

**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-019124**Date Inspected:** 22-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 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

SMAW welding of repair weld is identified as 4G-044 of BK005A1-002 for BK005A-002. The welder is identified as 259566. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-4G-Repair and B-WR19181.

FCAW welding of repair weld is identified as 3G-039 of SB023-106 for SB106E. The welder is identified as 062671. ABF QC is identified as Mr. Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-3G-ESAB-Repair-1 and B-WR19304.

FCAW welding of repair weld is identified as 3G-023 of SB023-106 for SB106E. The welder is identified as 062671. ABF QC is identified as Mr. Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-3G-ESAB-Repair-1 and B-WR19300.

ABF QC MT personnel performing MT of Critical weld repair area of plug welds is in progress of Bike path bottom cover plate BK004A-006.

ABF hired ESAB welders give training to ZPMC qualified FCAW welders, how to perform welding with ESAB flux cored welding wire. Welding variables recorded by ZPMC QC Mr.Xu tao are appeared to comply with the

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# WELDING INSPECTION REPORT

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WPS-B-T-2232-ESAB.

This QA inspector performed MT 15% of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as OBG Bike path. The weld designations reviewed as follows.

BK004A3-013-025,026

BK004A4-013-014,015,066,150

BK004A6-013-029,041

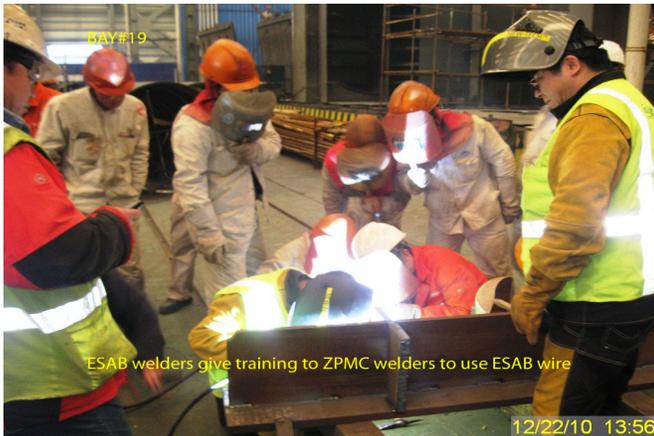
BK004A8-013-029,041,123,126,125

BK004B6-001-029,041

BK004B8-001-029,041

BK004B3-001-025,026

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



## 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

**Reviewed By:** Patel,Hiranch

QA Reviewer