

**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-005133**Date Inspected:** 07-Jan-2009**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:** Shi Lei**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 Segments**Summary of Items Observed:**

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

This QA Inspector observed the following work in progress:

Bay 14 OBG Assembly

Segment 5BE

Shielded Metal Arc Welding (SMAW) of weld joint SEG024A-032 located on SP359A to BP111A. Welder is identified as 067765. ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Shielded Metal Arc Welding (SMAW) of weld joint SEG024A-005 located on SP603A to BP165A. Welder is identified as 044772. ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Shielded Metal Arc Welding (SMAW) of weld joint SEG024G -001 thru 004 located on X74G to FB40A. Welder is identified as 200432. ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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# WELDING INSPECTION REPORT

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Shielded Metal Arc Welding (SMAW) of weld joint SEG024-001 located on LD017-006 to FB40A. Welder is identified as 044837. ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

## Segment 3AE

Shielded Metal Arc Welding (SMAW) of weld joint SEG014A-031 located on BP6A to SP29A. Welder is identified as 067767. ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Shielded Metal Arc Welding (SMAW) of weld joint SEG014A-032 located on CA2A to SP13A. Welder is identified as 067751. ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

## Segment 6AE

Submerged Arc Welding (SAW) of weld joint SEG028B-007 located on SP525A to SP565A. Welder is identified as 062406. ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

## Segment 6CE

Submerged Arc Welding (SAW) of weld joint SEG032B-032 located on SP528A to SP565A. Welder is identified as 062406. ZPMC QC is identified as Wu Bin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Submerged Arc Welding (SAW) of weld joint SEG032B-014 located on SP529A to SP090A. Welder is identified as 062406. ZPMC QC is identified as Wu Bin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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, 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hernandez, Dan	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford, William	QA Reviewer

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