

**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-010441**Date Inspected:** 27-Nov-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:** Lv Li Qing**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 7DW**

During random visual inspection of OBG segment 7DW, this QA inspector found that ZPMC has deviated the joint design on SSD11A-PP57-146, 146, 142, 143 and SSD22-PP56.5-131, 132. According to approved drawings these welds are 8mm fillet welds, ZPMC has changed these welds to CJP. For further information, please find attached pictures.

**Segment 7DE**

This QA Inspector performed a preliminary random visual inspection after the grit blast of the internal components of the deck panel and corner assemblies of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

**Segment 7EE**

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:

-(Seg042C-026)

Bay#14

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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:

-(Seg074A-004)

Bay#13

SMAW welding of weld joint SSD20A-PP103-223, 243, 232, 242 located on Segment 11CE. Welder is identified as 067589 (4G). ZPMC QC is identified as Zhong Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

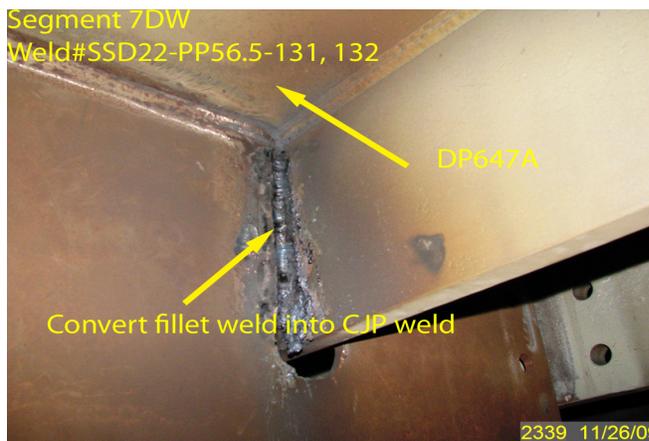
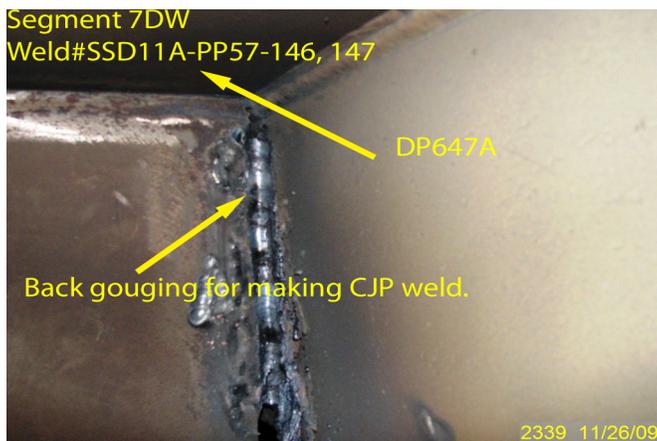
FCAW welding of weld joint SSD29-PP97.5-059~094 located on Segment 11AE. Welder is identified as 050988 (2F). ZPMC QC is identified as Zhang Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint SSD20A-PP103-245, 235 located on Segment 11CE. Welder is identified as 044774 (3G). ZPMC QC is identified as Zhang Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2333-Tc-P4-F.

FCAW welding of weld joint SSD20-PP103-244, 234 located on Segment 11CE. Welder is identified as 044774 (3G). ZPMC QC is identified as Zhang Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2333-Tc-P4-F.

FCAW welding of weld joint SSD20-PP103-237, 247 located on Segment 11CE. Welder is identified as 044774 (2G). ZPMC QC is identified as Zhang Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

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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# WELDING INSPECTION REPORT

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