

**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-024978**Date Inspected:** 03-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:** Xu Le Feng**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 & TOWER Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#10

This QA Inspector observed the following work in progress

Flux Cored Arc Welding (FCAW):

Weld joint #004 located on Bike path BK009A8-001. Welder is identified as 050038. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2313-Tc-P4.

Weld joint #001 located on Bike path BK009A8-001. Welder is identified as 050038. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2312-Tc-P4.

Weld joint #002 located on Bike path BK009A8-001. Welder is identified as 052930. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2314-Tc-P4.

Surface Welding by Shielded Metal Arc Welding (FCAW):

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Surface welding / buttering being performed as per the critical weld repair report B-CWR16924 located on traveler rail identified as 29TR1-001. Welder is identified as 057266. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 2G (2F) – ESAB – Repair. (See attached photo)

### Heat Straightening:

Heat Straightening being performed on Bike path identified as BK010A-001 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Li Jun present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (B) – 10334. (See attached photo)

### BAY#11

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 09017

#### Visual Inspection Testing (VT)

This QA inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as TOWER Component. The identified component designations reviewed are as follows:

#### TOWER HEAD, LIFT-6

Verification of slotted holes on curved diaphragm as per TC-RFI388R1.

This QA Inspector observed the following work in progress

#### Shielded Metal Arc Welding (SMAW):

Weld joint #1A located on Tower head component ESD1-TBSA7-4B/B. Welder is identified as 202354. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-Tc-U4c.

Weld joint #013 located on Tower head component WSD1-TBSA7-4B/B. Welder is identified as 041271. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-Tc-U4c.

Weld joint #006 located on Tower head component ESD1-TBSA7-4B/B. Welder is identified as 202354. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-Tc-U4c.

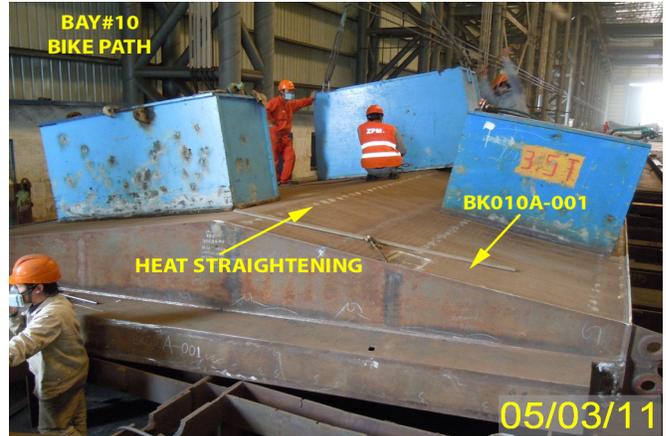
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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## 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 Thomas Ho - 15002048250, who represents the Office of Structural Materials for your project.

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**Inspected By:** Kumar,Sandeep

Quality Assurance Inspector

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**Reviewed By:** Clifford,William

QA Reviewer