

**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-015630**Date Inspected:** 14-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:** Mr. Wu shi guo/Gong wei**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 welding of weld joint no: SSD19-PP108-009 located on OBG Segment 11EE Corner Assembly to Floor beam. Welder is identified as #201087. ZPMC QC is identified as Mr. Li ping. Welding was performed according to the weld repair report B-WR11253 and UT report number: B787-UT-11807. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G(3F)-Repair. Please see the attached picture.

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 11DE, weld No: SEG072A-031. The welder is identified as #054013. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1.

Bay#14

This QA Inspector observed the following work in progress:

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FCAW in the 3G position for the OBG Segment 12AW, weld No: SEG3004J-225. The welder is identified as #201215. ZPMC QC is identified as Mr. Tang ya jun. The welding variables recorded by QC appear to comply with WPS-B-T-2333-TC-U5-F.

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 12BW, weld No: CA3009-004. The welder is identified as #067183. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appear to comply with WPS-B-P-2214-TC-U4b-FCM-1.

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 12CW, weld No: SEG3006-232/252. The welder is identified as #045246. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appear to comply with WPS-B-P-2214-TC-U5-FCM-1.

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. BP3074-001-002. The welder is identified as #045270. ZPMC QC is identified as Mr. Tao wei. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-U3c-S-2.

Bay #19

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the Bike Path, weld No. BK004A8-004-002/007. The welder is identified as #062749. ZPMC QC is identified as Mr. Xia chun hui. The welding variables recorded by QC appear to comply with WPS-B-T-2332-TC-P4-F. Please see the attached picture.

Magnetic Particle Testing:-

Bay #14

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 OBG Segment 13AE Side Plate. The weld designations reviewed are as follows:-

SP3059E-001-015 to 042.

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 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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