

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-014668**Date Inspected:** 18-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**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:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for relative to the work being performed.

Bays 10 and 11

This QA Inspector randomly observed no apparent welding related work being performed in Bays 10 or 11.

Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the Trial Assembly Area:

SMAW welding of weld joint OBE7C-009 located outside PCMK OBG 7E. Welders were identified as 068917, 037932. ZPMC QC was identified as Sha Zhi (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Zhang Xiao Ming, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

SMAW welding of weld joint OBE7C-010 located outside PCMK OBG 7E. Welder was identified as 067571. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Zhang Xiao Ming, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

FCAW welding of weld joint CA046-006 located inside PCMK OBG 7EE, deck plate to edge plate, near the 7DE/7EE joint then continuing onto weld joint CA042-002 PCMK OBG 7DE, deck plate to edge plate, near the

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

7DE/7EE joint. Welder was identified as 220069. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Zhong Yong Gang, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2234-TC-U4b-F.

FCAW welding of weld joint SEG038-006 located inside PCMK OBG 7E, floor beam web to longitudinal diaphragm flange on the south (bike path) side. Welder was identified as 220067. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Zhong Yong Gang, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2234-TC-U4b-FCM.

FCAW welding of weld joint SEG038-009 located inside PCMK OBG 7E, floor beam web to longitudinal diaphragm web on the south (bike path) side. Welder was identified as 220063. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Zhong Yong Gang, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2233-TC-U4b-FCM.

## Heavy Dock

This QA Inspector randomly observed the following work in progress on the Heavy Dock:

FCAW welding of weld joint SSD1-SA16F/G-41 located on PCMK south tower, base shear plate. Welder was identified as 057266. ZPMC QC was identified as You Qi Guo (QC3). The welding variables recorded by QC3 appeared to comply with WPS-B-T-2333-TC-P4-F.

FCAW welding of weld joint SSD1-SA16F/G-47 located on PCMK south tower, base shear plate. Welder was identified as 057266. ZPMC QC was identified as QC3. The welding variables recorded by QC3 appeared to comply with WPS-B-T-2333-TC-P4-F.

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

## Summary of Conversations:

No significant 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.

---

<b>Inspected By:</b>	Goulet,George	Quality Assurance Inspector
<b>Reviewed By:</b>	Dawson,Paul	QA Reviewer

---