

**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-014380**Date Inspected:** 14-May-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>	Li Yang and Wu Zhi Cheng	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes	No N/A
		<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG Trial Assembly	

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) Trial Assembly Areas

Segment 10BE

This QA Inspector performed Green Tag DCP along with Mr. Manikandan for the following Segment 10BE from Panel Point (PP) 88.5 to PP 91.5.

Plumbness and Flatness measurement for Deck Panel to Deck Panel Diaphragm at PP 89, PP 90 and PP 91 from East and West Side.

Flatness measurement for Floor Beam at PP 89, PP 90 and PP 91 Cross Beam and Bike Path side.

Segment 7AW to 7BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder performing Flux Cored Arc Welding process for weld OBW7N-003 located at Counter weight connection plate. Welder is identified as 067079. ZPMC

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QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T-1.

## Segment 7EW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder performing Flux Cored Arc Welding process for weld SP443-001-025 located at Hold back weld between “T” stiffener and side panel (cross beam side). Welder is identified as 067876. ZPMC QC Mr. Cai Xiao Feng monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232.

## Segment 8CE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder performing Shielded Metal Arc Welding (SMAW) repair welding was performed on weld joint CA054-004 Corner Assembly bike path side of segment. Welder is identified as 048047. ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair-1 and CWR1409 R1 procedure.

## Segment 8BE to 8AE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder performing Shielded Metal Arc Welding (SMAW) repair welding was performed on weld joint OBE8B-003 bottom plate splice of segment. Welder is identified as 048659. ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G (1F)-Repair-1 and CWR1450 R1 procedure.

## Segment 8AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder performing Shielded Metal Arc Welding (SMAW) repair welding was performed on weld joint CA047-004 counter weight side of segment. Welder is identified as 066258. ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair-1 and CWR1222 R2 procedure.

## Segment 8AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder performing Shielded Metal Arc Welding (SMAW) repair welding was performed on weld joint CA047-004 counter weight side of segment. Welder is identified as 058087. ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair-1 and CWR1222 R2 procedure.

## Segment 7DW to 7EW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder performing Shielded Metal Arc Welding (SMAW) repair welding base metal was performed on weld joint 009 and 010 located at OBW7C cross beam side of segment. Welder is identified as 045268. ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-4G (4F)-FCM –Repair-1 and CWR1414

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procedure.

Segment 8BW to 8CW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder performing Flux Core Arc Welding (FCAW) welding was performed on weld joint OBW8C-005 cross beam side of segment. Welder is identified as 067079. ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233T-1.

Segment 8BW to 8CW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder performing Flux Core Arc Welding (FCAW) welding was performed on weld joint OBW8C-004 cross beam side of segment. Welder is identified as 066239. ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233T-1.

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

**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 T Sang 1500-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Math,Manjunath	Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer
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