

**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-008968**Date Inspected:** 05-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**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**Summary of Items Observed:**

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

Bay 2:

This QA Inspector observed the following work in progress: SAW welding of Deck Panel DP97A to DP124 splice weld SEG053-002. ZPMC welder was identified as 045270. ZPMC QC is identified as Li Zhi Jiang. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-B-L2C-S-2.

Bay 3-

This QA inspector performed Magnetic Particle Testing (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 was identified as OBG Cross beam 14 Floor Beams, FB204-041, FB204-043, FB205-041, FB205-043, FB205-044 and FB205-044. The weld identification numbers are as follows. FB204-041-056, 016, 013, 020, FB204-043-038, 046, 067, 068, FB205-041-014, 016, 017, 034, FB205-043-019, 020, 023, 034, FB205-044-014, 016, 023, 034 and FB205-044-007, 009, 010, 012, 027.

Bay 5:

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## WELDING INSPECTION REPORT

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This QA Inspector observed the following work in progress: FCAW welding OBG Bike Path Cantilever beam weld BK001-019-003. ZPMC welder was identified as 058174. ZPMC QC is identified as Li Yang. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2231-TC-U4c-F-1.

Bay 9:

This QA Inspector observed the following work in progress: FCAW welding OBG Deck Panel internal U rib diaphragm welds DP3028-001-316 and 317. ZPMC welder was identified as 059443. ZPMC QC is identified as Guo Yan Fei. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2233-TC-U4b-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation between QA and QC occurred 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, 150 0042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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