

**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-022834**Date Inspected:** 23-Mar-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:** Sha Zhi**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 OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#19

SMAW welding of weld is identified as 1G-032 of SB027-110 for SB110East. The welder is identified as 259906. ZPMC QC is identified as Mr.Li ping. The welding variables recorded by QC are appeared to comply with the WPS-B-P-2211-Tc-U4b-1.

SMAW welding of weld is identified as 4G-043 of SB026-110 for SB110 West. The welder is identified as 259956. ZPMC QC is identified as Mr.Li Ping. The welding variables recorded by QC are appeared to comply with the WPS-B-P-2214-Tc-U4b-1.

FCAW welding of weld is identified as 2G-031 of SA6030-001 for SA6030. The welder is identified as 062749. ZPMC QC is identified as Mr.Li Ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2232-ESAB.

FCAW welding of weld is identified as 1G-117 of SA6030-001 for SA6030. The welder is identified as 062783. ZPMC QC is identified as Mr.Li Ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-ESAB.

FCAW welding of weld is identified as 2G-006 of SA6529-001 for SA6529. The welder is identified as 062806.

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ZPMC QC is identified as Mr.Li Ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2232-ESAB.

FCAW welding of weld is identified as 1G-090 of SA6529-001 for SA6029. The welder is identified as 062808. ZPMC QC is identified as Mr.Li Ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-ESAB.

ZPMC personnel performing Heat straightening of Bike path stringer plate flange is identified as BK91G for BK025A-001 is in progress as per HSR1 (B)-10214.

ZPMC QC NDT MT personnel performing MT of bike path is identified as BK005A-002 MEP fillet welds is in progress.

ABF QC NDT MT personnel performing MT on after back gouged welds of suspender bracket is identified as SB110E, SB110W.

ABF QC NDT MT personnel performing MT after root pass welds of cable bracket is identified as SA6529, SA6030 is in progress.

BAY#8

This QA inspector performed MT 15% of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as OBG Bike path.

The weld designations reviewed as follows

BK004A2-062-001,005,009,011

BK004A3-062-019,032,043,044,030,045,046,057,005,009

BK004A6-062-061,065,070,076,082,088,090,098,102,073

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 Conversation.

## 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-15--0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Kumar, Chadra

Quality Assurance Inspector

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**Reviewed By:** Patel, Hiranch

QA Reviewer