

**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-016177**Date Inspected:** 06-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:** 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#19

FCAW welding of weld joint 2G-037 located on PCMK SB016-074 for OBG SB74E the welder is identified as 062783. ZPMC QC is identified as Mr.Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint 2G-004 located on PCMK SB019-076 for OBG SB76E the welder is identified as 062806. ZPMC QC is identified as Mr.Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint 1G-005 located on PCMK SB020-080 for OBG SB80E the welder is identified as 062794. ZPMC QC is identified as Mr.Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-Tc-U4b-F.

FCAW welding of weld joint 2F-005 located on PCMK SB016-072 for OBG SB72W the welder is identified as 062761. ZPMC QC is identified as Mr.Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-Tc-U4b-F.

OUTSIDE SHOP

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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This QA inspector performed UT of repaired weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an UT report for this date. The

Members are identified as OBG Segment 11CE. The weld designations reviewed as follows.

SSD20A-PP101-198.

SSD19-PP102-108.

SEG070\*-028,029,023,024,025.

## BLAST SHOP#1

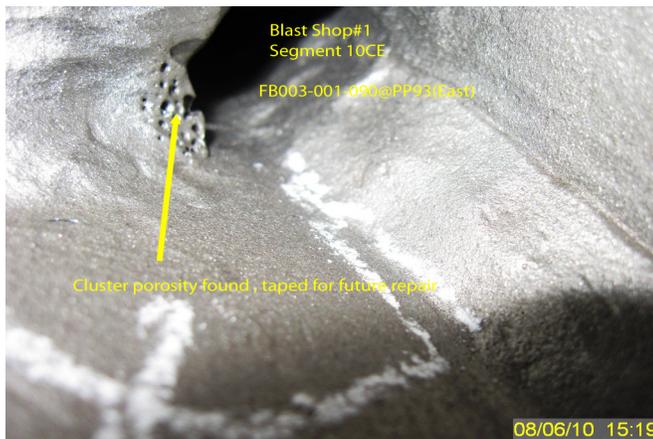
Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG segment 10CE Internal Deck panel, Floor beam and Corner assembly from the panel point 92 to 94 after grit blasting. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel. Areas that marked for repair were recorded and reported to ABF QA Mr. Wang heng for future repair.

DP677-001-004 @ PP94 west, Bike path side-Cluster porosity.

FB011-001-004 @ PP93 East, Apro.4.5mtr from BK side CA Undersize weld.

FB003-001-00 @ PP93 East, Bike path side cluster porosity.

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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**Inspected By:** Kumar,Chadra

Quality Assurance Inspector

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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**Reviewed By:** McClendon, Timothy

QA Reviewer