

**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-013453**Date Inspected:** 11-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**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 hua ji**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

FCAW welding of weld joint 2G-022 located on PCMK SEG071C 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-Tc-U4b-F.

FCAW welding of weld joint 1G-009 located on PCMK SEG3003\* of 12CE welder is identified as 048038.ZPMC QC is identified as Mr. Guo pan . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-B-U2-F.

FCAW welding of weld joint 1G-004 located on PCMK CA3006 of 12AW 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-2231-Tc-U4b-F.

ZPMC UT QC personnel performing their UT of bottom plate to side plate weld of segment 12 CW is identified as SEG30096C-001,009,011. The weld in between the PP115 to PP 115.2 is identified as SEG3006A-001,002 east and west ZPMC could not perform their UT from top of the weld, because ZPMC already installed the Longitudinal Diaphragm. This is discussed with ZPMC QC Mr. Li ming yang. He told that ZPMC will do their UT from bottom side of the weld.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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Fit up of longitudinal diaphragm LD3024-001 connected with Floor beam FB3096-001 and FB3098-001 is ongoing in segment 12CW, is appeared to comply with contract documents.

## OUTSIDE SHOP

This QA inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The members are identified as OBG Hand rails. The components are reviewed are as follows:

Type 1 Cat walk-150nos.

Type 9 Cat walk-40nos.

Type 6 Cat walk-04nos.

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

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# WELDING INSPECTION REPORT

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your project.

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