

**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-021131**Date Inspected:** 08-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.

**Bay 6/West Jacking Frame**

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 2G position of weld joint WJF-001-709 located on West Jacking Frame. The welder is identified as 066261. ZPMC CWI is identified as Huang Min. The welding variables recorded by QC appeared to comply with the WPS B-T-3312-TC-P4. See attached photograph Pic\_001.

**Bay 6 /Steel Barriers**

This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated UT report for this date. The member is identified as Steel Barriers as per ZPMC notification # 06887 items # 1 to 5.

The weld designations reviewed are as follows:

Item # 1 W2-SB1-033-019, 020, 021, 062, 081, 083, 093, 096, 097, 112, 128, 129, 130, 131

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W2-SB1-022-019, 020, 021, 062, 081, 083, 093, 096, 097, 112, 128, 129, 130, 131  
W2-SB1-034-019, 020, 021, 062, 081, 083, 093, 096, 097, 112, 128, 129, 130, 131  
W2-SB1-025-019, 020, 021, 062, 081, 083, 093, 096, 097, 112, 128, 129, 130, 131  
Item # 2 W2-SB1G-017-019, 020, 021, 062, 081, 083, 093, 096, 097, 112, 128, 129, 130, 131  
Item # 3 W2-SB1B-001-019, 020, 021, 062, 081, 083, 093, 096, 097, 112, 128, 129, 130, 131  
Item # 4 W2-SB1A-009-019, 020, 021, 062, 081, 083, 093, 096, 097, 112, 128, 129, 130, 131  
W2-SB1A-011-019, 020, 021, 062, 081, 083, 093, 096, 097, 112, 128, 129, 130, 131  
W2-SB1A-005-019, 020, 021, 062, 081, 083, 093, 096, 097, 112, 128, 129, 130, 131  
W2-SB1A-001-019, 020, 021, 062, 081, 083, 093, 096, 097, 112, 128, 129, 130, 131  
Item # 5 W2-SB1H-001-019, 020, 021, 062, 081, 083, 093, 096, 097, 112, 128, 129, 130, 131  
W2-SB1H-003-019, 020, 021, 062, 081, 083, 093, 096, 097, 112, 128, 129, 130, 131

### Bay 6 /Steel Barriers

This QA inspector performed Ultrasonic Testing (UT) approximately 10% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated UT report for this date. The member is identified as Steel Barriers as per ZPMC notification # 06887 items # 1 to 5.

The weld designations reviewed are as follows:

W2-SB1-033-019  
W2-SB1-022-081  
W2-SB1-034-019  
W2-SB1-025-019  
W2-SB1G-017-081  
W2-SB1B-001-050  
W2-SB1A-009-050  
W2-SB1A-011-019  
W2-SB1A-005-019  
W2-SB1A-001-081  
W2-SB1H-001-019  
W2-SB1H-003-019

### Bay 6 /Floor Beam Assy

This QA inspector performed Ultrasonic Testing (UT) approximately 10% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated UT report for this date. The member is identified as OBG Floor Beam 'I' rib splice welds as per ZPMC notification # 06890 items # 5.

The weld designations reviewed are as follows:

FB3241A-001-026 and 028

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Bay 6 /OBG Bike Path

This QA inspector performed Ultrasonic Testing (UT) approximately 10% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated UT report for this date. The member is identified as OBG Bike Path welds as per ZPMC notification # 06892 items # 1 and 2.

The weld designations reviewed are as follows:

BK004A1-055-043

BK004A1-055-090



## 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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