

**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-015846**Date Inspected:** 19-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. Gong wei/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**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 in the 2G position for the OBG Segment 11CW Side Panel to Edge Plate, weld No: CA086-004. The welder is identified as #200113. ZPMC QC is identified as Mr. Wang xian qin. The welding variables recorded by QC appear to comply with WPS-B-P-2212-TC-U4B-FCM-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SEG071E-128 located on OBG Segment 11DW X8E Plate. Welder is identified as #045246. ZPMC QC is identified as Mr. Li ping. Welding was performed according to the weld repair report B-WR13991. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G(3F)-FCM-Repair.

Bay #14

This QA Inspector observed the following work in progress:

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SMAW in the 4G position for the OBG Segment 12BW Lifting lug , weld No: SEG3005E-240. The welder is identified as #067183. ZPMC QC is identified as Mr. Wang wei ming. Welding was performed with the temporary weld repair report. The welding variables recorded by QC appear to comply with WPS-345-SMAW-3G(3F)-FCM-Repair -1

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 12BW Floor beam to longitudinal diaphragm, weld No: SEG3005D-270. The welder is identified as #066413. ZPMC QC is identified as Mr. Wang wei ming. Welding was performed with the temporary weld repair report. The welding variables recorded by QC appear to comply with WPS-345-SMAW-3G(3F)-FCM-Repair -1

This QA Inspector observed the following work in progress:

SMAW in the 2G position for the OBG Segment 12CW Edge plate to side plate, weld No: CA3011-003. The welder is identified as #045263. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appear to comply with WPS-B-P-2212-TC-U4B-FCM-1

Bay #16

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 13AW longitudinal diaphragm weld No: LD3031-001-003. The welder is identified as #045265. ZPMC QC is identified as Mr. Tao wei. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2C-S-2.

Magnetic Particle Testing:-

Bay #19

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 Suspender Bracket. The weld designation reviewed is as follows:

SB019-072-051,040,027,029,002,057,058,047,035,033,023,021,069,074,076.

SB016-074-063,039,027,029,002,003,059,047,035,033,023,021,022,072,075.

SB016-076-063,051,039,041,027,029,002,059,060,047,033,023,021,069,070,071,072,076.

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