

**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-024013**Date Inspected:** 26-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. 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**Summary of Items Observed:**

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

Bay #19

This QA Inspector observed the following work in progress,

Flux Cored arc welding (FCAW)

Weld joint- 002, Located on Cable Bracket SA6530-001. Welder is identified as 062808. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Weld joint- 110, Located on Cable Bracket SA6030-001. Welder is identified as 062749. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint- 036, Located on Cable Bracket SA6031. Welder is identified as 062808. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

### Heat Straightening:

Heat Straightening being performed on Bike path identified as BK-024-001 between Deck plate to Stinger plate by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Li Ping present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (B) – 10265.

### Bay #16

This QA Inspector observed the following work in progress

#### Shielded Metal Arc Welding (SMAW)

Weld joint- 003, Located on Bike path Hand rails, FS17. Welder is identified as 053753. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

Weld joint- 003, Located on Bike path Hand rails, FS27. Welder is identified as 201905. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

### Bay #14

This QA Inspector observed the following work in progress

#### Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint- 012 as per WRR no. B-WR-20787, Located on Traveler Rail TR 3007 TR2 -001. Welder is identified as 066673. ZPMC Quality Control Inspector (QC) is identified as Liu Fang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-Repair.

Repair welding of Weld joint- 011 as per WRR no. B-WR-20787, Located on Traveler Rail TR 3027 TR2 -001. Welder is identified as 067611. ZPMC Quality Control Inspector (QC) is identified as Liu Fang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-Repair.

#### Flux Cored arc welding (FCAW)

Weld joint- 001/ 002, Located on U Rib Splice plate X3305K-050. Welder is identified as 045240. ZPMC Quality Control Inspector (QC) is identified as Liu Fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

Weld joint- 001/ 002, Located on U Rib Splice plate X3305K-049. Welder is identified as 067876. ZPMC Quality Control Inspector (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

For further information see below pictures:-

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.

### 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.

---

**Inspected By:** Baskar, Govindarajan

Quality Assurance Inspector

---

**Reviewed By:** Clifford, William

QA Reviewer