

**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-008636**Date Inspected:** 13-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 / Shen Fu You**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 Bay No. 19

The QA inspector performed a random Magnetic Particle (MT) verification on Cross Beam Bottom Panel BP - 026 - 009 after ZPMC performed 100% MT and discovered a 70mm long longitudinal linear indication on weld number 005. A incident report was written on this issue. See attached photograph for additional information.

OBG Assembly Bay 14

On this date the QA inspector observed ZPMC personnel installing longitudinal diaphragm LD001-028 between PP77 and PP78 for SEG. 9CE.

On this date the QA inspector observed ZPMC personnel installing longitudinal diaphragm LD001-029 between PP78 and PP79 for SEG. 9CE.

On this date the QA inspector observed ZPMC personnel installing longitudinal diaphragm LD011-013 between PP76 and PP77 for SEG. 9CE.

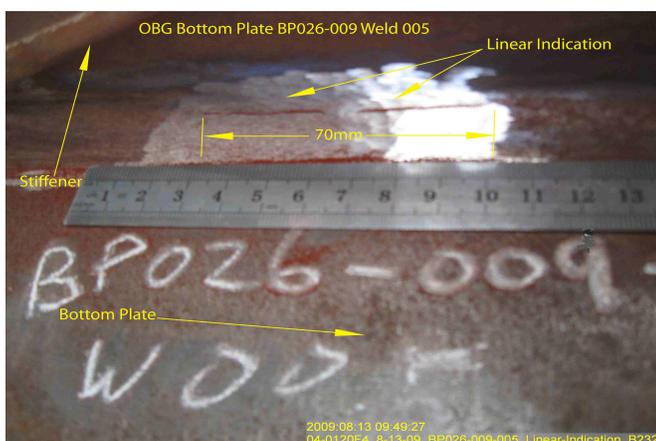
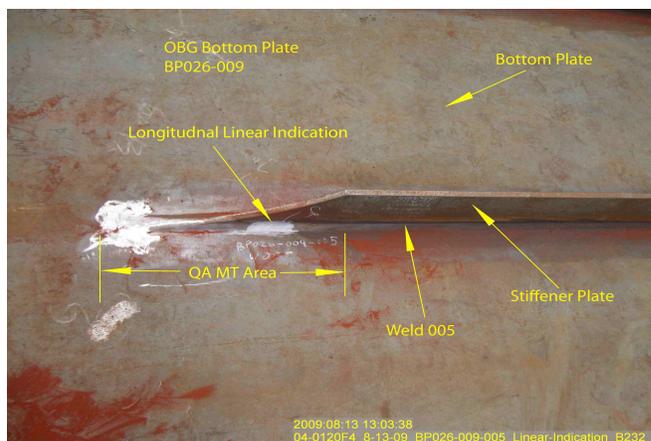
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Flux Cored Arc Welding (FCAW) of weld joint SEG052 - SSD18 - PP76 for OBG Floor Beam Flange weld number 003 for Segment 9BE. The ZPMC welders identified as 044801 was welding in the 1G position. The ZPMC QC identified as GZhong Guo Hui was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2131-B-U2a-F.

Flux Cored Arc Welding (FCAW) of weld joint SEG052 - SSD18A - PP76 for OBG Floor Beam Flange weld number 003 for Segment 9BE. The ZPMC welders identified as 044801 was welding in the 1G position. The ZPMC QC identified as GZhong Guo Hui was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2131-B-U2a-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
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<b>Reviewed By:</b>	Patterson, Rodney	QA Reviewer
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