

**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-008118**Date Inspected:** 05-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**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 Assembly**Summary of Items Observed:**

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

The QA Inspector randomly observed the following work in progress:

OBG Bay No. 14

Shielded Metal Arc Welding (SMAW) of weld joint SSD 19A - PP79 weld number 127 for OBG Segment 9AE. The ZPMC welder identified as 043661 was welding in the 4G position. The ZPMC QC identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-P-2214-Tc-U2b-FCM-1.

Flux Cored Arc Welding (FCAW) of weld joint DP 396 - 001, weld numbers 59, 60, 64, 65, 69, 70, 72, 73, 77, 78, 80, 81, 85, 88, 89, 93 and 94 for OBG Segment 9EE. The ZPMC welder identified as 066825 was welding in the 3F position. ZPMC QC is identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2133.

Flux Cored Arc Welding (FCAW) of weld joint DP 396 - 001, weld numbers 58, 63, 68, 71, 76, 79, 84, 87 and 92 for OBG Segment 9EE. The ZPMC welder identified as 066825 was welding in the 3G position. ZPMC QC identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2233-Tc-U4b-F.

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## WELDING INSPECTION REPORT

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Flux Cored Arc Welding (FCAW) of weld joint SEG062; weld number 002 located on OBG Segment 10BE. The ZPMC welder identified as 0488038 was welding in the 1G position. ZPMC QC identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2231-B-U2-F.

Flux Cored Arc Welding (FCAW) of weld joint DP 396 - 001, weld numbers 11, 17, 22, 26, 31, 35, 40, 44 and 49 for OBG Segment 9EE. ZPMC welder identified as 066825 was welding in the 3G position. ZPMC QC identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2233-Tc-U4b-F.

Flux Cored Arc Welding (FCAW) of weld joint CSD2 - PP 71.5, weld numbers 085 ~ 090 for OBG Segment 9AW Corner Assembly CA 056. ZPMC welder identified as 045203 was welding in the 2F position. ZPMC QC is identified as Li Ming Yang was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2132.

Flux Cored Arc Welding (FCAW) of weld joint CSD2 - PP 71.5, weld numbers 091 ~ 098 for OBG Segment 9AW Corner Assembly CA 056. ZPMC welder identified as 045203 was welding in the 3F position. ZPMC QC is identified as Li Ming Yang was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-4133.

On this date the QA inspector observed ZPMC personnel installing the FL3 floor beam at the PP86 location for SEG. 10AE.

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

### Summary of Conversations:

No relevant conversations spoken on this date.

### 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 (15000422372), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	McClendon, Timothy	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson, Rodney	QA Reviewer

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