

**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-005612**Date Inspected:** 12-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:** Luan Zhao Gang**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 Assembly**Summary of Items Observed:**

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

Segment Repair Yard (South of the paint shop)

Segment 4AW

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of side plate to side plate splice weld previously rejected by (UT). The welder is identified as #067183. The weld designation is SEG17A-009. ZPMC QC is identified as Mr. Geng Wei. The welding variables recorded by QC appeared to comply with WPS-345-4G(4F)-FCM-Repair.

Shielded Metal Arc Welding (SMAW) in the 4G position of the Deck Plate to Deck Plate splice weld previously rejected by (UT). The welder is identified as #067183. The weld designation is SEG17\*-019. ZPMC QC is identified as Mr. Geng Wei. The welding variables recorded by QC appeared to comply with WPS-345-4G(4F)-FCM-Repair.

Paint Shop

Segment 3AW

This QA Inspector performed a preliminary random visual inspection after the grit blast of the internal components of the bottom panel and side panel super assemblies of this segment. A linear indication was discovered in way of floor beam 17A slotted flange termination to the longitudinal diaphragm at panel point 20, and was measured to be 80mm in length. Other areas of visual indications that will require welding were taped and will be repaired after

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# WELDING INSPECTION REPORT

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the coating is applied. ZPMC QC personnel have been made aware of these defects but were not present at the time of inspection.

## 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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**Inspected By:** Patterson,Rodney

Quality Assurance Inspector

**Reviewed By:** Carreon,Albert

QA Reviewer

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