

**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-008138**Date Inspected:** 07-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.

This QA Inspector randomly observed the following work in progress:

OBG Assembly Bay 14

On this date the QA inspector observed ZPMC personnel installing FL2 floor beam segment at the PP92 location for SEG. 10AE.

Flux Cored Arc Welding (FCAW) of weld joint DP 315 - 001, weld numbers 62, 67, 72, 75, and 80 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 DP 315 - 001, weld numbers 64, 69, 73, 74, 76, 77, 81, and 82 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 315 - 001, weld numbers 65, 66, 70, 71, 78, and 89 for OBG

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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Segment 9EE. The ZPMC welder identified as 066825 was welding in the 2F 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-2132.

Flux Cored Arc Welding (FCAW) of weld joint SEG 052A weld number 020 for OBG Segment 9BE. The ZPMC welder identified as 044795 was welding in the 1G 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-T-2231-B-U2-F.

Shielded Metal Arc Welding (SMAW) of weld joint SEG 050A - PP72 weld number 139 and 135 for OBG Segment 9AE. The ZPMC welder identified as 043661 was welding in the 4F 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-2114-FCM-1.

The QA inspector observed ZPMC UT personnel rejected 2 areas on SSD19 – PP72 weld number 129 on SEG 9AE. ZPMC UT personnel also inspected weld number 129 on SSD19 – PP73 on SEG 9AE and found no rejectable indications.

Flux Cored Arc Welding (FCAW) of weld joint CA58A CSD7 – PP7 weld number 023, 027, 031 for OBG Segment 9AE. The ZPMC welder identified as 051356 was welding in the 3G 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-T-2233-Tc-U4b-F.

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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