

**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-008174**Date Inspected:** 29-Jul-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

<b>CWI Name:</b>	Zhu Tian Shu / Liu fa wen / Li yan			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	OBG Components		

**Summary of Items Observed:**

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

**BAY#5**

This QA inspector performed 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 member is identified as a Traveler Bracket. The weld designations reviewed as follows:

TR3A-PP9-01 to 02.

TR3B-PP9-03 to 04.

TR2D-PP10-07 to 08.

TR2E-PP10-09 to 10.

Ongoing FCAW Welding of Weld Joint 3F-023 Located on BK001-023 Welder no identified as 0215185 and The welding variables recorded by QC ZMPC Mr.Wang Liang to comply with the WPS-B-T-2133.

**BAY#6**

Ongoing SMAW Welding of Weld Joint 2G-1B Located on WD1-A305-65m-2 Welder no identified as 37780 and The welding variables recorded by QC ZMPC Mr.Shi Yu to comply with the WPS-B-T-3212-Tc-U5b-1.

Ongoing Fit-up of Floor Beam for CB9 checked with ZPMC QC Mr.Liu fa wen.

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## WELDING INSPECTION REPORT

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Ongoing ZPMC UT on ND1-SA658-65m-7-1A witnessed, Technician name found as Mr.Dai geng sheng.

During random verification Magnetic Particle Testing of the internal components of OBG Bottom Plate, Caltrans Quality Assurance (QA) Inspector discovered one Transverse indication from 10mm to 15mm in length in the weld metal location BP3019-001-108. These areas have not been previously tested and accepted by ZPMC Quality Control MT Technicians.

For further information, please see the Incident report 040120F4\_TL-015\_B255\_07-29-09 Bottom plate\_MT\_Transverse\_Indication.

BAY#7

Ongoing FCAW Semi automatic Welding of Weld Joint 2F-067 Located on BP3003A Welder no indentified as 053669 and The welding variables recorded by QC ZMPC Mr.Zhou Jie to comply with the WPS-B-T-2132-3.

BAY#3

Green Tag issued for the following items after NDT carried out successfully.

SSD11-PP105-009721.

SSD16-PP098-009722.

Unless otherwise noted, all 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 Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

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

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