

**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-009441**Date Inspected:** 05-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**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/Tower 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.

**9BE**

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:

-(Seg052\*-046)

**7DE**

This QA inspector performed UT (After Repair) 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:

-(SSD16A-PP56-003, 004)

**South Tower Lift1**

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:

-(E74-SSD1-E-33M-003(1, 2, 3), 004(1, 2, 3))

**Segment 9DE**

# WELDING INSPECTION REPORT

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This Quality Assurance Inspector (QA) observed that the contractor has deviated the contract drawings and changed a fillet weld to a complete joint penetration (CJP) to weld#SSD17-PP81-138/139 without the prior approval of the Engineer. During in process visual inspection of excavated area by carbon arc gouging, this QA inspector found a total of one (1)120mm long linear indication inside the excavation. This QA inspector notified ZPMC QC Mr. Wang Xu of the above mentioned issue, and ZPMC personal proceeded to excavate the linear indication without prior approval of the engineer. For further information, see incident report on this date.

Bay 14

FCAW welding of weld joint SSD18-PP88-234 located on Segment 10AE. Welder is identified as 050242(3G). ZPMC QC is identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-U5-F.

FCAW welding of weld joint SSD16-PP92-240 located on Segment 10CE. Welder is identified as 058551(1G). ZPMC QC is identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U4b-F.

FCAW welding of weld joint Seg060\*-018, 017, 016, 015 located on Segment 10CE. Welder is identified as 214945 (3G). ZPMC QC is identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-U2-F.

SMAW repair welding of weld joint Seg054C-026 located on Segment 9E. Welder is identified as 218086 (3G). ZPMC QC is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G (3F) FCM-Repair-1.

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

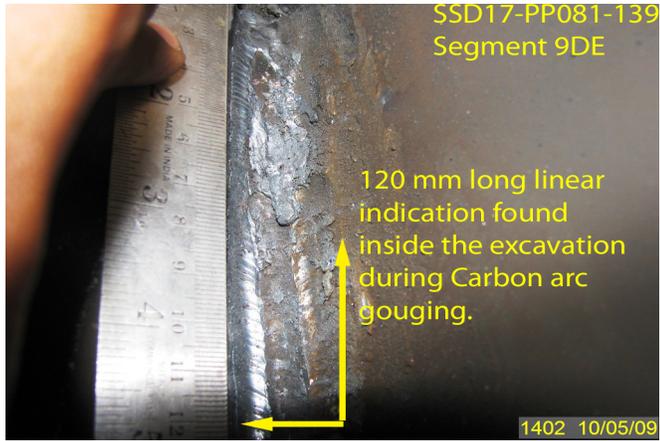


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# WELDING INSPECTION REPORT

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## 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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