

**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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005667**Date Inspected:** 22-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Chih Ming**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 Segments**Summary of Items Observed:**

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

This QA Inspector observed the following work in progress:

Bay 14 OBG Assembly

Segment 7CE

Flux Cored Arc Welding (FCAW) on root pass of weld joint SEG038A-003 located on SP573A to SP613A.

Welder is identified as 052696. ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 6AE

Submerged Arc Welding (SAW) of weld joint SEG028B-031 located on BP113A to SP361A. Welder is identified as 048296. ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 7CE

Submerged Arc Welding (SAW) of weld joint SEG038A-006 located on BP64A to BP118A. Welder is identified as 048296. ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

## Segment 1BE

Flux Cored Arc Welding (FCAW) of weld joint DP616-001-082, 087, 092, 097, 102, 107, 112 located on Floor Beam Diaphragm X98G to DP616.

DP611-001-112, 107, 102, 097, 092, 087, 082 located on Floor Beam Diaphragm X98F to DP611.

DP596-001-092, 087, 084, 079, 076, 071, 068, 063, 060, 053 located on Floor Beam Diaphragm X98F to DP596.

Welders are identified as 044801. ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

## Bay 13 OBG Assembly

### Segment 1BE

Flux Cored Arc Welding (FCAW) of weld joint SSD49A-PP12-130 located on FB6A to FB59A. Welder is identified as 067665.

FCAW of weld joint SSD47-PP11-130 located on FB6A to FB59A. Welder is identified as 067661.

FCAW of weld joint SSD49-PP12-124, 125 located on FB59A to LD29A. Welder is identified as 044774.

FCAW of weld joint SSD49A-PP12-139 located on FB77B to LD30A. Welder is identified as 051356.

ZPMC QC is identified as Huang Shuai. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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, 150-0042-2372, who represents the Office of Structural Materials for your project.

---

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

---