

**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-020393**Date Inspected:** 19-Aug-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:** Zhu Zong Hai  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

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

**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

This QA Inspector performed the following work:

OBG Segment 9DW

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the Counterweight side DP to EP holdback weld (9EW side).

ABF Report # UT-9W-078

The weld designations reviewed are as follows:

CA065-006

OBG Segment 9EW

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This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the Counterweight side DP to EP holdback weld (10AW side).

ABF Report # UT-9W-082

The weld designations reviewed are as follows:

CA067-006

OBG Segment 9EE

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the Crossbeam side BP to SP holdback weld (10EW side).

ABF Report # UT-9E-099

The weld designations reviewed are as follows:

SEG058A-011

OBG Segment 9EW

This QA Inspector could NOT perform UT due to repair work was being done by ZPMC personnel. The member is identified as the Counterweight side EP to SP holdback weld (10AW side).

ABF Report # UT-9W-083

OBG Segment 10AW

This QA Inspector could NOT perform UT due to repair work was being done by ZPMC personnel. The member is identified as the Counterweight side DP to EP holdback weld (9EW side).

ABF Report # UT-9W-018

OBG Segment 10AW

This QA Inspector could NOT perform UT due to repair work was being done by ZPMC personnel. The member is identified as the Counterweight side EP to SP holdback weld (9EW side).

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ABF Report # UT-9W-019

OBG Segment 10AW-10BW

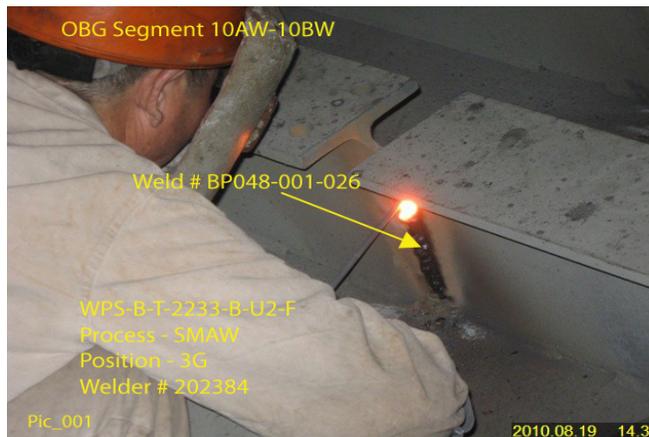
Shielded Metal Arc Welding (SMAW) in the 4G position of Counterweight side SP 'T' rib splice weld # SP164-001-050. The welder is identified as 041713. ZPMC Quality Control (QC) is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

OBG Segment 10AW-10BW

Flux Core Arc Welding (FCAW) in the 3G position of Bottom Panel 'T' rib splice weld # BP048-001-026. The welders are identified as 202384. ZPMC Quality Control (QC) is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with . See attached photograph Pic\_001.

OBG Segment 9CW-9DW

During in process visual inspection this QA Inspector observed ZPMC NDT personnel performing Magnetic Particle Testing (MT) on Bottom splice weld temporary attachment removed area. See attached photograph Pic\_002.



## Summary of Conversations:

No relevant conversations reported on this date.

## 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 (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Gade,Ramesh

Quality Assurance Inspector

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**Reviewed By:** McClendon, Timothy

QA Reviewer