

**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-010159**Date Inspected:** 01-Nov-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:** Shen fu you / Lv liqing**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

FCAW welding of weld joint 3G-037 located on PCMK SEG051A of 9BW welder is identified as 202122.ZPMC QC is identified as Mr.Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-Tc-U4b-F.

SMAW welding of weld joint 4G-009 located on PCMK SEG063A of 10CW welder is identified as 051348. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint 4G-127 located on PCMK SSD12A-PP88 of 10BW welder is identified as 069896. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

FCAW welding of weld joint 2F,3F-049,078 located on PCMK SSD22-PP80.5 of 10BW welder is identified as 203871.ZPMC QC is identified as Mr.Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132 & WPS-B-T-2133.

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## WELDING INSPECTION REPORT

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FCAW welding of weld joint 3G-026 located on PCMK DP264-001 of 10CW welder is identified as 047866. ZPMC QC is identified as Mr. Li wan ning. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-Tc-U4b-F.

Fit up of following weld joint 1G-031 located on PCMK SEG051\* of 9BW checked with ZPMC QC Mr.Xu tao , dimension, ceramic backing bar and tack weld and recorded , the WPS Variables recorded by QC appeared to comply with the WPS-B-T-223(2)1T-2.

BAY#13

FCAW welding of weld joint 1G-127 located on PCMK SSD19A-PP102 of 11CE welder is identified as 055560.C QC is identified as Mr.Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-Tc-U4b-F.

FCAW welding of weld joint 2F-027 located on PCMK SEG066B of 11AE welder is identified as 058551.C QC is identified as Mr.Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

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

BAY#10

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 members are identified as Tower strut web plate. The weld designations reviewed are as follows:

ND1-STSA3-1-89M-1-51A/B.

ND1-STSA3-1-99M-1-51A/B.

ND1-STSA3-1-109M-1-2A/B.

BAY#11

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 members are identified as Tower strut. The weld designations reviewed are as follows:

WD1-6001-3-08,09,10,12.

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

### Summary of Conversations:

No relevant Conversation.

Item	Description	WBS	Dwg No.	Status
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# WELDING INSPECTION REPORT

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## 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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