

**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-008873**Date Inspected:** 15-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi/ Sun Wei**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 Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

**Bay #3**

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

- ( CA066-019~024, 101, 102)
- ( CA060-079~984, 111, 112)
- ( CA060-019~024, 101, 102)
- ( CA060-055~060, 107, 108)
- ( CA060-043~048, 105, 106)
- ( CA070-031~036, 103, 104)
- ( CA057-027~032, 067, 068)
- ( CA057-039~044, 069, 070)
- ( CA063-031~036, 103, 104)
- ( CA063-079~084, 111, 112)
- ( CA063-055~060, 107, 108)
- ( CA063-019~024, 101, 102)
- ( CA063-043~048, 105, 106)
- ( CA069-079~084, 111, 112)

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- ( CA064-019~024-101, 102)
- ( CA069-055~060, 107, 108)
- ( CA069-019~024, 101, 102)
- ( CA058-039~044, 069, 070)
- ( CA069-031~036, 103, 104)
- ( CA066-079~084, 111, 112)

### Bay #2

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

- ( FB6501-001-026)
- ( FB3019-001-017, 018, 001)
- ( FB3024-001-001, 018)

### Bay #3

This QA inspector observed that all the required NDT work completed on following items and ready for green tag. This QA Inspector issued green tag for the following items. The member is identified as OBGComponents. The weld designations reviewed are as follows:

- CA057-071, 072 Green Tag#9909
- CA064-101, 102 Green Tag#9910
- CA070-103, 104 Green Tag#9911
- CA060-111, 112 Green Tag#9912
- CA064-103, 104 Green Tag#9913
- CA057-069, 070 Green Tag#9914
- CA058-067, 068 Green Tag#9915
- CA066-101, 102 Green Tag#9916
- CA063-109, 110 Green Tag#9917
- CA060-105, 106 Green Tag#9918
- CA069-105, 106 Green Tag#9919
- CA064-111, 112 Green Tag#9920
- CA063-105, 106 Green Tag#9921
- CA069-111, 112 Green Tag#9922
- CA057-065, 066 Green Tag#9923
- CA058-071, 072 Green Tag#9924
- CA064-109, 110 Green Tag#9925
- CA069-101, 102 Green Tag#9926
- CA058-065, 066 Green Tag#9927
- CA066-107, 108 Green Tag#9928
- CA060-107, 108 Green Tag#9929
- CA064-105, 106 Green Tag#9930
- CA070-101, 102 Green Tag#9931
- CA069-103, 104 Green Tag#9932
- CA070-107, 108 Green Tag#9933

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CA060-101, 102 Green Tag#9934  
CA069-109, 110 Green Tag#9935  
CA064-107, 108 Green Tag#9936  
CA070-111, 112 Green Tag#9937  
CA066-109, 110 Green Tag#9939  
CA063-107, 108 Green Tag#9940  
CA066-111, 112 Green Tag#9941  
CA070-109, 110 Green Tag#9942  
CA058-069, 070 Green Tag#9943  
CA057-067, 068 Green Tag#9944  
CA070-105, 106 Green Tag#10199  
CA060-109, 110 Green Tag#10200  
CA066-103, 104 Green Tag#10201  
CA063-103, 104 Green Tag#10202  
CA066-105, 106 Green Tag#10203  
CA060-103, 104 Green Tag#10204  
CA063-101, 102 Green Tag#10205  
CA063-111, 112 Green Tag#10206

This QA inspector observed the following work in progress:

Bay#2

SAW welding of weld joint FB6502-001-023, 031 located on FB6502-001. Welder is identified as 207237(1G). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SAW welding of weld joint FB3010-001-023, 031 located on FB3010-001. Welder is identified as 250050(1G). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay#3

SAW welding of weld joint CB202B-014-003/004 located on CB202B-014. Welder is identified as 062406 (1G). ZPMC QC-CWI is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all observed on this date 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 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Patel,Hiranch	Quality Assurance Inspector
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<b>Reviewed By:</b>	Prue,Erik	QA Reviewer
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