

**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-019662**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

<b>CWI Name:</b>	Yu Dong Ping		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	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.

BAY#10

This QA Inspector observed the following work in progress

Flux Cored Arc Welding (FCAW):

Weld joint # 02 located on Bike Path BK009A1 – 001. Welder is identified as 053869. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – ESAB.

Weld joint # 02 located on Bike Path BK009A1 – 001. Welder is identified as 052075. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – ESAB.

Witness of Magnetic Particle Testing (MT)

This QA inspector Witnessed MT performed by ZPMC Quality Control personnel. The member is identified as OBG Component. The component designation is identified as follows:

BIKE PATH : BK004A1 – 031

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### Heat Straightening:

Heat Straightening being performed on Bike path component identified as BK008-001 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Li Jun present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (B) – 9965.

### Shielded Metal Arc Welding (SMAW):

Weld joint # 15 located on Bike Path BK004A – 031. Welder is identified as 044511. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112 – plug.

Weld joint # 19 located on Bike Path BK004A – 031. Welder is identified as 057258. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112 – plug.

### BAY#11

This QA Inspector observed the following work in progress  
Critical Weld Repair (CWR) report verification for Buttering

This QA inspector verified CWR#T-CWR678 (R0) report prior to the weld repair submitted by ZPMC on lift-5 tower grillage I-beam identified as WD1-BPSA5-5-EN2. ZPMC Certified Welding Inspector (CWI) is identified as Yu Dong Ping. This QA Inspector generated a CWI tracker sheet for this date. The member is identified as Tower Component.

### Surface Welding by Shielded Metal Arc Welding (SMAW):

Surface welding / buttering being performed as per the critical weld repair report T-CWR678 located on Lift-5 tower grillage I-beam identified as WD1-BPSA5-5-EN2. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 1G (1F) – Repair.  
(See attached photo)

### BAY#12

This QA Inspector observed the following work in progress  
Shielded Metal Arc Welding (SMAW):

Tack welding on typical service platform grating and guard rail SP8-07. Welder is identified as 059373. ZPMC Quality Control (QC) Inspector is identified as Guo Yan Fei. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113. (See attached photo)

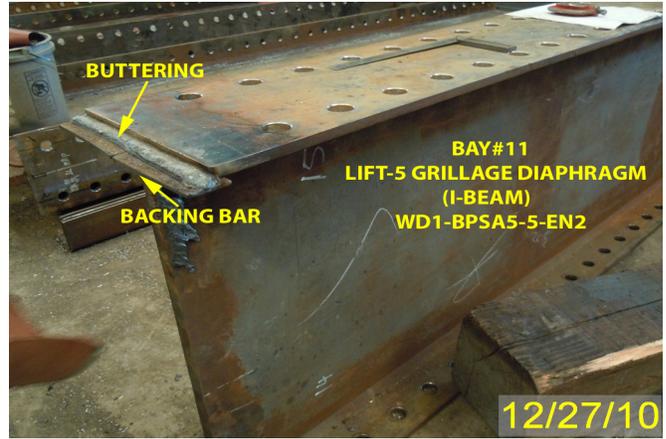
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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## Summary of Conversations:

No Relevant 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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**Inspected By:** Kumar,Sandeep

Quality Assurance Inspector

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**Reviewed By:** Clifford,William

QA Reviewer