

**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-015712**Date Inspected:** 17-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:** 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

SMAW welding of repair weld joint 4G-027 located on PCMK SEG3004\* for Segment 12AW the welder is identified as 068097. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-4G(4F)-Repair.

FCAW welding of weld joint 2F-010 located on PCMK SEG3004B for Segment 12AW the welder is identified as 201215. ZPMC QC is identified as Mr. wang wei ming. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

FCAW welding of weld joint 2F-020 located on PCMK SP3099A for Segment 13AW the welder is identified as 055564. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

BAY#16

SAW welding of weld joint 1G-007 located on PCMK LD3034-001 for Segment 13AW the welder is identified as 250050. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-U2c-S-2.

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# WELDING INSPECTION REPORT

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Ongoing heat straightening of Longitudinal diaphragm is appeared to comply with HSR-8802.

## BAY#19

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 Suspender bracket. The weld designations reviewed as follows.

SB016-072-051,052,063,064,029,030,041,042,003,027,028.

## PAINT SHOP#1

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG Suspender bracket cope hole locations after Painting.. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel. The suspender bracket is identified as SB 48E, SB 48W.

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-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
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<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer
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