

**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-023765**Date Inspected:** 19-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:** Li yan hua**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 2G-003 of BK24A1-001 for BK24A. The welder is identified as 062757. 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.

ZPMC QC NDT MT personnel performing MT on Bike path fillet welds is identified as BK25A is in progress.

ZPMC personnel performing grinding of bike path fillet welds is in progress of BK24A.

ZPMC personnel performing Heat straightening of bike path top plate to side plate CJP welds is in progress as per HSR1 (B)-10361. The weld is identified as BK024A1-001-003.

ZPMC qualified SMAW welder is identified as 259566 is performing touch welding on VT repair marked location is in progress of cable bracket SA6031.

ZPMC personnel performing back gouging of CJP weld joint is identified as BK24A2-001-004,006,013 is in progress.

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# WELDING INSPECTION REPORT

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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 Cable bracket. The weld designations reviewed as follows

SA6031 (CWR2953 Locations)

SA6031-001-127,039,027,034,028,040,041,038,001

SA6031-001-073,079,044,045,056,097,102,091,093,050

SA6031-001-004,012,013,020,021,009,010,017,019,007,014,022,032,008

SA6031-001-053,062,065,066,075,060,069,071,063,068,076,077

SA6031-001-033,035,036

SA6031-001-047,049,095,104

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



### 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