

**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-009439**Date Inspected:** 02-Oct-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:** Shen Fu You/Li Yan Hua**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.

**Segment 7EW**

FCAW welding (repair) of weld joint SSD13-PP059-004 located on Segment 7EW-PP059. Welder is identified as 045280 (2G). ZPMC QC is identified as Zhon Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-FCAW-2G (2F)-Repair.

FCAW welding (repair) of weld joint SSD13-PP059-004 located on Segment 7EW-PP059. Welder is identified as 067103 (2G). ZPMC QC is identified as Zhon Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-FCAW-2G (2F)-Repair.

**Segment 10BW**

FCAW welding of weld joint Seg061\*-003 located on Segment 10BW. Welder is identified as 050316 (1G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-B-U2-F.

**Segment 9DW**

FCAW welding of weld joint DP098-001-008, 009, 014, 015 located on Segment 9DW. Welder is identified as 045175, 201215, and 050316(3F). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233.

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# WELDING INSPECTION REPORT

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Segment11DW

SAW welding of weld joint Seg071A-003 located on Segment 11DW. Welder is identified as 058100 (1G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-BL2c-S-2.

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
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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