

**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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012362**Date Inspected:** 04-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Li Yan Hua**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 Segment**Summary of Items Observed:**

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

Outside Yard: Segment 8CE.

This QA inspector observed ZPMC qualified welding personnel identified as 043661 and 058087 perform Shielded Metal Arc Welding (SMAW) Welding on T-ribs edge plate misalignment weld joints of segment 8CE cross beam side. The weld joint details are identified as PP69.5-PP70-13, 14, 15, 16, 17, 18, 19(T-ribs numbers); PP69-PP69.5- 17, 18; PP68-PP68.5- 19. ZPMC QC is identified as Mr. Zhang Zin. The approved Welding Repair Report (WRR) is identified as B-CWR10632. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3G (3F) Repair. For more information, please see the attached photos.

This QA inspector observed ZPMC qualified welding personnel performing weld repair / correction on Flange Plate X7K of PP68, PP69, PP70 and PP71 to maintain the required radius R50mm. The welding process is identified as Shielded Metal Arc Welding (SMAW) and the welder is identified as 043661. ZPMC QC is identified as Zhang Zin. The welding variables recorded by QC appeared to comply with the applicable WPS: 345-SMAW-1G (1F)-Repair, which is used as per Welding Repair Report (WRR) B-WR10642.

Outside Yard: SEG 7DW.

# WELDING INSPECTION REPORT

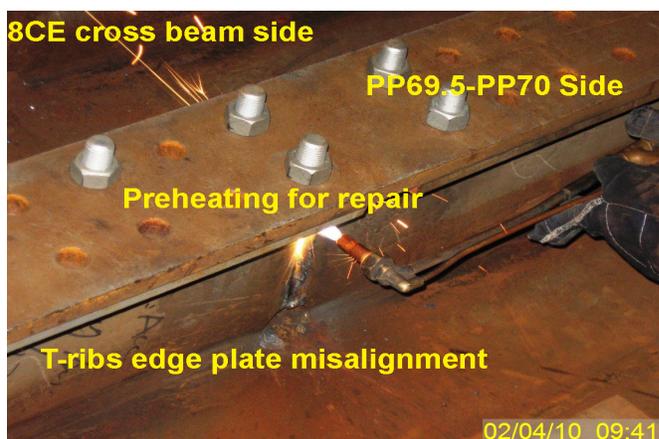
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ZPMC personnel performing weld repair / correction on Flange Plate X7K of PP56, PP57 & PP58; to maintain the required radius R50mm. The welding process is identified as Shielded Metal Arc Welding (SMAW) and welder is identified as 045133. ZPMC QC is identified as Wang Wei Ming. The welding variables recorded by QC appeared to comply with the applicable WPS: 345-SMAW-1G (1F)-Repair, which was used as per Welding Repair Report (WRR) B-WR10642.

## BLAST SHOP 1

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG segment 8CE external side panel, bottom panel, Deck panel floor beam and longitudinal diaphragms surfaces from the panel point 68 to 71 after grit blasting. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



## Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

## 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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remedial efforts please contact , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Vibin	Quality Assurance Inspector
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<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer
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