

**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-016255**Date Inspected:** 10-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yang Bai Qian.**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

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

Subassembly, Bay 04, 14E, Edge plate to Stiffener.

FCAW welding of weld joint EP3027D-(PL3443D)-001-055, 56; located on assembly, Bay 04, 14E. Welder is identified as 206386; ZPMC Quality Control Inspector (QC) is identified as Zhu Tian Shu. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2132. The attached photographs provide additional detail.

Subassembly, Bay 04, 13CW, Deck panel to U-rib.

FCAW Repair welding of partial penetration weld joints DP3152-001-138, 176, 001; located on subassembly, Bay 04, 13CW. Welder is identified as 062265; ZPMC Quality Control Inspector (QC) is identified as Yang Bai Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-FCM-REPAIR.

Y-Locations for the repairs were;

W138 – 4850mm.

W176 – 2450mm.

W001 – 4250mm.

Subassembly, Bay 04, 13CW, Deck panel to U-rib.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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FCAW Repair welding of partial penetration weld joints DP3144-001-240, 230, 229; located on subassembly, Bay 04, 13CW. Welder is identified as 062265; ZPMC Quality Control Inspector (QC) is identified as Yang Bai Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-FCM-REPAIR.

Y-Locations for the repairs were;

W240 – 2300mm.

W230 – 4750mm.

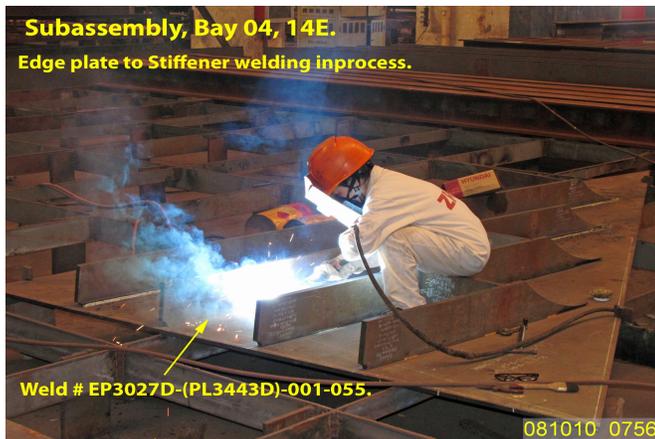
W229 – 3650mm.

This QA Inspector carried out NDE on following Subassembly, Bay 04, U-Rib to Deck Plate welds.

This QA inspector performs Random Visual Testing (VT) & random Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel (Notification # 06375). This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as

- 1) DP3106C(PL3202E)-001; Green tag # 014243.
- 2) DP3106C(PL3202F)-001; Green tag # 014244.
- 3) DP3106C(PL3202G)-001; Green tag # 014245.

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



## Summary of Conversations:

No relevant conversations.

## 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, 1500.042.2372, who represents the Office of Structural Materials for your project.

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# WELDING INSPECTION REPORT

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<b>Inspected By:</b>	Juvekar,Amit	Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer
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