

**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-011277**Date Inspected:** 11-Dec-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:** Liu Huajie / Lv liqian**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#13**

SMAW welding of weld joint 4G-232 located on PCMK SSD18A-PP100 of 11BE welder is identified as 044772. ZPMC QC is identified as Mr. Gui xing hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2214-TC-U4b-FCM-1.

**BAY#14**

FCAW welding of weld joint 3G-019 located on PCMK SEG063E of 10CW welder is identified as 201215. 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.

FCAW welding of weld joint 1G-001 located on PCMK SEG073\* of 11EW welder is identified as 020125. ZPMC QC is identified as Mr. Wang xu. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-B-U2-F.

FCAW welding of weld joint 3G-173 located on PCMK SEG059D of 10AW welder is identified as 050316. ZPMC QC is identified as Mr. Wang xu. The welding variables recorded by QC appeared to Comply with the

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# WELDING INSPECTION REPORT

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WPS-B-T-2233-TC-U4b-F.

SMAW welding of weld joint 4G-005 located on PCMK SEG072A of 11DE welder is identified as 067609.ZPMC QC is identified as Mr. Geng wei. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-B-U2-FCM-1.

BAY#19

FCAW welding of weld joint 1G-002 located on PCMK BP3017-001 of CB12 welder is identified as 062738. ZPMC QC is identified as Mr.Zheng cheng. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-B-U2-F.

Ongoing heat straightening of bottom plate BP025-013-001,002,003 and BP026-013-001,002,003 of CB12 Temperature and Dimension checked with ZPMC QC Mr.Zheng cheng and recorded that is to comply with HSR1(B)-7895, HSR1(B)-7896.

## OUTSIDE SEGMENT

During random in process visual inspection of the internal components of OBG Segment 7CW, this Quality Assurance Inspector (QA) discovered the following issues:

The intermediate angle stiffener at panel point 52.5 identified as X74E was found welded to the longitudinal diaphragm 12A web plate indentified as X69L. The approved contract drawing SEGSD29 shows that the intermediate angle stiffener is not to be welded to the longitudinal diaphragm at this location.

For more information please see the Incident report

04-0120F4\_TL-15\_B247\_12-11-09\_7CW \_Additional weld added without Engineer approval.

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 Eric Tsang-15--0042-2372, 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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