is identified as 062761. ZPMC Quality Control (QC) Inspector is identified as Guo Xing hui. The welding variables recorded by QC appeared to comply with the WPS – 345 –FCAW -3G (3F) –Esab -Repair.

Ultrasonic Testing (UT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 07942.

This QA inspector performed UT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report (TL 6027) for this date. The member is identified as OBG Bike path Components at Bay #8. The weld designation reviewed as follows:

BK004B1-001-Jt. nos -043, 044  
BK 005A1-002- Jt. nos 043, 044  
BK004A1-013- Jt. nos 043, 044  
BK004A1-014- Jt. nos 043, 044

Magnetic Particle Testing (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 07949

This QA inspector performed (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an TL 6028 MT report for this date. The member is identified as OBG Bike path components. The weld designations reviewed are as follows:

BK005ASD1-002 – Jt. nos. – 007, 025

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BK004ASD1-001 – Jt. nos. – 007, 008,026

BK004ASD1-014 – Jt. nos. – 012, 019, 025

BK004ASD1-013 – Jt. nos. – 016, 019, 025

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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 Hu (15002048250), who represents the Office of Structural Materials for your project.

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**Inspected By:** Baskar, Govindarajan

Quality Assurance Inspector

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**Reviewed By:** Clifford, William

QA Reviewer