

**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-006265**Date Inspected:** 14-Apr-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:** Huang Wen pang**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 Counter Weight / Floor Beam**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

**OBG # BAY 1**

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. The member is identified as Counter Weight. The weld designations reviewed are as follows:

(CW001B-PP042-001,002,003)

(CW001B-PP046-001,002,003)

(CW001B-PP030-001,002,003)

**OBG # BAY 3**

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. The member is identified as Floor Beam. The weld designations reviewed are as follows:

(FB012-026-043)

(FB010-028-043)

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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(FB009-022-043)

This QA Inspector randomly observed the following work in progress:

OBG # BAY 2

FCAW Process:

Welding of weld joint –013,014 located on PCMK FB009-032. Welder is identified as 205091. ZPMC QC is identified as Huang Wen pang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

OBG # BAY 3

FCAW Process:

Welding of weld joint –021 located on PCMK FB027-008. Welder is identified as 044830. ZPMC QC is identified as Huang Wen pang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

Welding of weld joint –011 located on PCMK LD012-012. Welder is identified as 044790. ZPMC QC is identified as Huang Wen pang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint –011 located on PCMK LD013-008. Welder is identified as 066164. ZPMC QC is identified as Huang Wen pang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint –011 located on PCMK LD020-006. Welder is identified as 044824. ZPMC QC is identified as Huang Wen pang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

**Summary of Conversations:**

No Relevant Conversation

**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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# WELDING INSPECTION REPORT

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