

**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-025873**Date Inspected:** 18-Jul-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

<b>CWI Name:</b>	Sha Zi	<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	

**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 9

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

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

ZPMC QC is identified as Chen Xi Gang.

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: BK002-001-017

Welder: 059378

WPS-B-T-2231-ESAB

PCMK: BKSA11-001-015

Welder: 059418

WPS-B-T-2231-ESAB

PCMK: TR3017TR1-004

Welder: 059443

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

WPS-B-T-2231-ESAB

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

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

ZPMC QC is identified as Chen Xi Gang.

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: Traveler Rail

PCMK: TR3018TR1-001-

Welder: 201840

WPS-B-P-2112

Bay 14

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

ZPMC was performing match drilling on splice plate angles for lifts 13 and 14. ZPMC was also noted performing grinding to smooth the edges of areas that had been cut by Oxygen/Acetylene cutting and removing the burr's caused by drilling.

Bay 16

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

ZPMC was using the Shield Metal Arc Welding (SMAW) process for VT repair welding.

ZPMC QC is identified as Ma Chun Li.

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: Steel Barrier

PCMK: W2-SKYWAY-W1

Welder: 201905

WPS-B-P-2113

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

ZPMC perform grind work for smooth edges, drilling burr and weld cover pass smooth of steel barrier. ZPMC also noted that pre assembly for hand rail, checked straightness, bolt holes locations, and dimension.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as follows; E2-SKYWAY, E5-SKYWAY on item number 1, 2 of NWIT tracker document # 09766,

Bay 19

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

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

ZPMC QC is identified as Ma Chun Li.

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

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: Bike Path  
PCMK: BK9003A-001-  
Welder: 259629  
WPS-B-P-2112

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 Ma Chun Li.

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: Bike Path  
PCMK: BK23A5-001-016  
Welder: 259353  
WPS-B-P-2114

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.

---

<b>Inspected By:</b>	Shin,DJ	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

---