

**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-020067**Date Inspected:** 06-Mar-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:** Liu Hua Jie, Lu Li Qing.**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

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

This QA Inspector observed the following work in progress:

Assembly, Bay 14, 12CW, Corner Assembly, Side Plate to Edge Plate.

FCAW welding of weld joint CA3011-003; located on assembly, Bay 14, 12CW. Welder is identified as 201215, 045175; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS:

WPS-B-P-2231-TC-U4B-F.

During random Visual Inspection on above mentioned weld; This QA inspector observed Crack like indication at the weld in crater (STOP position of weld where welder created a crater.) This QA inspector informed to ZPMC QC "Li Ming Yang" about this. The attached photographs provide additional detail.

Assembly, Bay 14, Traveler rail.

FCAW Repair welding (build up about 15-27mm) of weld joint 11TR1-007 (CWR # B-CWR1086); located on Assembly, Bay 14. Welders are identified as 214945; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-1G(1F)-REPAIR-1.

Assembly, Bay 14, 11DW, SEG071C, Longitudinal Diaphragm.

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SMAW welding of weld joint SEG071C-005, 006; located on assembly, Bay 14, 11DW. Welder is identified as 045246; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2214-TC-U4B.

Assembly, Bay 14, 11DE, Corner Assembly to Floor beam.

FCAW welding of weld joint SSD17A-PP105-001, 008; located on assembly, Bay 14, 11DE. Welder is identified as 044790; ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2114-FCM-1.

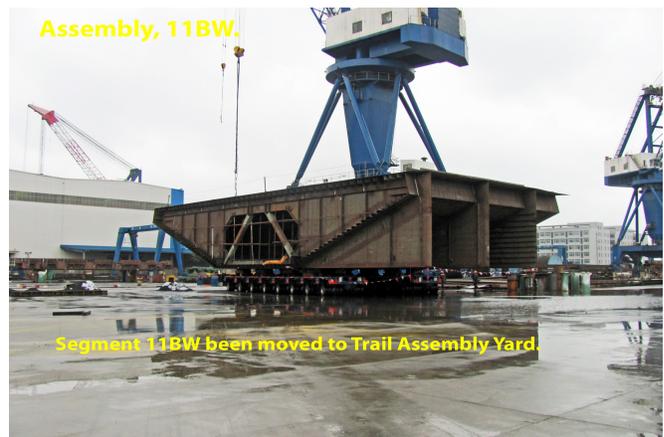
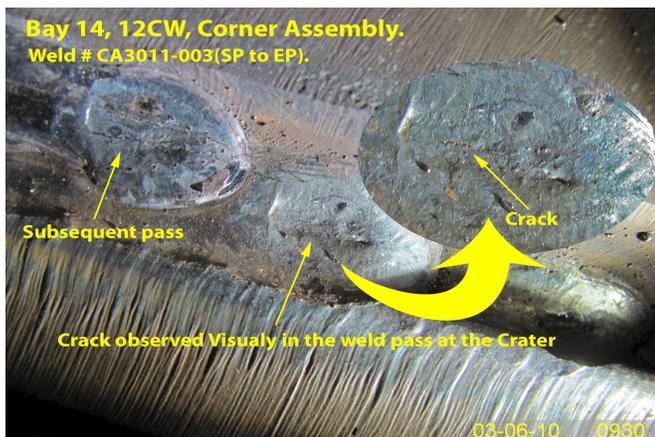
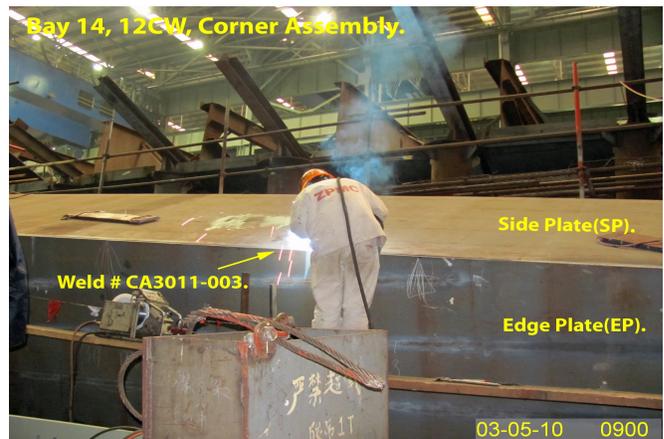
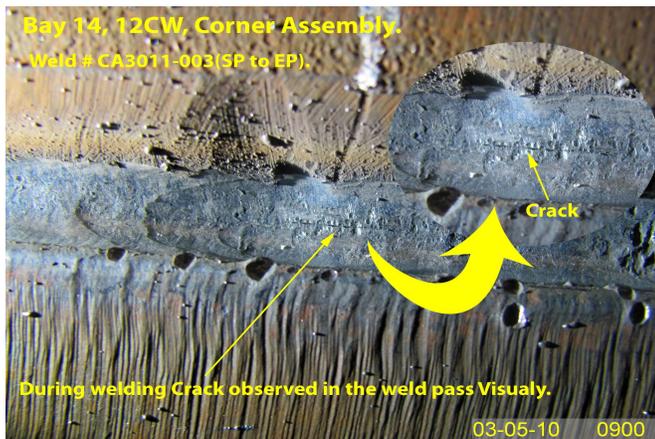
Assembly, Bay 14, 12CW, Floor Beam.

During Random Visual in process Inspection, this QA inspector observed fit up of Floor beam FB3070-002. The attached photographs provide additional detail.

Assembly, Bay 13, 11BW.

Segment 11BW moved to Trial Assembly Yard for further processing. The attached photographs provide additional detail.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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**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 remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Juvekar,Amit	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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