

**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-005698**Date Inspected:** 01-Mar-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 13 OBG Assembly

Segment 2BE

Flux Cored Arc Welding (FCAW) of weld joint SEG010B-017 located on LD6D to BP196A. Welder is identified as 067079. ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Shielded Metal Arc Welding (SMAW) of weld joint SEG010B-003 located on FB16A to LD1A. Welder is identified as 067609. ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Shielded Metal Arc Welding (SMAW) of weld joint SSD19A-PP18-135 located on FB2B to FB3A. Welder is identified as 044837. ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Shielded Metal Arc Welding (SMAW) of weld joint SSD19-PP18-139 located on FB16A to FB3A. Welder is

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## WELDING INSPECTION REPORT

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identified as 044837. ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

### Segment 2BW

Flux Cored Arc Welding (FCAW) of weld joint SSD13A-PP18-107 thru 124, 69 thru 104 located on FB4A to BP193A and BP191A. Welder is identified as 066359. ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

### Segment 2BE

QA Inspector observed the stiffener plates on Longitudinal Diaphragms LD6D, LD1A, LD11C, LD8D, LD2A and LD12C were fillet welded to Bottom Plates BP196A and BP194A. The stiffener plates are designed to be tight fit bearing on the bottom plate as detailed on the approved Segment Assembly Standard Sections drawing SEGSD29.

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.

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

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