

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-015798**Date Inspected:** 07-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:** ZPMC and ABF**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 13 section**Summary of Items Observed:**

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

**Bay #14**

Caltrans QA Inspector observed a welder performed a FCAW process on stiffeners. The stiffener weld is designed 8mm fillet weld with T-joint welded on angle plate. The angle plate is section #14 mock up. The angle plate ID is SA3350B/D, SA3349E/F/G and SA3353F/J. The FCAW process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Caltrans QA inspector observed two fit up groups performed fit up and SMAW tack weld process on T-joint fillet weld. The T-joint is attached to stiffeners and side plate (SP) with plate 18mm and 25mm wall thick. The side plate and plate ID are # SP3102A/PL3394A and SP3575A/PL3255A of 13AE and 13CE section. A numerous temporary tack welds have been welded attach between plate and stiffeners after adjusted and secured by hand jack. The fit up SMAW tack welding process were monitored and recorded by ZPMC and ABF QC inspector. Base on Caltrans QAI observation, no discrepancies were noted.

Caltrans QA inspector observed two ZPMC welders performed FCAW fillet weld process on OBG side plate (SP). The weld is designed T-joint stiffeners to plate with size 8mm fillet weld. The side plate and plate ID are SP3075A/PL3654A. The region of the weld joint has been pre-heating to specific desired temperature prior FCAW welding. The FCAW process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

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## WELDING INSPECTION REPORT

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### Bay #15

Caltrans QA Inspector observed a ZPMC operator performed machining process on the surface of base plate. The machining surface is designed to attach to bearing component. Total 5mm metal has been removed from the surface. ZPMC operator informed Caltrans QA that surface has 1mm left for machining. The machining was monitored and recorded by ZPMC and ABF QC inspector. The ZPMC machining operator informed to Caltrans QA that other side of bottom plate has 360mm width of surface can't be machining due to the machine can't reach that area. The 360mm width will be start machining after relocated the machine. Based on Caltrans QAI observations, no discrepancies were noted.

### Bay#16

Caltrans QA Inspector observed a welding operator in process of semi-automatic SAW on CJP butt joint weld. The CJP weld is attached to 60mm wall thick base plate of 13AW section of west line. This section is a SPM member. The weld number and plate number are BP3073-001-002/PL3364B and PL3365B (side A). The minimum preheat for SPM member CJP weld is 160C degree. The semi-automatic SAW process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

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

### Summary of Conversations:

As notes within report above

### 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 James Devey 15000026784 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Pau,Wai	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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