

**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-008689**Date Inspected:** 25-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 Assembly Bay 14

The QA inspector observed UT inspection was performed by ZPMC personal on Longitudinal Diaphragm welded to bottom panel on SEG 052C between PP74 and PP75 Weld 026/027. Two locations were changed from a fillet weld to a CJP weld due to a root opening of greater than 5mm. In one location ZPMC UT technician marked six areas with rejectable indications on one weld area and five areas of rejectable indications on the other weld area.

Flux Cored Arc Welding (FCAW) of weld joint SEG054C for OBG Assembly Longitudinal Diaphragm welded to bottom panel weld number 027 and 028 for Segment 9CE. The ZPMC welders identified as 214945 was welding in the 2F position. The ZPMC QC identified as Zhong 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-2132.

Shielded Metal Arc Welding (SMAW) of fillet welds of T-Stiffeners to Side Panel SP587 - 001 OBG assembly weld number 014, 016, 018, 020, 022, 024 for Segment 9DE. 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

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WPS-B-T-2114-B-U2-FCM-1.

Shielded Metal Arc Welding (SMAW) of fillet welds of T-Stiffeners to Side Panel SP627 - 001 OBG assembly weld number 014, 016, 018, 020, 022, 024 for Segment 9DE. 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-T-2114-B-U2-FCM-1.

Shielded Metal Arc Welding (SMAW) of fillet welds of T-Stiffeners to Side Panel SP626 - 001 OBG assembly weld number 013, 015, 017, 019, 021, 023 for Segment 9DE. The ZPMC welder identified as 200112 was welding in the 2F 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-2112-FCM-1.

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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