

**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-013812**Date Inspected:** 21-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Liu Hua Jie**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.

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 204730 perform Flux Cored Arc Welding (FCAW) welding on OBG Segment 12BW, weld joint identified as SEG3005\*-005. ZPMC QC is identified as Mr. Liu Hua Jie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-U2-F.

This QA inspector observed ZPMC qualified welding personnel identified as 045265 perform Submerged Arc Welding (SAW) Welding on Segment 12BW, weld joint identified as SEG3005\*-005. ZPMC QC is identified as Mr. Liu Hua Jie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 048038 perform FCAW welding on OBG Segment 12BE, weld joint identified as DP3020-PP114-063, 068, 073, 078, 083, and 088. ZPMC QC is identified as Mr. Guo Xing Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 048038 perform FCAW welding on

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## WELDING INSPECTION REPORT

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OBG Segment 12BE, weld joint identified as DP3020-PP114-054, 055, 074, 075, 084, and 085. ZPMC QC is identified as Mr. Guo Xing Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133.

This QA inspector observed ZPMC qualified welding personnel identified as 204730 perform FCAW welding on OBG Segment 12CW, weld joint identified as SEG3005\*-005. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-U2-F.

This QA inspector observed ZPMC qualified welding personnel identified as 201215 perform FCAW welding on OBG Segment 12CW, weld joint identified as SEG3005K-048. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 202122 perform FCAW welding on OBG Segment 12CW, weld joint identified as SEG3005K-073 and 074. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA observed ZPMC personnel performing 100% UT Inspection on OBG Segment 12CW deck panel to deck panel CJP weld. The joining deck panels number is identified as SEG3006\*-002. See the attached picture.

Magnetic Particle Testing (MT) - Document No's: 005389

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

1. CA089-004
2. CA074-004

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 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
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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