

**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-009573**Date Inspected:** 15-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen 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 Components**Summary of Items Observed:**

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

BAY#14

SAW welding of weld joint 1G-012 located on PCMK SEG071A of 11DW welder is identified as 045265.ZPMC QC is identified as Mr. Liu wan ning. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2C-S-2.

FCAW welding of weld joint 1G-004 located on PCMK SEG071A of 11DW welder is identified as 045175. ZPMC QC is identified as Mr. Liu wan ning. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-B-U2-F.

SAW welding of weld joint 1G-007 located on PCMK SEG057\* of 9EW welder is identified as 045265.ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-223(2)1T-2.

FCAW welding of weld joint 3G-019 located on PCMK SEG053 of 9CW welder is identified as 202122.ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-B-U2-F.

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# WELDING INSPECTION REPORT

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FCAW welding of repair weld joint 2G-010 located on PCMK SEG049A of 9AW welder is identified as 066673. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-223(2)1T-1 and the Repair Report WR-8140.

## OUTSIDE SEGMENTS

SMAW welding of weld joint 4G-256 located on PCMK SSD12-PP52 of 7BW welder is identified as 045196. ZPMC QC is identified as Mr. Zhang qiang. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

FCAW repair welding of fillet weld joint 2F-004 converted into complete joint penetration 2G located on PCMK SSD12-PP50 of 7BW welder is identified as 0671103. ZPMC QC is identified as Mr. Zhang qiang. The welding variables recorded by QC appeared to Comply with the WPS-345-FCAW-2G(2F)-Repair & Temporary WR.

## TOWER

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 members are identified as East Tower Lift 3 (82.25Mtr). The weld designations reviewed are as follows:

Skin A - ESTL3-4B/K-036,039,043,045.

Skin B - ESTL3-4B/K-054,056,057,061.

Skin C - ESTL3-4B/K-068,070,073,075.

Skin D - ESTL3-4B/K-009,012,015,018,022.

Skin E - ESTL3-4B/K-025,028,030,033.

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

### Summary of Conversations:

No Relevant Conversation.

### 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 Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar, Chadra	Quality Assurance Inspector
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<b>Reviewed By:</b>	Patterson, Rodney	QA Reviewer
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