

**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-015244**Date Inspected:** 27-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:** Mr. Wu shi gao**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**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 Yard

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG Segment 11BE, weld No: SEG068D-079. The welder is identified as #215533. ZPMC CWI is identified as Mr. Wu shi gao. The welding variables recorded by QC appear to comply with WPS-B-P-2213-TC-U4b-FCM.

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG Segment 11BE, weld No: SEG068D-091. The welder is identified as #216086. ZPMC CWI is identified as Mr. Wu shi gao. The welding variables recorded by QC appear to comply with WPS-B-P-4213-2. Please see the attached picture.

This QA Inspector observed the following work in progress:

SMAW in the 3F position for the OBG Segment 11EW, weld No: CA091-033. The welder is identified as #047864. ZPMC QC is identified as Mr. Tang ya jun. The welding variables recorded by QC appear to comply with WPS-B-P-2113-FCM.

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This QA Inspector observed the following work in progress:

SMAW in the 3F position for the OBG Segment 11EW, weld No: CA092-057. The welder is identified as #051348. ZPMC QC is identified as Mr. Tang ya jun. The welding variables recorded by QC appear to comply with WPS-B-P-2113-FCM. Please see the attached picture.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SEG072A-032 located on OBG Segment 11DE Side Plate. Welder is identified as #0540413. ZPMC QC is identified as Mr. Tang ya jun. Welding was performed according to the weld repair report B-WR11228 and UT report number: B787-UT-11789. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G(4F)-FCM-Repair.

This QA inspector observed the following work in progress:

ZPMC performed base metal repair of temporary attachments removal area located on OBG Segment 11EW Side Panel. Welder is identified as #069683. ZPMC QC is identified as Mr. Tan Ya jun. SMAW welding was performed according to the weld repair report B-WR13348. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G(4F)-FCM-Repair.

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. BP3074-001-004. The welder is identified as #045270. ZPMC QC is identified as Mr. Xia Chen hui. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-U3c-S-2.

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



## Summary of Conversations:

No Relevant Conversation.

## Comments

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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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