

**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-020821**Date Inspected:** 01-Oct-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:** Huang Min**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 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 10BE-10CE

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 Edge Panel splice weld.

ABF report # UT-10E-044

The weld designations reviewed are as follows:

OBE10A-001

Bay 7/CB18 Tie down Plate

Flux Core Arc Welding (FCAW) in the 3G position of SA3077 plate weld # SA3077-007-001. The welder is identified as 068494. ZPMC Quality Control (QC) is identified as Xu Hai Yang. The welding variables recorded

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by QC appeared to comply with WPS-B-T-2333-C-P2-F-2. See attached photograph Pic\_001.

## Bay 7/CB18 Tie down Plate

Flux Core Arc Welding (FCAW) in the 1G position of SA3077 plate weld # SA3077-006-002. The welder is identified as 068920. ZPMC Quality Control (QC) is identified as Xu Hai Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2331-C-P2-F-2. See attached photograph Pic\_002.

## Bay 6/CB18

Flux Core Arc Welding (FCAW) in the 3F position of CB3002J plate weld # CB3002J-001-041. The welder is identified as 051246. ZPMC Quality Control (QC) is identified as Shu Yang Hua. The welding variables recorded by QC appeared to comply with WPS-B-T-2233.

## Bay 8/ OBG Bike Path

Flux Core Arc Welding (FCAW) in the 1G position of Bike Path BK4ASD1 weld # BK4ASD1-054-001. The welder is identified as 067947. ZPMC Quality Control (QC) is identified as Liu Fa Wen. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-U2-F.

## OBG Segment 10BE-10CE

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 CB side DP to EP holdback weld.

ABF report # UT-10E-046

The weld designations reviewed are as follows:

10BE-CA075-006

10CE-SEG064\*-036



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**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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<b>Inspected By:</b>	Gade,Ramesh	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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