

**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-015181**Date Inspected:** 25-Jun-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**CWI Name:** Li yan hua / 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:** 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.

BAY#14

FCAW welding of weld joint 2F-080 located on PCMK SP3059-001 of Segment 13AE the welder is identified as 0447740. ZPMC QC is identified as Mr. Zhong guo hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

FCAW welding of weld joint 2F-074 located on PCMK SP3059-001 of Segment 13AE the welder is identified as 055491. ZPMC QC is identified as Mr. Zhong guo hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

BAY#19

SMAW welding of repair weld joint 2G-019 located on PCMK SB015-060 of Lift 8 welder is identified as 062752. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-2G(2F)-FCM-Repair and B-WR13756.

During in process visual inspection it is found that Stacking of Bike path components stringer plate and one deck plate on another of BK004-013. This is informed to ZPMC QC Mr. Xu tao for their attention and action.

During in process visual inspection is found that fabrication of Drip plates Type 1,2,3,4 for Suspender bracket

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ZPMC started their production but they don't have any weld maps and also no QC welding inspection report. This is informed to ABF QA Mr. Peter shaw and ZPMC QC Mr. Xu tao. ZPMC QC discussed with their QA and told no more weld maps for this drip plates.

BAY#16

SAW welding of weld joint 1G-001 located on PCMK BP3074-001 of Segment 13AW welder is identified as 045270. ZPMC QC is identified as Mr. Tao wei. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-U3c-S-2.

OUTSIDE SHOP

12BE

SMAW welding of weld joint 4G-004 located on PCMK SEG3002A of Segment 12BE welder is identified as 044836. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appeared to Comply with the WPS-B-P2214-B-U2-FCM-1.

12CE

SMAW welding of weld joint 4G-011 located on PCMK SEG3003A of Segment 12CE welder is identified as 044772. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

11DE

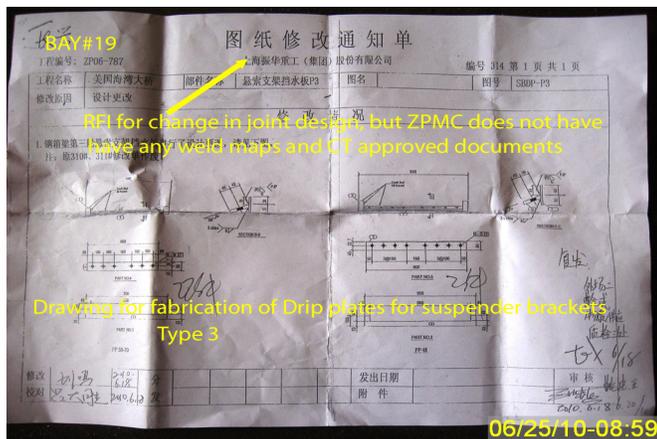
SMAW welding of weld joint 3G-036 located on PCMK SEG072E of Segment 11DE welder is identified as 201087. ZPMC QC is identified as Mr. Tang ya jun. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2213-Tc-U4b -FCM.

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



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## 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.

**Inspected By:** Kumar, Chadra

Quality Assurance Inspector

**Reviewed By:** McClendon, Timothy

QA Reviewer