

**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-008619**Date Inspected:** 11-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, Tu Jun**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

OBG segment 3AE-3BE

## Magnetic Particle Inspection

This Q.A Inspector performed Magnetic Particle Testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (MT) report for this date. The members are identified as the OBG segment 3AE the welds Designation are as follows.

SEG014-20, 21

SEG014A-005

LD019-001-013, 014, 015

## TRIAL ASSEMBLY YARD

OBG segment 3AE-3BE

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## Ultrasonic Inspection

This Q.A Inspector performed Ultrasonic Testing of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (UT) report for this date. The members are identified as the OBG segment 3AE the welds Designation are as follows.

SEG014A-005

LD019-001-013, 014, 015

## TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

### OBG SEGMENT-1AAW-1AW

FCAW welding process of weld joint 571 located on PCMK SEG1E. Welder is identified as 220066 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U3-F.

FCAW welding process of weld joint 574 located on PCMK SEG1E. 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-2233-B-U3-F.

FCAW welding process of weld joint 546 located on PCMK SEG1E. Welder is identified as 220069 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U3-F.

### BAY#10

This QA Inspector randomly observed the following work in progress.

SAW welding process of weld joint 82B located on PCMK NSTL3-3B/K. Welder is identified as 227745 PMC QC is identified as Li Feng fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2B-S.

SAW welding process of weld joint 82B located on PCMK NSTL3-3B/K. Welder is identified as 051413 PMC QC is identified as Li Feng fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2B-S.

FCAW welding process of weld joint 64 located on PCMK SSSL3-1C/K. Welder is identified as 201825 PMC QC is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F.

FCAW welding process of weld joint 152 located on PCMK SSSL3-1C/K. Welder is identified as 052766 PMC

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# WELDING INSPECTION REPORT

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QC is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-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 Jim Simonis - 134-7246-3441, 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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