

**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-024236**Date Inspected:** 01-Jun-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:** Shi Yu**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:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

**Bay 1**

This QA Inspector observed the following work in progress for Bay 1.

ZPMC perform FCAW welding on lifting lug and grinding work on the hand rail and lifting lug,

**Bay 9**

This QA Inspector observed the following work in progress for Bay 9.

ZPMC perform grinding work on the hand rail, Traveler rail and fit up on traveler rail support.

**Bay 10**

This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) of approximately 15 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as follows; Bike Path BK010A on item number 3 & 4 of NWIT tracker document # 09326,

**Bay 11**

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Mao Bin Bin.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Bike Path

PCMK: BK011A8-001-054,055

Welder: 205649

WPS-B-P-2132-ESAB

Bay 14

Heat straightening of PCMK, TR3027TR1-001, under approved Heat Straightening procedure, HSR 1 (B)-10227, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Shen Jian Bo. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 6mm.

This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) of approximately 15 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as follows; SA4025A, B, C on item number 1 of NWIT tracker document # 09331,

Bay 16

This QA Inspector observed the following work in progress for Bay 16.

ZPMC perform FCAW welding on lifting lug and grinding work on the hand rail and lifting lug

Bay 19

This QA Inspector observed the following work in progress for Bay 19.

ZPMC was using the Shield Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Guo Xing Hui.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector

Components: Suspender Bracket

PCMK: SA6529-001-089

Welder: 259906

Report: B-WR21152

WPS-345-SMAW-1G (1F)-Repair-1

PCMK: SA6529-seal plate

Welder: 220338

WPS-B-P-2112

This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) of approximately 15 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as follows; Bike Path BK25A on item number 1 of NWIT tracker document # 09319,

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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

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**Inspected By:** Shin,DJ

Quality Assurance Inspector

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**Reviewed By:** Riley,Ken

QA Reviewer