**DEPARTMENT OF TRANSPORTATION**
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

# WELDING INSPECTION REPORT

**Resident Engineer:** Pursell, Gary
**Address:** 333 Burma Road
**City:** Oakland, CA 94607

**Report No:** WIR-016437
**Date Inspected:** 25-Aug-2010

**Project Name:** SAS Superstructure
**Prime Contractor:** American Bridge/Fluor Enterprises, a JV
**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

**OSM Arrival Time:** 700
**OSM Departure Time:** 1900
**Location:** Shanghai,China

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| **CWI Name:** | Wu shi guo/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 3F position for the OBG Segment 12AE X3P Plate, weld No: SEG3001J-057. The welders are identified as #215553. ZPMC CWI is identified as Mr. Wu shi guo. The welding variables recorded by QC appear to comply with WPS-B-P-2113-FCM-1.

Bay #14

This QA Inspector observed the following work in progress:
FCAW in the 3G position for the OBG Segment 12AW X8E Plate, weld No: SEG3004Z-005. The welders are identified as #202122. ZPMC QC is identified as Mr. Wang xiang pin. The welding variables recorded by QC appear to comply with WPS-B-T-2233-TC-U4B-F.

This QA Inspector observed the following work in progress:
SAW in the 1G position for the OBG Segment 13AW Side Panel, weld No: SEG3013AE-004. The welder is

identified as #045270. ZPMC QC is identified as Mr.Xia chuan hui. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2C-S-2. Please see the attached picture.

This QA Inspector observed the following work in progress:
SAW in the 1G position for the OBG Segment 13BE Side Panel, weld No: SEG30009N-001. The welder is identified as #044771. ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2C-S-2.

This QA Inspector observed the following work in progress:
FCAW in the 1G position for the OBG Segment 13BE Side Panel, weld No: SEG3007AE-002. The welder is identified as #044790. ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded by QC appear to comply with WPS-B-T-2231-B-U2-F.

Bay #19

This QA inspector observed the following work in progress:
FCAW welding of weld joint no: SB019-074-019 located on OBG Segment Suspender Bracket SB74E. Welder is identified as #062783. ZPMC CWI is identified as Mr. Xu Tao. Welding was performed according to the Critical weld repair report B-CWR-1825 and UT report number: B787-UT-14457.The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G(2F)-Repair.

This QA inspector observed the following work in progress:
FCAW welding of weld joint no: SB019-074-004 located on OBG Segment Suspender Bracket SB74E. Welder is identified as #062783. ZPMC CWI is identified as Mr. Xu Tao. Welding was performed according to the Critical weld repair report B-CWR-1825 and UT report number: B787-UT-14457.The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G(2F)-Repair. Please see the attached picture.

Visual Inspection after Blast

Segment 11AE

This QA Inspector performed a preliminary random visual inspection after the grit blast of the Interior components of the Deck panel, Side panels and Corner Assembly of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

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

# WELDING INSPECTION REPORT

*( Continued Page 3 of 3 )*

**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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| **Inspected By:** | Pillai,Pandaram | Quality Assurance Inspector |
| **Reviewed By:** | McClendon,Timothy | QA Reviewer |