

**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-023850**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 Corporation, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Mai Quin Li**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:** Traveler Rails & Handrail**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Delbert Humphrey was present during the times noted above for observations relative to the work being performed at ZPMC.

OBG Bay # 16

WELDING

This QA Inspector observed the following work in progress:

SMAW welding # 8 fillet weld, Lifting Point Assembly B3, OBG Deck Bracket, Lift 13. Welder is identified as 201861. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

FCAW welding # 8 fillet weld, Lifting Point Assembly A3N, OBG Deck Bracket, Lift 13. Welder is identified as 053753. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T2132-ESAB (2F).

SMAW welding # 6 fillet weld, P45 (25 x25 bar) to P19 Pipe (PX36), located on BKR-FS2-2, OBG Bike Path Handrail components. Welder is identified as 205770. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

SMAW welding # 6 fillet weld, P45 (25 x25 bar) to P19 Pipe (PX36), located on BKR-FS2-2, OBG Bike Path Handrail components. Welder is identified as 201905. ZPMC Quality Control (QC) is identified as Mr. Mai Quin

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Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

OBG Bay # 14

WELDING

This QA Inspector observed the following work in progress:

SMAW welding of weld identified as TR3004-TR2-001-008, located on Traveler Rail, TR3021-TR2. Welder is identified as 200569. ZPMC Quality Control (QC) is identified as Mr. Gou Qui Zing. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G/2F-Fcm-Repair-1 & BWR-21511.

SMAW welding of weld identified as TR3004-TR2-001-008, located on Traveler Rail, TR3021-TR2. Welder is identified as 067752. ZPMC Quality Control (QC) is identified as Mr. Gou Qui Zing. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G/2F-Fcm-Repair-1 & BWR-21511.

SMAW welding of weld identified as TR3004-TR2-001-008, located on Traveler Rail, TR3021-TR2. Welder is identified as 046704. ZPMC Quality Control (QC) is identified as Mr. Gou Qui Zing. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G/2F-Fcm-Repair-1 & BWR-21511.

SMAW welding of weld identified as TR3004-TR2-001-008, located on Traveler Rail, TR3021-TR2. Welder is identified as 067752. ZPMC Quality Control (QC) is identified as Mr. Gou Qui Zing. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G/2F-Fcm-Repair-1 & BWR-20755.

SMAW welding of weld identified as TR3004-TR2-001-008, located on Traveler Rail, TR3021-TR2. Welder is identified as 045268. ZPMC Quality Control (QC) is identified as Mr. Gou Qui Zing. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G/2F-Fcm-Repair-1 & BWR-20755.

OBG Bay # 13

WELDING

This QA observed the following components in this bay, OBG, Steel Barriers. This QA observed no work being performed on the above mentioned components during the time QA was present.

OBG Bay # 28

WELDING

This QA observed the following components in this bay, OBG, Mock-Up Service Hand Rails. This QA observed no work being performed on the above mentioned components during the time QA was present.

Paint Yard

This QA observed the following components in the paint yard, OBG, Bike Path Hand Rails being lifted from the ground and stack one on top of the without any care to the components no dunnage in between each railing causing damage (buckling, notches, knocking out of straightness, bending pipe rail) to handrail. Hand rail were being taken back to Bay 16 to have breather holes drilled in them for galvanizing process. This QA took pictures of the incident in paint yard and of the trailer loaded with handrail after it was delivered to Bay 16.

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Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



### Summary of Conversations:

No relevant conversations were reported on this date.

### 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, 15000422372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Humphrey, Delbert

Quality Assurance Inspector

**Reviewed By:** Hall, Steven

QA Reviewer