

**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-023058**Date Inspected:** 09-Apr-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. 08779

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 COMPONENTS

SSD1-DPSA6-5-08; 22; 23

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint #165 located on Bike path BK010A6-001. Welder is identified as 040365. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-Tc-U4c.

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

Weld joint #025 located on Traveler Rail 31TR2-001. Welder is identified as 040582. ZPMC Quality Control (QC) Inspector is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-Tc-U5b.

Weld joint #061 located on Bike path BK009A3-001. Welder is identified as 053829. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-B-U2a-1.

Weld joint #025 located on Traveler Rail 31TR2-001. Welder is identified as 040581. ZPMC Quality Control (QC) Inspector is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-Tc-U5b.

Weld joint #062 located on Bike path BK009A3-001. Welder is identified as 053829. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-B-U2a-1.

Weld joint #165 located on Bike path BK010A6-001. Welder is identified as 040365. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-B-Tc-U4c.

Flux Cored Arc Welding (FCAW):

Weld joint #008 located on Bike path BK008A-002. Welder is identified as 205649. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Lang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

Weld joint #039 located on Bike path BK008A-002. Welder is identified as 205649. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Lang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB. (See attached photo)

BAY#11

This QA Inspector observed the following work in progress

Flux Cored Arc Welding (FCAW):

Weld joint #029 located on Lift-6 Tower head component WSD1-FGSA6-1. Welder is identified as 041271. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS-B-P-2313-Tc-P4. (See attached photo)

Weld joint #027 located on Lift-6 Tower head component WSD1-FGSA6-1. Welder is identified as 044551. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS-B-P-2313-Tc-P4.

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

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---



## 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.

---

**Inspected By:** Kumar,Sandeep

Quality Assurance Inspector

**Reviewed By:** Clifford,William

QA Reviewer