

**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-005461**Date Inspected:** 15-Feb-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:** Li Zhi jiang/SunWei**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 Quality Assurance (QA) Inspector, Lonnie Whitehead, was present during the times noted above for observations relative to the work being performed.

**BAY#1**

This QA Inspector observed the following work in progress:

S.A.W. welding of the weld joints 001 located on CB203E-001. Welder is identified as #207345. ZPMC QC is identified as Zhu Lin. The welding variables recorded by QC appeared to comply with the applicable WPS.

F.C.A.W. welding of the weld joints 002/008 located on CB203E-001. Welder is identified as #068087. ZPMC QC is identified as Zhu Lin. The welding variables recorded by QC appeared to comply with the applicable WPS.

**BAY#3**

This QA Inspector observed the following work in progress:

Fit up and Tack welding of LD005-007-weld joint 012 and LD003-023-weld joint 011 utilizing S.M.A.W. process. Welder is identified as #058102. The welding variables recorded by QC appeared to comply with the applicable WPS.

This QA Inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated a UT report for this date. The member is identified as:

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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FB023-007-101

FB027-008-101

BAY#2

This QA Inspector observed the following work in progress:

F.C.A.W. welding of the weld joints 033 located on SEG1E-1AA. Welders are identified as #045221 and 045240 and 045280. ZPMC QC is identified as Zhu Lin. 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 (15000422372), who represents the Office of Structural Materials for your project.

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

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