

**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-009134**Date Inspected:** 12-Sep-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

<b>CWI Name:</b>	Wan Wen Zhong, Shen Fu You	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes	No N/A
		<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	Tower/OBG	

**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.

BAY#14

This QA Inspector randomly observed the following work in progress.

SMAW welding process of weld joint 127 located on PCMK SSD13A-PP73. Welder is identified as 205718ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4B-FCM-1.

SMAW welding process of weld joint 004 located on PCMK SSD16A-PP80. Welder is identified as 044753ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

BAY#10

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 03 located on PCMK NSD1-FESA4-3D/F. Welder is identified as 053869ZPMC QC is identified as Wan Wen Zhong. The welding variables recorded by QC appeared to comply

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with the WPS-B-T-4332-TC-P4-F-1.

FCAW welding process of weld joint 03 located on PCMK NSD1-FESA4-3C/F. Welder is identified as 057244ZPMC QC is identified as Wan Wen Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F-1.

FCAW welding process of weld joint 07 located on PCMK NSD1-FESA4-3B/F. Welder is identified as 052075ZPMC QC is identified as Wan Wen Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F-1.

FCAW welding process of weld joint 03 located on PCMK NSD1-FESA4-3D/F. Welder is identified as 040533ZPMC QC is identified as Wan Wen Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F-1.

FCAW welding process of weld joint 07 located on PCMK NSD1-FESA4-3B/F. Welder is identified as 040338ZPMC QC is identified as Wan Wen Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F-1.

FCAW welding process of weld joint 03 located on PCMK NSD1-FESA4-3C/F. Welder is identified as 057180ZPMC QC is identified as Wan Wen Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F-1.

FCAW welding process of weld joint 10 located on PCMK NSD1-FASA4-1A/E. Welder is identified as 040343ZPMC QC is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P4-F.

FCAW welding process of weld joint 98 located on PCMK SSTL3-1C/K. Welder is identified as 050041ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2A-F-1.

BAY#11

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 41 located on PCMK ESTL3-4-1C/K. Welder is identified as 068206 ZPMC QC is identified as Zhong Zhi Neng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2A-F-A

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT-4AW-4BW

This QA Inspector observed ZPMC personnel performing spray painting on deck panel 'U' rib at PP24-25.

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**OBG SEGMENT-1AAW-1AW**

This QA Inspector observed ABF Inspector performing Magnetic Particle Testing on the weld joint between 'I' rib to bottom panel on hold back weld area at near the PP8.5.

**OBG SEGMENT-3AE-3BE**

This QA Inspector observed ZPMC personnel performing sand blasting on bike path side longitudinal diaphragm in between PP21 to PP22.

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 Serge Sinevod 13482570045, 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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