

**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-007355**Date Inspected:** 31-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Fa Wen**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:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

**OBG Trial Assembly Area-**

During random visual inspection of OBG segment 1AE to 1BE deck panel Complete Joint Penetration weld OBE1-006 joint fit up, the QA Inspector observed the gap between the bottom of the Deck Plate and steel backing was up to 9 mm for a length of approximately 500 mm. This exceeds the 2mm gap allowed by AWS D1.5 (2002). An Incident report was issued for the noncompliant joint fit up this date. ZPMC QC stated that the backing would be repaired prior to welding. Please see the attached photos below

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Traveler railing brackets for TR-13BT1-73 through 096.

**Bay 13-**

QA Inspector observed the following work in progress: SAW welding of weld joint 006 Deck Panel DP120A to DP147A Butt Splice. ZPMC welder was identified as 058100. ZPMC QC is identified as Liu Fa Wen. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-B-L2c-S-2.

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# WELDING INSPECTION REPORT

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Bay 14-

QA Inspector observed the following work in progress: SAW welding of weld joint 006 Bottom Panel BP76A to BP130A Butt Splice. ZPMC welder was identified as 044755. ZPMC QC is identified as Liu Fa Wen. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-B-L2c-S-2.

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



## Summary of Conversations:

As identified within the contents of this 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, 150 0042 2372, who represents the Office of Structural Materials for your project.

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

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