

**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-013446**Date Inspected:** 17-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**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:** CB 9**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.

Magnetic Particle Testing (MT) - Document No's: 005536

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 CB. The weld designations reviewed are as follows:

1. CB202A-009-020, 017
2. CB202G-021-153~156
3. CB202G-021-140, 158, 081~084, 180, 181, 147, 165, 049, 050
4. CB202G-022-140, 158, 081~084, 180, 181, 147, 165, 049, 050
5. CB202G-023-140, 158, 081~084, 180, 181, 147, 165, 049, 050
6. CB202G-024-140, 158, 081~084, 180, 181, 147, 165, 049, 050
7. FB205-021-033, 034, 014, 015, 018, 020, 021, 023, 024

Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 062807 perform Flux Cored Arc Welding (FCAW) Welding on USPL1, weld joint identified as USPL1-502-001 and 002. ZPMC QC is identified

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as Mr. Zhou Cheng. 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 062750 perform FCAW Welding on USPL1, weld joint identified as USPL1-503-001 and 002. ZPMC QC is identified as Mr. Zhou Cheng. 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 062761 perform FCAW Welding on USPL1, weld joint identified as USPL1-501-001 and 002. ZPMC QC is identified as Mr. Zhou Cheng. 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 062783 perform FCAW Welding on USPL1, weld joint identified as USPL1-504-001 and 002. ZPMC QC is identified as Mr. Zhou Cheng. 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 062761 perform FCAW Welding on USPL1, weld joint identified as USPL1-505-001 and 002. ZPMC QC is identified as Mr. Zhou Cheng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

### Outside Yard OBG Segment 9DE

This QA inspector observed ZPMC qualified welding personnel identified as 043661 perform Shielded Metal Arc Welding (SMAW) Welding on OBG Segment 9DE, weld joint identified as SEG056D-007 and 008. ZPMC QC is identified as Mr. Wang Wei Ming. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2113-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 054013 perform Shielded Metal Arc Welding (SMAW) Welding on OBG Segment 9DE, weld joint identified as SEG056E-007, 008, 011 and 012. ZPMC QC is identified as Mr. Wang Wei Ming. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2113-FCM-1.

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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