

**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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015715**Date Inspected:** 13-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) Chanxing Island **Location:** Shanghai, China**CWI Name:** Mr. Geng 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 Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing (MT) - Document No's: 006191

This QA inspector performed 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 members are identified as OBG Segment Side Plates. The weld designations reviewed are as follows:

1. SP3062A-001-049 to 052 and 063 to 066
2. SP3062A-001-021 to 024 and 035 to 038

Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 062749 perform Flux Cored Arc Welding (FCAW) welding on Bike Path, weld joint identified as BK004A6-004-007. ZPMC QC is identified as Mr. Xia Chun Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2334-Tc-P4-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062749 perform FCAW welding on Bike Path, weld joint identified as BK004A6-004-002. ZPMC QC is identified as Mr. Xia Chun Hui. The welding

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parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2332-Tc-P4-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062749 perform FCAW welding on Bike Path, weld joint identified as BK004A6-004-001 and 012. ZPMC QC is identified as Mr. Xia Chun Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F. See the attached picture.

Bay 16

This QA inspector observed ZPMC qualified welding personnel identified as 045270 perform SAW Welding on OBG Segment 13AW bottom plate, weld joint identified as BP3074-001-002. ZPMC QC is identified as Mr. Tao Wei. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-U3c-S-2.

OBG Segment 11 CW

This QA inspector observed ZPMC qualified welding personnel identified as 200113 perform Shielded Metal Arc Welding (SMAW) welding on corner assembly X37 plate of OBG Segment 11CW, weld joint identified CA086-037, 038, 041 and 042. ZPMC QC is identified as Mr. Wu Shi Gao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4113-2.

This QA inspector observed ZPMC qualified welding personnel identified as 066258 perform SMAW welding on corner assembly X37 plate of OBG Segment 11CW, weld joint identified CA086-049, 050, 051 and 052. ZPMC QC is identified as Mr. Wu Shi Gao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4113-2.

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 250050 perform Submerged Arc Welding (SAW) Welding on Longitudinal Diaphragm of OBG Segment 13CW, weld joint identified as LD3033-001-003. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-U3c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 201215 perform FCAW Welding on OBG Segment 12AW, weld joint identified as SEG3004J-246. ZPMC QC is identified as Mr. Tang Ya Jun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U5-F.

OBG Segment 11DE

This QA inspector observed ZPMC qualified welding personnel identified as 054013 perform SMAW Welding on OBG Segment 11EE, weld joint identified as SSD19A-PP108-002. ZPMC QC is identified as Mr. Li Ping and Welding Repair Report is identified as B-WR11254. The welding parameters as measured using QC's calibrated

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instruments appeared to be in general compliance with WPS-345-SMAW-3G (3F)-Repair.

This QA inspector observed ZPMC qualified welding personnel identified as 201087 and 204339 perform SMAW welding on OBG Segment 11EE, weld joint identified SSD29-PP108.5-207 to 243. ZPMC QC is identified as Mr. Li Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2113-FCM-1.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### 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 , who represents the Office of Structural Materials for your project.

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