

**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-015339**Date Inspected:** 02-Jul-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:** Xu tao / Li yan hua**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#19

SMAW welding of critical repair weld joint 3F-032 located on PCMK SB007-048 the welder is identified as 062811. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-3G(3F)-Repair and B-CWR1677.

SMAW welding of critical repair weld joint 2G-001 located on PCMK SB007-048 the welder is identified as 062811. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-2G(2F)-Repair and B-CWR1676.

This QA inspector performed 15% MT of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as OBG Bike path base metal buttered locations. The weld designations reviewed as follows. NWIT- 06102.

BK004A-004.

During in process visual inspection it is found that the fit-up of bottom end closure plate of BK004A-004-114 is identified as, this CJP with permanent backing bar, but in fit-up it is found that Gap in between backing bar instead of continuous backing bar as per D1.5. This is informed to ZPMC QC Mr. Xu tao, he

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agreed for rectification. Please see the attached photos.

## BAY#16

SAW welding of weld joint 1G-004 located on PCMK BP3074-001 of Segment 13AW welder is identified as 045270. ZPMC QC is identified as Mr. Xin chun hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-U3c-S-2.

## BAY#14

SAW welding of weld joint 1G-004 located on PCMK BP3032-001 of Segment 13AE welder is identified as 062406. ZPMC QC is identified as Mr. Gui xing hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-U3c-S-2.

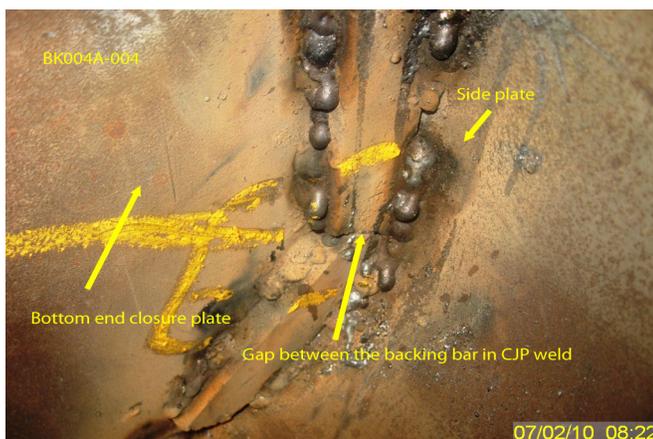
SAW welding of weld joint 1G-004 located on PCMK BP3033-001 of Segment 13AE welder is identified as 044771. ZPMC QC is identified as Mr. Gui xing hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-U3c-S-2.

## OUTSIDE SHOP

### 12BW

FCAW welding of weld joint 1G-250 located on PCMK SEG3005D of Segment 12BW welder is identified as 045175. ZPMC QC is identified as Mr. Tang ya jun . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-Tc-U2a-F.

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.

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

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