

**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-023419**Date Inspected:** 03-May-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:** Zheng zhi qiang**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

FCAW welding of weld is identified as 2F-003/004 of BK023A6-001 for BK23A-001. The welder is identified as 062739. 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 3F-029/030 of BK23A3-001 for BK23A-001. The welder is identified as 062739. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2133-ESAB.

FCAW welding of weld is identified as 3F-079/080 of BK23A4-001 for BK23A-001. The welder is identified as 062739. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2133-ESAB.

FCAW welding of weld is identified as 3F-021/022 of BK25A6-001 for BK25A-001. The welder is identified as 062807. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2133-ESAB.

FCAW welding of weld is identified as 2F-064/065 of BK25A8-001 for BK25A-001. The welder is identified as

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062807. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132-ESAB.

ZPMC personnel performing heat straightening of cable bracket bottom flange is in progress of SA6029 as per HSR1 (B)-10329.

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.

BK0025A3-001-018,019,040,041

BK25A4-001-032,033,055

BK25A5-001-013,014,019,020,025,026,031,032,043,044,050, 055,056

BK25A7-001-207,209,043,098,209,212,056,109,115,213,216,

BK25A7-001-001,061,062,199,014,019,073,080,026,031,032,091,206

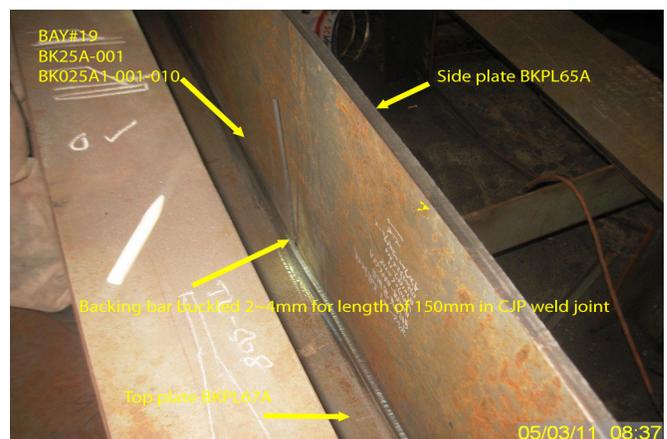
During random in-process visual inspection of OBG Bike path in bay 19, Caltrans Quality Assurance (QA) Inspector discovered the following issues:

- ZPMC personnel welded the CJP weld joint with permanent Backing bar in Bike path.
- After welding the gap between backing bar and the side plate was measured approximately 4mm for a length of 150mm.
- Y location is 1700mm away from A6 weld joint end.
- The weld is identified as BK025A1-001-010.

For more information please see the Incident report

04-0120F4\_TL-15\_B247\_05-03-11\_Bike\_Path\_BK25A-001\_\_Buckled\_Backing\_Bar\_in\_CJP\_weldjoint

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

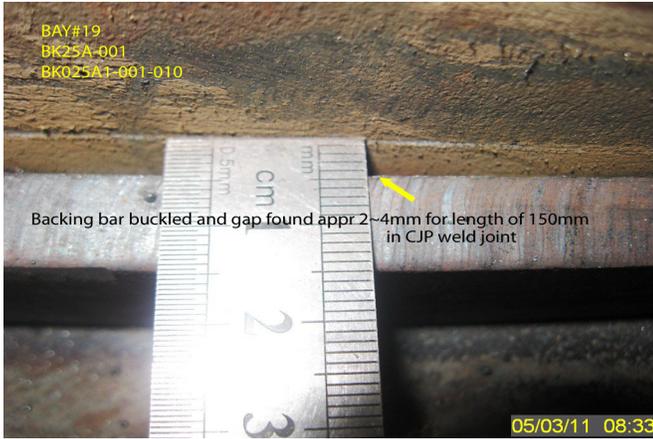


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## Summary of Conversations:

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