

**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-011977**Date Inspected:** 10-Feb-2010**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:** Wu Chi Chang**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.

Trial Assembly Area

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 7BW, weld No.SEG035-004. The welder is identified as #068917. ZPMC QC is identified as Mr.Li Yang. The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW in the 4G position for the OBG Segment 7CW, weld No.CA035-006. The welder is identified as #069683. ZPMC QC is identified as Mr.Li Yang. The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

FCAW in the 3G position for the OBG Segment 7AW to 7BW, weld No.BP-089-001-41. The welder is identified as #066746. ZPMC QC is identified as Mr.Li Yang. The welding variables recorded by QC appear to comply with WPS-B-T-2233-B-U2-F.

FCAW in the 3F position for the OBG Segment 6CW, weld No.EP-032-001-49. The welder is identified as #066673. ZPMC QC is identified as Mr.Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2133.

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# WELDING INSPECTION REPORT

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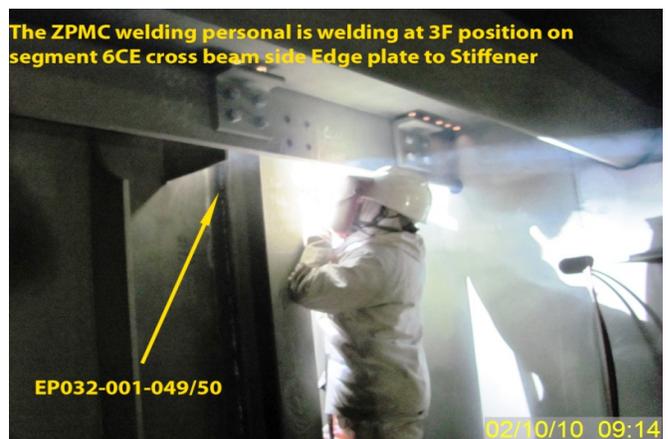
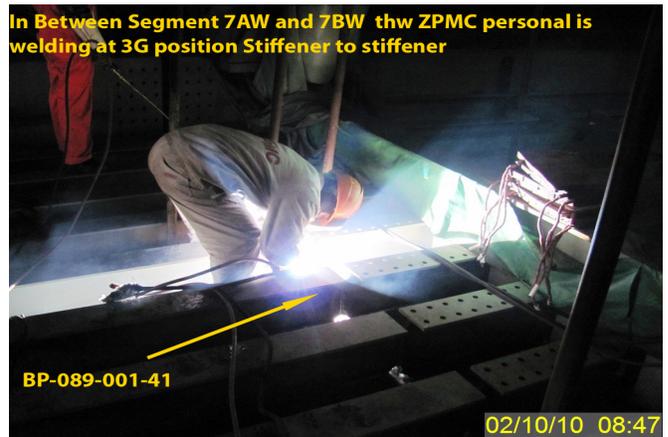
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## Visual Inspection after Blast

During the Quality Assurance (QA) random visual inspection after grit blast inside Orthotropic Box Girder (OBG) segment 7DW, this Quality Assurance Inspector (QA) discovered that the ZPMC has temporarily tack welded scaffolding legs to a Seismic Performance Critical Member (SPCM). The approved shop drawings do not specify any welds in these areas. The size and length of the tack welds do not meet the requirements of AWS D1.5 2002, table 12.2. The member is a side panel identified as: SP483A. The Side panel is designated on the approved shop drawings as (SPCM). The Side panel is located between panel point PP057 and PP058 on the Cross Beam side. The location of the temporary tack welds are 340mm and 1100mm from PP058.

This QA Inspector generated an incident report for this date.

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

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## WELDING INSPECTION REPORT

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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
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<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer
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