

**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-023785**Date Inspected:** 21-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 / Li yang**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

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.

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.

BK25A4-001-004, 005, 009, 017, 018, 022, 027, 028, 030, 040, 041, 042, 049, 050, 061, 064, 067, 070

BK25A6-001-056, 057, 010, 107, 009

BK25A8-001-032, 033, 054, 055, 066,

During MT of Bike path BK25A fillet welds it is observed that some of the location need grinding and welding marked for further repair work and informed to ZPMC QC Mr. Li ping.

**TRAIL ASSEMBLY YARD**

SMAW welding of weld is identified as 3G-151 of SEG3019S for Segment 14East. The welder is identified as

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# WELDING INSPECTION REPORT

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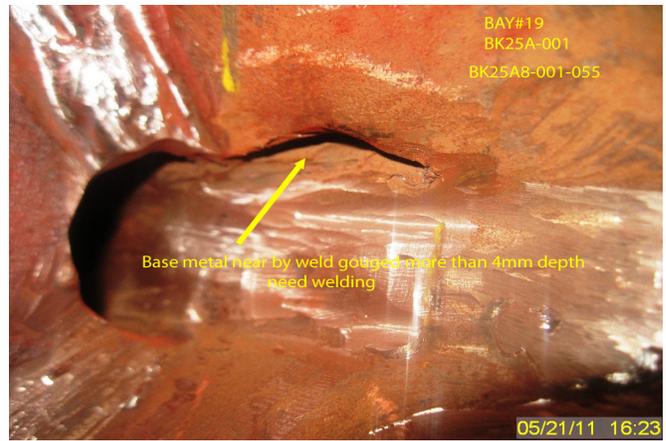
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501946. ZPMC QC is identified as Mr. Zhu yuan yuan. The welding variables recorded by QC are appeared to comply with the WPS-B-P-2213-Tc-Ub-FCM-1.

SMAW welding of weld is identified as 4G-084 of SEG3019W for Segment 14AEast. The welder is identified as 066733. ZPMC QC is identified as Mr. Zhu yuan yuan. The welding variables recorded by QC are appeared to comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld is identified as 3G-105 of SEG3019N for Segment 14AEast. The welder is identified as 066418. ZPMC QC is identified as Mr. Zhu yuan yuan. The welding variables recorded by QC are appeared to comply with the WPS-B-P-2213-Tc-U4b-FCM-1.

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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<b>Inspected By:</b>	Kumar,Chadra	Quality Assurance Inspector
<b>Reviewed By:</b>	Patel,Hiranch	QA Reviewer

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