

**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-009389**Date Inspected:** 05-Oct-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

**CWI Name:** Tu Jun, Li Lin  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** Yes No N/A  
**Approved WPS:** Yes No N/A  
**Delayed / Cancelled:** Yes No N/A

**Bridge No:** 34-0006**Component:** 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 #11**

This QA Inspector randomly observed the following work in progress.

SMAW welding process of weld joint 81A located on PCMK WSTL3-4B/K. Welder is identified as 058009 ZPMC QC is identified as Cao Cheng. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F) Repair. The weld repair report noted as T-WR2046. ZPMC UT report identified as T787-UT-2177.

**BAY #10**

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 79 located on PCMK NSTL3-3B/K. Welder is identified as 057180 ZPMC QC is identified as Tu Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-P4-F-2.

FCAW welding process of weld joint 080 located on PCMK NSTL3-3B/K. Welder is identified as 053116 ZPMC

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QC is identified as Tu Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4-F-2.

FCAW welding process of weld joint 078 located on PCMK NSTL3-3B/K. Welder is identified as 054069 ZPMC QC is identified as Tu Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P4-F-2.

FCAW welding process of weld joint 077 located on PCMK NSTL3-3B/K. Welder is identified as 053870 ZPMC QC is identified as Tu Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4-F-2.

## TRIAL ASSEMBLY YARD

### OBSERVATIONS

#### OBG SEGMENT-1AAE-1AE

This QA Inspector observed the bottom panel splice joint between OBG segment 1AAE and 1AE observed excavated at one location. The excavation located approximately 3400mm from bike path side longitudinal diaphragm. The length, width and depth of excavation measured approximately 170x40x25mm.

This QA Inspector observed ZPMC NDT Inspector performed ultrasonic inspection on deck panel splice joint between OBG segment 1AAE and 1AE and observed transverse indication mark on weld at different 16 locations.

#### OBG SEGMENT-1AAW-1AW

This QA Inspector observed the deck panel splice joint between OBG segment 1AAW and 1AW observed excavated at 6 different locations. The lengths of excavation and location as below from cross beam side.

Excavation located	Length of excavation
1) 660mm to 3030mm	2370mm
2) 7810mm to 7920mm	110mm
3) 10300mm to 10670mm	370mm
4) 19600mm to 19710mm	110mm
5) 20760mm to 20870mm	110mm
6) 21840mm to 23400mm	1560mm

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

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your project.

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**Inspected By:** Utekar,Shrikant

Quality Assurance Inspector

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**Reviewed By:** Dawson,Paul

QA Reviewer