

**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-015124**Date Inspected:** 21-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**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>	Mr. Zhong Chen/wu shi gao	<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	

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

In process Inspection

Out Side

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG Segment 11DE, weld No. SEG072D-079. The welder is identified as #054013. ZPMC QC is identified as Mr. Tang ya jun. The welding variables recorded by QC appear to comply with WPS-B-P-2213-TC-U4b-FCM. Please see the attached picture.

This QA inspector observed the following work in progress:

SMAW in the 3F position for the OBG Segment 11BW, weld No. SEG068D-007. The welder is identified as #051359. ZPMC QC is identified as Mr. Wu Zhi Guo. The welding variables recorded by QC appear to comply with WPS-B-T-4113-2.

This QA inspector observed the following work in progress:

ZPMC performed base metal repair of temporary attachments removal area located on 11BW Side Panel. Welder is identified as #067589. ZPMC QC is identified as Mr. Tan Ya jun. SMAW welding was been performed against Critical Weld Repair Report B-CWR1491. The welding variables recorded by QC appeared to comply with the

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WPS-345-SMAW-4G(4F)-FCM-Repair. Please see the attached picture.

Bay #14

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 13AE bottom Plate, weld No. BP3033-001-002. The welder is identified as #044771. ZPMC QC is identified as Mr. Guo xing Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-U3c-S-2.

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG Segment 13AE Side Plate, weld No. SP3060E-001-011. The welder is identified as #044774. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG Segment 13AW Side Plate, weld No. SP3092B-001-067. The welder is identified as #044830. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

Bay #16

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 13AW bottom Plate, weld No. BP3074-001-005. The welder is identified as #045265. ZPMC QC is identified as Mr. Xia Chun Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-U3c-S-2.

Magnetic Particle Testing:-

Bay #19

This QA inspector performed Magnetic Particle Testing (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 member is identified as Suspend Brackets. The weld designation reviewed is as follows:

SB014-056-26, 32, 25, 37, 49, 61, 1, 4, 5, 7, 8, 19

SB013-060-26, 32, 31, 49, 61, 1, 4, 5, 7, 8, 19

Ultrasonic Testing:-

Bay #19

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an UT report for this date. The member is identified as Suspend Brackets. The weld designations reviewed are as follows:

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SB014-056-25, 37, 49, 61, 4, 5, 7, 8, 19

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

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

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