

**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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004799**Date Inspected:** 23-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Sei Fa**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 Components**Summary of Items Observed:**

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

**Bay 8 - OBG Sub Assembly**

This QA Inspector observed ZPMC welding personnel performing Flux Core Arc Welding (FCAW) of tower double diaphragm component weld designated as North Shaft / 18m. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

This QA Inspector observed ZPMC welding personnel performing Flux Core Arc Welding (FCAW) of tower double diaphragm component weld designated as WSD1-SA415. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

**Bay 7 – OBG Sub Assembly**

This QA Inspector observed ZPMC welding personnel performing Flux Core Arc Welding (FCAW) of CJP on OBG floor beam assembly designated as FB039-002-148. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

This QA Inspector observed ZPMC welding personnel performing Flux Core Arc Welding (FCAW) of CJP on OBG floor beam assembly designated as FB024-004-146. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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This QA Inspector observed ZPMC welding personnel performing Flux Core Arc Welding (FCAW) of CJP on OBG floor beam assembly designated as FB023-003-146. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

### Bay 3 – OBG Sub Assembly

This QA Inspector observed ZPMC welding personnel performing automated in gantry Flux Core Arc Welding (FCAW) of stiffener to bottom plate welds designated as BP148-001-001, BP040-001, BP121-001, and BP175-001. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

This QA Inspector observed continued Shielded Metal Arc Welding (SMAW) tack welding and fit-up of edge panel components designated as: EP091-001 and EP071-001.

This QA Inspector observed ZPMC welding personnel performing Flux Core Arc Welding (FCAW) of Complete Joint Penetration (CJP) at WT stiffeners for OBG bottom panels. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure. Component numbers are designated as: BP127-001-004/003 and BP073-001-006/005.

### Bay 1 - OBG Sub Assembly

This QA Inspector observed continued Gas Metal Arc Welding (GMAW) tack welding and fit-up of closed rib components to deck plates designated as: DP472-001, DP260-001, DP369-001 and DP368-001.

### Tracking and Log Book

This QA Inspector reviewed the contract files and tracking logs for the Magnetic Particle Testing (MT), Ultrasonic Testing (UT), Welding Procedure Specifications (WPS), Procedure Qualification Records (PQR), and QC Inspector records for the deck panel repairs to date.

### 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 Peter Dautermann (858) 232-6799, who represents the Office of Structural Materials for your project.

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

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