

**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-008616**Date Inspected:** 07-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:** Wu Zhi Chen, Peng Guo**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 & Tower**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.

**TRIAL ASSEMBLY YARD**

This QA Inspector randomly observed the following work in progress

**OBG segment 1AAW-1AW**

FCAW welding process of weld joint 003 located on PCMK OBW1A. Welder is identified as 200676 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T.

FCAW welding process of weld joint 003 located on PCMK OBW1A. Welder is identified as 053742 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T.

**OBG segment 1AAE-1AE**

FCAW welding process of weld joint 003 located on PCMK OBE1A. Welder is identified as 050316 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T.

FCAW welding process of weld joint 003 located on PCMK OBE1A. Welder is identified as 045309 ZPMC QC is

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identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T.

FCAW welding process of weld joint 001 located on PCMK OBE1A. Welder is identified as 220067 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T-1.

FCAW welding process of weld joint 002 located on PCMK OBE1A. Welder is identified as 058240 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T-1.

FCAW welding process of weld joint 004 located on PCMK OBE1A. Welder is identified as 220067 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T-1.

OBG segment 3AE-3BE

This QA Inspector observed ZPMC NDT Inspector performing Magnetic Particle testing (MT) on the repair area of weld joint between deck panel diaphragms to floor beam flange at PP22.

OBG segment 4AE-4BE

This QA Inspector observed ABF NDT Inspector performing Magnetic Particle Testing on the weld joint between deck panel diaphragms to floor beam flange at PP21.

OBG segment 4AW-4BW

This QA Inspector observed ABF NDT Inspector performing Magnetic Particle Testing on the repair area of weld joint between deck panel diaphragms to floor beam flange at PP25.

OBG segment 2AW-2BW

This QA Inspector observed ZPMC personnel performing carbon air arc gouging on the weld joint between deck panel diaphragms to floor beam flange at PP16.

BAY#11

This QA Inspector randomly observed the following work in progress

FCAW welding process of weld joint 42 located on PCMK ESD1-FDSA4-2C/D. Welder is identified as 068865 ZPMC QC is identified as Peng Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

FCAW welding process of weld joint 4 located on PCMK ESD1-FDSA4-2C/D. Welder is identified as 066683 ZPMC QC is identified as Peng Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

FCAW welding process of weld joint 41 located on PCMK ESD1-FDSA4-2C/D. Welder is identified as 069043

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ZPMC QC is identified as Peng Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

FCAW welding process of weld joint 26 located on PCMK ESD1-FDSA4-2C/D. Welder is identified as 066484  
ZPMC QC is identified as Peng Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

FCAW welding process of weld joint 01 located on PCMK ESD1-FDSA4-2C/D. Welder is identified as 066882  
ZPMC QC is identified as Peng Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

Unless otherwise noted, all work observed on this dated 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 Eric Tsang + (86) 15000422372, 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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