

**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-021343**Date Inspected:** 25-Feb-2011**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:** Geng Wei**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 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#14

East Side

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 08390

Magnetic Particle Testing (MT)

This QA inspector performed MT of the area previously tested and accepted by ZPMC Quality Control personnel.

This QA Inspector generated an MT report for this date. The member is identified as OBG Component. The weld designation reviewed as follows:

SEGMENT 13A EAST

SEG3007R-010; 013~017; 092~113

DP3157-001-033~044; 057~068

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint #018 located on 14E, FB3260-001. Welder is identified as 067665. ZPMC Quality Control (QC)

Inspector is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the

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WPS-B-P-2114-FCM-1.

Weld joint #024 located on 13AE, DP3078-001. Welder is identified as 066163. ZPMC Quality Control (QC) Inspector is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-Tc-U4b-FCM-1.

Weld joint #004 located on 14E, SEG3019X. Welder is identified as 067572. ZPMC Quality Control (QC) Inspector is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-U5b-FCM-1.

Repair welding of weld joint #260 located on 13AE, SEG3007C. Welder is identified as 067183. ZPMC Quality Control (QC) Inspector is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-REPAIR-1.

Weld joint #026 located on 13AE, DP3078-001. Welder is identified as 066163. ZPMC Quality Control (QC) Inspector is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-Tc-U4b-FCM-1.

Weld joint #006 located on 14E, SEG3019X. Welder is identified as 067572. ZPMC Quality Control (QC) Inspector is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-U5b-FCM-1.

Weld joint #013 located on 14E, FB3260-001. Welder is identified as 067665. ZPMC Quality Control (QC) Inspector is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-FCM-1.

Flux Cored Arc Welding (FCAW):

Weld joint #075 located on 13AE, SEG3007AH. Welder is identified as 067877. ZPMC Quality Control (QC) Inspector is identified as Zhong Yong Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-ESAB.

Weld joint #209 located on 14E, SEG3019M. Welder is identified as 066236. ZPMC Quality Control (QC) Inspector is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #076 located on 13AE, SEG3007AH. Welder is identified as 067877. ZPMC Quality Control (QC) Inspector is identified as Zhong Yong Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-ESAB.

Weld joint #018 located on 14E, FB3260-001. Welder is identified as 067665. ZPMC Quality Control (QC) Inspector is identified as Zhong Yong Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2134-ESAB.

Weld joint #053 located on 14E, SEG3019X. Welder is identified as 066439. ZPMC Quality Control (QC)

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Inspector is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

## EAST GRILLAGE INSTALLATION ON BIKE PATH SIDE OF 13A EAST SEGMENT

This QA inspector observed east side grillage installation and fit-up on bike path side of 13A east segment. The member is identified as OBG Component. (See attached photo)

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



### 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 Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Sandeep	Quality Assurance Inspector
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<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer
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