

**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-024990**Date Inspected:** 13-Jun-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

<b>CWI Name:</b>	Lei/Wen/Shigang/Feng /Wen	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes	No N/A
		<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG Bike Path	

**Summary of Items Observed:**

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

Bay 11

In Process Inspection SMAW

This QA Inspector observed the following work in progress: SMAW welding of weld joint 010 located on BK012ASD1-001. Welder is identified as 066326. ZPMC Quality Control (QC) is identified as Xu Le Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Visual Inspection

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09453.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BKSA013-001-021, 022, 023, 024, 025, 026, 027, 028, 029, 030, 031, 032, 033, 034, 035, 036, 037, 038

BKSA020-001-005, 007, 009, 020, 021, 011, 010, 012

BK011A6-001-001, 002, 165, 007

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## WELDING INSPECTION REPORT

( Continued Page 2 of 4 )

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BK011A8-001-001, 002, 130, 007

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09454.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BKSA011-001-021, 022, 023, 024, 025, 026, 027, 028, 029, 030, 031, 032, 033, 034, 035, 036, 037, 038, 039, 040, 041, 042, 043, 044, 045, 046, 047, 048, 049, 050, 051, 052, 053, 054, 055, 056, 057, 058, 059, 060, 061, 062, 063, 064, 065, 066, 067, 068, 069, 070, 071, 072, 073, 074

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09455.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK09A1-001-189, 192

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09456.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BKSA015-001-009, 010, 011, 012

BKSA018-001-009, 010, 011, 012

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09457.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK23A6-001-001, 007, 003, 006

BK23A2-001-001, 007, 016, 023, 030

BK23A3-001-012, 013, 036, 037

BK23A4-001-001, 002, 031, 032, 061, 062

BK23A5-001-088, 089, 090, 091, 120, 121, 150, 151

Magnetic Particle Inspection (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09453.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date.

The members are identified as:

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## WELDING INSPECTION REPORT

( Continued Page 3 of 4 )

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BKSA013-001-021, 022, 023, 024, 025, 026, 027, 028, 029, 030, 031, 032, 033, 034, 035, 036, 037, 038  
BKSA020-001-005, 007, 009, 020, 021, 011, 010, 012  
BK011A6-001-001, 002, 165, 007  
BK011A8-001-001, 002, 130, 007

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BK23A2-001-001, 007, 016, 023, 030  
BK23A3-001-012, 013, 036, 037  
BK23A4-001-001, 002, 031, 032, 061, 062  
BK23A5-001-088, 089, 090, 091, 120, 121, 150, 151

### Ultrasonic Testing Inspection (UT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09456.

This QA inspector performed UT of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a UT report for this date.

The members are identified as:

BKSA015-001-009, 010, 011, 012  
BKSA018-001-009, 010, 011, 012

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

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# WELDING INSPECTION REPORT

( Continued Page 4 of 4 )

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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 Eric Tsang at 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Leavitt, Scott	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford, William	QA Reviewer

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