

**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-007305**Date Inspected:** 16-May-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:** Lang zao gan**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 Bottom Plate / Side Plate**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

OBG # CROSS BEAM 04

This QA inspector performed Magnetic Particle Test of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Magnetic Particle Test report for this date. The member is identified as Bottom Plate / Side Plate. The weld designations reviewed are as follows:

(CB201G-001-003,004,159)

(CB201G-002-013,014,141)

(CB201G-003-019,020,159)

(CB201G-004-041)

(SP202-004-013 R1)

(SP207-004-077,078,079,103,104)

(SP208-004-012,013,014,015)

This QA Inspector randomly observed the following work in progress:

OBG # BAY 07

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# WELDING INSPECTION REPORT

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Flux Cored Arc Welding Process:

Welding of weld joint –001,002 located on PCMK BP203-015. Welder is identified as 054459. ZPMC QC is identified as Zhang hai tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint –003,004 located on PCMK BP203-015. Welder is identified as 051246. ZPMC QC is identified as Zhang hai tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint –005,006 located on PCMK BP203-015. Welder is identified as 062447. ZPMC QC is identified as Zhang hai tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

OBG # SEGMENT 6AE

Flux Cored Arc Welding Process:

Welding of weld joint –183 located on PCMK SSD17-PP039. Welder is identified as 066683. ZPMC QC is identified as Zhang hai tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-TC-U4b-F.

Welding of weld joint –261 located on PCMK SSD17-PP039. Welder is identified as 200113. ZPMC QC is identified as Zhang hai tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-FCM.

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

**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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<b>Inspected By:</b>	Sukanthan,Dhanasingh	Quality Assurance Inspector
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<b>Reviewed By:</b>	Prue,Erik	QA Reviewer
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