

**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-016025**Date Inspected:** 02-Aug-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:** 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**Summary of Items Observed:**

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

Bay 14-

This QA Inspector observed the following work in progress: Submerged Arc Welding (SAW) of OBG Segment 13BE bottom panel weld, SEG3009A-004. ZPMC welder was identified as 044771. ZPMC QC was identified as Zhang Lin. ZPMC CWI was identified as Geng Wei. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-B-L2c-S-2.

Flux Cored Arc Welding (FCAW) of OBG Segment 13CW bottom panel weld, SEG3005A-003. ZPMC welder was identified as 201215. ZPMC QC was identified as Zhang Lin. ZPMC CWI was identified as Geng Wei. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2231-B-U2-F.

Shielded Metal Arc Welding (SMAW) of OBG Segment 12AW FL3 to side panel weld, SEG3004AA-016. ZPMC welder was identified as 051348. ZPMC QC was identified as Wang Wei Ming. The welding appeared to be in conformance with welding procedure specification, WPS-345-SMAW-4G(4F)-Repair-FCM.

Bay 16-

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of OBG Segment

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# WELDING INSPECTION REPORT

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13CW longitudinal diaphragm stiffener welds, LD3036-001-106, 107. ZPMC welders were identified as 201583 and 040344. ZPMC CWI was identified as Wang Jie. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132.

Caltrans QA marked bottom panel 13AW shear key and bearing rod holes that were damaged during thermal cutting by ZPMC personnel for repair.

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

**Summary of Conversations:**

Only general conversation occurred this day.

**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>	Viars,Larry	Quality Assurance Inspector
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<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer
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