

**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-019113**Date Inspected:** 05-Jan-2011**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 tao**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 (R2) weld is identified as 3G-053 of SB025-108 for SB108 East. The welder is identified as 058792. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-3G-ESAB-Repair and WR19497.

FCAW welding of repair (R2) weld is identified as 3G-026 of SB024-108 for SB108 West. The welder is identified as 062788. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-3G-ESAB-Repair and R19516.

SMAW welding of repair (R2) weld is identified as 1G-004 of SB022-106 for SB104 West. The welder is identified as 066002. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-3G-Repair and R19242.

SMAW welding of repair (R2) weld is identified as 2G-006 of SB023-106 for SB106 East. The welder is identified as 067520. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-2G-Repair and R19297.

FCAW welding of weld is identified as 3G-130 of BK004A8-014 for BK004A-014. The welder is identified as

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062757. ZPMC QC is identified as Mr.Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2233-ESAB.

FCAW welding of weld is identified as 2G-007 of BK004A8-014 for BK004A-014. The welder is identified as 062757. ZPMC QC is identified as Mr.Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2232-ESAB.

FCAW welding of weld is identified as 2F-013 of BK004A2-014 for BK004A-014. The welder is identified as 062757. ZPMC QC is identified as Mr.Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132-ESAB.

Visual inspection of welds and internal cleaning carryout before fit-up of end closure plate with bike path of BK005A-002.

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 suspender bracket. The weld designations reviewed as follows.

SB023-104-002,004,005,006,035,045,023,025,013,015

During random in-process visual inspection of OBG Bike path, Caltrans Quality Assurance (QA) Inspector discovered the following issue;

-ZPMC personnel had performed base metal repairs (BMR) without a critical weld report (CWR) or without prior approval of the engineer.

-These repairs were performed due to MT Linear Indications discovered by ABF QC MT personnel on light brackets removal areas from the side plate.

-Ten (10) different BMR repairs were located on bike paths approximately 10mm width, with lengths between 20 to 50mm.

-The bike paths are identified as; BK004A-003, BK004A-009, BK004A-004, BK004A-012 and BK006A-002

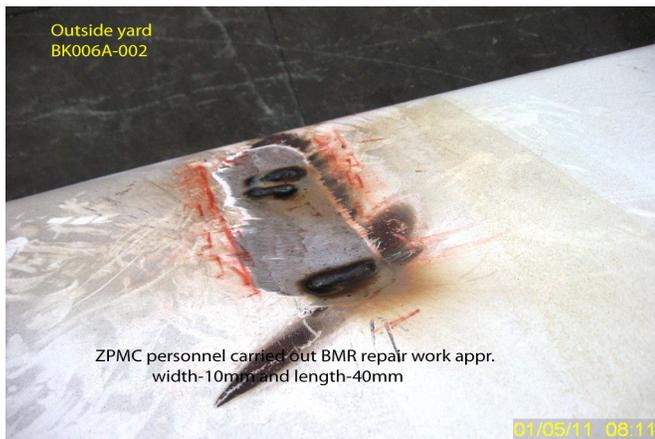
For more information please see the Incident report

Incident\_Report\_TL-15\_B247\_01-05-11\_Bike\_paths\_BMR\_without\_Engineer\_Approval

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

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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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<b>Inspected By:</b>	Kumar, Chadra	Quality Assurance Inspector
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<b>Reviewed By:</b>	Patel, Hiranch	QA Reviewer
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