

**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-008129**Date Inspected:** 01-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Du Zhi Qun**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:** Tower&OBG**Summary of Items Observed:**

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

BAY#11

This QA Inspector randomly observed the following work in progress

SAW welding process of weld joint 146B located on PCMK ESD1-A67-2. Welder is identified as 044558 ZPMC QC is identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2C-S-2.

BAY#10

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 5 located on PCMK NSD1-FCSA4-1B/C. Welders are identified as 054069 ZPMC QC is identified as Du Zhi Qun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

FCAW welding process of weld joint 19 located on PCMK NSD1-FCSA4-1C/C. Welders are identified as 040349 ZPMC QC is identified as Du Zhi Qun. The welding variables recorded by QC appeared to comply with

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# WELDING INSPECTION REPORT

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the WPS-B-T-2332-TC-P5-F.

FCAW welding process of weld joint 6 located on PCMK NSD1-FCSA4-1B/C. Welders are identified as 053116 ZPMC QC is identified as Du Zhi Qun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

FCAW welding process of weld joint 20 located on PCMK NSD1-FCSA4-1C/C. Welders are identified as 047350 ZPMC QC is identified as Du Zhi Qun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

## TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

### OBG SEGMENT-4AW

SMAW welding process of weld joint 005 located on PCMK SSD13-PP024. Welder is identified as 048617 ZPMC QC is identified as Zhang Quing. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F) Repair.

### OBG SEGMENT-4BW

SMAW welding process of weld joint 005 located on PCMK SSD12-PP028. Welder is identified as 220067 ZPMC QC is identified as Zhang Quing. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F) Repair.

Unless otherwise noted, all work observed on this dated 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 Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

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

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