

**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-010732**Date Inspected:** 07-Dec-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:** Li Huajie**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 COMPONENT**Summary of Items Observed:**

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

In process Inspection

Bay #14

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG segment 11DW, deck plate DP133A to deck plate DP268A, weld No. SEG-071-005. The welder is identified as #045265. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

FCAW in the 1G position at Deck plate to Edge plate at OBG Corner Assembly, weld No. CA89-003. The welders are identified as #202122, #058245 and #045240. ZPMC QC is identified as Mr. Xu Tao. The welding variables recorded by QC appear to comply with WPS-B-T-2231-Tc-U4b-F.

SAW in the 1G position for the OBG segment 11EE, deck plate DP404 to deck plate DP431, weld No. SEG-074-004. The welder is identified as #044771. ZPMC QC is identified as Mr. Zhong Gao Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

SAW in the 1G position for the OBG segment 12CW, Bottom plate BP3026 to Bottom plate BP3027, weld No.

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## WELDING INSPECTION REPORT

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SEG-3006A-005. The welder is identified as #045265. ZPMC QC is identified as Mr.Xu Tao. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2 .

SAW in the 1G position for the OBG segment 12CW , Bottom plate BP3025 to Bottom plate BP3026A , weld No. SEG-3006A-006. The welder is identified as #045265. ZPMC QC is identified as Mr.Xu Tao. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2 .

Bay #13

This QA Inspector observed the following work in progress:

SMAW in the 3F position for the OBG segment 11BE , weld No. SSD16-PP98-144. The welder is identified as #067656. ZPMC QC is identified as Mr.Guo Xing Hui. The welding variables recorded by QC appear to comply with WPS- B-P-2113-FCM.

SMAW in the 3F position for the OBG segment 11BE, weld No. SSD17-PP99-136. The welder is identified as #067904. ZPMC QC is identified as Mr.Guo Xing Hui. The welding variables recorded by QC appear to comply with WPS- B-P-2113-FCM.

FCAW in the 3G position for the OBG segment 11BE, weld No. SEG-068A-033. The welders are identified as #050242,#044774 and #051356. ZPMC QC is identified as Mr.Guo Xing Hui. The welding variables recorded by QC appear to comply with WPS- B-T-2233-Tc-U4b-F.

Unless otherwise noted, all work 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>	Bera,Subhasis	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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