

**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-027186**Date Inspected:** 16-Oct-2010**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**CWI Name:** Chen Xi**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 R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

Bay Number 1

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel, by the lot method testing procedure. This QA Inspector generated an MT report for this date. All components were as listed on NWIT notification no. 06982. The member(s) is/are identified as OBG Barrier Rails. The weld designations reviewed are as follows:

1. E2-SB1-007-001~179.
2. E2-SB5-011-001~179.
3. E2-SB5-005-001~179.
4. E2-SB2-003-001~179.
5. E2-SB1D-016-001~179.
6. E2-SB1D-015-001~179.
7. E2-SB1D-012-001~179.
8. E2-SB1-010-001~179.
9. E2-SB1-004-001~179.

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### Bay Number 2

This QA inspector performed 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. All components were as listed on NWIT notification no.(s) 06976. The member(s) is/are identified as OBG Floor Beams and Sub Assemblies. The weld designations reviewed are as follows:

1. FB3327-001-001, 010, 024, 059, 016, 054, 053, 046, 017, 052, 066, 061, 015, 009, 008, & 005.
2. SA3409-001-015, 063, 059, 052, 017, 053, 046, 054, 042, 024, 018, 001, 016, 005, 008, & 009.

### Bay Number 3

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel, by the lot method testing procedure. This QA Inspector generated an MT report for this date. All components were as listed on NWIT notification no. 06974, 06977, 06985. The member(s) is/are identified as OBG floor beams. The weld designations reviewed are as follows:

1. FB3282-001-001~016.
2. FB3277-001-001~016.
3. FB3283-001-001~016.
4. FB3276-001-001~016.
5. FB3275A-001-007, & 008.
6. FB3268-001-026, 027, 032, & 033.
7. FB3275A-001-001, 002, 005, & 006.
8. FB3268-001-028~031.

### Bay Number 4

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) sub assembly member identified as SA3362-001. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Chen Xi was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) no. HSR1-9614.

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) sub assembly member identified as SA3361-001. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Chen Xi was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) no. HSR1-9615.

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents

### Summary of Conversations:

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Pertinent conversations are included in the body of the report.

## **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 1500-0042-02372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hernandez,Rene	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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