

**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-006786**Date Inspected:** 14-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xian Ping**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:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

**OBG Trial Assembly Area-**

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as Edge plate EP27A located OBG Segment 6CE. Testing was performed on fillet welds fabricated prior to Edge plate attachment to Segment 6CE.

**Bay 3-**

This QA inspector performed Ultrasonic Testing (UT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member are identified as FB024-011, FB027-012, FB020-009 and FB019-009. The weld identification number is as follows: FB024-011-101, FB027-012-101, 108, 117, 122, FB020-009-101, 108, 122, FB019-009-101, 108, 117 and 122.

**Bay 5-**

This QA Inspector observed the following work in progress: FCAW welding in the 2G position of weld joint

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## WELDING INSPECTION REPORT

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CB202A-006-014 located on OBG, Cross Beam 6 . ZPMC welder was identified as 250341. ZPMC QC is identified as Xu Xian Ping. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2232-B-U2-F.

Bay 7-

This QA Inspector observed the following work in progress: Semi Automatic FCAW welding in the 2G position of weld joint 011, 012, 019 and 020 located on Floor Beam201A-001 . ZPMC welders were identified as 054459 and 062447. ZPMC QC was identified as Xu Xian Ping. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132-3.

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

### Summary of Conversations:

Only general conversations occurred between QA and QC this date.

### 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>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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