

**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-013359**Date Inspected:** 10-Apr-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:** Zhou Cheng/Sun Bo**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, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

**Bay#19**

During random in process inspection of bike path BK006A-001, this QA inspector observed that ZPMC personal performing base metal repair. Base metal repair was performed by SMAW welding process. After removing the closure plate, interior diaphragm and horizontal stiffeners from plates, BKPL1A and BKPL2A and BKX-10E by carbon arc gouging. The gouging location requires a base metal repair. The plate numbers and weld repair reports (WRR) are identified as:

BK006A-001:

BKPL1A and BKPL2A- WRR# B-WR11501

Welder is identified as 062814 (3G). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-1G(1F)- Repair.

BKX-10E- WRR# B-WR11501

Welder is identified as 062814 (3G). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G(3F)- Repair.

For further information, please see the attached pictures below.

**Bay#8**

FCAW welding of weld joint BK004A6-062-074, 075 located on BK004A-062. Welder is identified as 500405

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(2F). ZPMC QC is identified as Sun Yan Fei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A7-062-023, 024 located on BK004A-062. Welder is identified as 210341 (2F). ZPMC QC is identified as Sun Yan Fei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

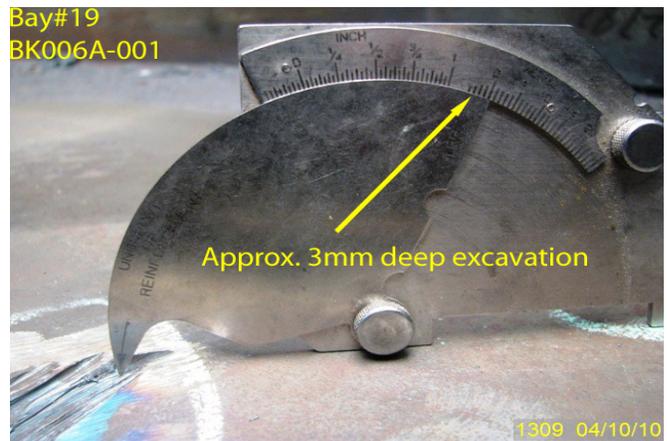
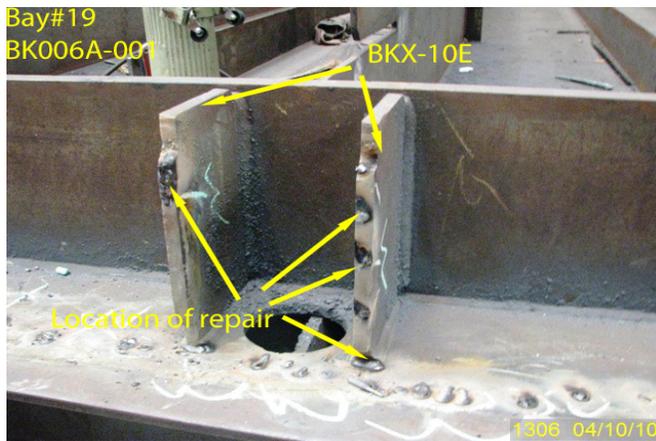
FCAW welding of weld joint BK004A7-062-146, 147 located on BK004A-062. Welder is identified as 500405 (2F). ZPMC QC is identified as Sun Yan Fei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A6-060-074, 075 located on BK004A-060. Welder is identified as 500405 and 210341 (2F). ZPMC QC is identified as Zhang Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A7-060-146, 147 located on BK004A-060. Welder is identified as 210341 (2F). ZPMC QC is identified as Zhang Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A7-060-083, 084 located on BK004A-060. Welder is identified as 500405 (2F). ZPMC QC is identified as Zhang Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

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



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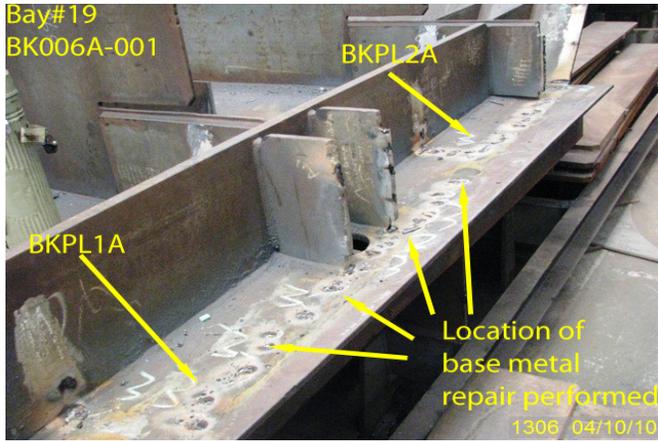
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## Summary of Conversations:

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 150-0042-2372, who represents the Office of Structural Materials for your project.

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

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