

**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-023048**Date Inspected:** 29-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:** Xu Le Feng**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 & TOWER 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#10

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 08664

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 TOWER Component. The weld designation reviewed as follows:

TOWER, LIFT-6

NSD1-PFA6-1-01; 07

SSD1-PFA6-2-09; 05

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint #044 located on Bike Path BK14A-001. Welder is identified as 044511. ZPMC Quality Control (QC)

Inspector is identified as Shi Yu. The welding variables recorded by QC appeared to comply with the

WPS-B-P-2214-B-U2.

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Repair welding of weld joint #013 located on Traveler Rail 28TR1-013 as per the weld repair report # B-WR20513. Welder is identified as 057220. ZPMC Quality Control (QC) Inspector is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F) - REPAIR.

Weld joint #044 located on Bike Path BK14A-001. Welder is identified as 056364. ZPMC Quality Control (QC) Inspector is identified as Shi Yu. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2 (See attached photo)

Repair welding of weld joint #013 located on Traveler Rail 28TR1-013 as per the weld repair report # B-WR20513. Welder is identified as 040582. ZPMC Quality Control (QC) Inspector is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F) - REPAIR.

BAY#11

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 08662

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:

SA6019E-001-013; 014  
SA6021A-001-013; 014  
SA6021B-001-016  
SA6021C-001-021  
SA6024A-001-013  
SA6022A-001-001; 004  
SA6022B-001-016  
SA6023A-001-001; 004

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 08665

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:

TRAVELER RAIL  
20TR2-034-011; 015  
20TR2-035-011; 015

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 08659

Magnetic Particle Testing (MT)

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

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

TOWER LIFT-6, CHANNEL

ESD1-WSA6-1-1~4

ESD1-WSA6-3-23~26

ESD1-WSA6-5-23~26

ESD1-WSA6-6-1~4

ESD1-WSA6-9-1; 2

NSD1-WSA6-2-1~4

NSD1-WSA6-4-1~4

NSD1-WSA6-7-25~28

NSD1-WSA6-8-13; 14

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint #13 located on East shaft lift-6, tower head ESD1-FESA6-2. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

Weld joint #010 located on Traveler Rail 32TR1-001. Welder is identified as 040611. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS-B-P-2111.

Weld joint #14 located on East shaft lift-6, tower head ESD1-FESA6-2. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114. (See attached photo)

Weld joint #016 located on Traveler Rail 25TR1-002. Welder is identified as 044541. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS-B-P-2211-Tc-U5b.

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

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# WELDING INSPECTION REPORT

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## 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 Thomas Ho - 15002048250, who represents the Office of Structural Materials for your project.

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**Inspected By:** Kumar,Sandeep

Quality Assurance Inspector

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**Reviewed By:** Clifford,William

QA Reviewer