

**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-013699**Date Inspected:** 29-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

<b>CWI Name:</b>	Zhou Zhongai / Li yuan hua	<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
		<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006	<b>Component:</b>	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.

**OUTSIDE SHOP**

## Segment 10CE

SMAW critical repair welding of deck to edge plate corner weld joint 2G-037 located on PCMK SEG064\* of segment 10CE welder is identified as 054013.ZPMC QC is identified as Mr.Li ping . The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-2G(2F)-FCM-Repair and CWR-1436.

## Segment 11AW

SMAW welding of weld joint 3F-026 located on PCMK SSD29-PP96.5 of segment 11AW welder is identified as 058102.ZPMC QC is identified as Mr.Tang ya jun . The welding variables recorded by QC appeared to Comply with the WPS-B-P-2113-FCM-1.

## BAY# 14

FCAW welding of weld joint 2F-152 located on PCMK DP3046-001 of segment 12AW welder is identified as 047866.ZPMC QC is identified as Mr.Li ming yang . The welding variables recorded by QC appeared to Comply

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## WELDING INSPECTION REPORT

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with the WPS-B-T-2132.

FCAW welding of weld joint 3G-099 located on PCMK DP3048-001 of segment 12AW welder is identified as 202122.ZPMC QC is identified as Mr.Li ming yang . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-Tc-U4b-F.

SMAW welding of weld joint 4G-252 located on PCMK SSD16-PP104 of segment 11DE welder is identified as 037723.ZPMC QC is identified as Mr. Wang xu . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint 4F-129 located on PCMK SSD19A-PP107 of segment 11EE welder is identified as 037723.ZPMC QC is identified as Mr.Wang xu . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2114-FCM-1.

During in process visual inspection it was found that root gap of Deck panel U ribs to Deck panel diaphragm fillet weld joint fit more than 5 mm. This is measured , marked and informed to ZPMC QC Mr.Li ming yang and ABF QA Mr.Jim. They agreed and send for engineer approval.

The weld number is identified as

DP3062-001-170/171 @ PP115.

DP3062-001-138/139 @ PP115.2.

DP3062-001-106/107 @ PP115.5.

BLAST SHOP#1

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of Segment 9EW internal Bottom panel, Side panel, Floor beam connecting to longitudinal diaphragm from panel point PP83 to PP85 after grit blasting. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

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 your project.

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

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