

**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-011862**Date Inspected:** 18-Jan-2010**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:** Li yan hua /Zho zhong hai**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

ZPMC is doing repair welding of existing weld joint due to weld reinforcement is below the required value , SMAW welding of repair weld joint is identified as SEG059A-001 of Segment 10AW welder is identified as 051348.ZPMC QC identified as Mr.Xu tao. The welding variable is recorded by QC appeared to comply with the WPS-345SMAW-4G(4F)-FCM-repair and repair welding report B-WR9942.

FCAW welding of weld joint 1G-020 located on PCMK SEG071A of 11DW 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-2231-B-U2-F.

Ongoing repair welding of following base metal location is identified as SP3004C of segment 12AE welder is identified as 049861. ZPMC QC identified as Mr.Zhang guo hui.The welding variable is recorded by QC to comply with WPS-345-SMAW-1G (1F)-RCM-Repair and B-CWR1059.

OUTSIDE SHOP

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## WELDING INSPECTION REPORT

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Weld reinforcement checked with ZPMC QC Mr.Li ping of segment 9AW the weld is identified as SEG049A-001, 010 after repair welding to comply with the B-WR9941.

Reinforcement is measured 10 different location and observed is 0mm to 3 mm.

ZPMC is doing repair welding of existing weld joint due to weld reinforcement is below the required value , SMAW welding of repair weld joint is identified as SEG053A-001 of Segment 9CW welder is identified as 067764 and 067752 .ZPMC QC identified as Mr.Wang xian pin. The welding variable is recorded by QC appeared to comply with the WPS-345SMAW-4G(4F)-FCM-repair and repair welding report B-WR9941.

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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