

**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-007336**Date Inspected:** 22-Jun-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:** Huang Wen pang**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 OSM Quality Assurance (QA) Inspector, Sandeep Kumar 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:

FCAW process welding of weld joint #043 located on FB205 – 016 – 022. Welder is identified as 054460. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – u4b – F.

**BAY 2**

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #012 located on LD013 – 011. Welder is identified as 215676. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – u4b – F.

**BAY 3**

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #043 located on Floor Beam FB009 – 033. Welder is identified as 044824.

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ZPMC QC is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – u4b - F.

FCAW process welding of weld joint #037 located on CSD5 – PP75. Welder is identified as 204338. ZPMC QC is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #057 located on Floor Beam FB024 – 011. Welder is identified as 044790. ZPMC QC is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – u4b - F.

This QA Inspector observed the following work not in compliance:

During random visual inspection on OBG Longitudinal Diaphragm (LD012 – 015 – 011), observed that weld tabs have not been used at the end of the joint for weld termination to ensure a sound weld, which was welded by Welder # 204338 using WPS # WPS – B- T – 2132 – 3.

For further details please see the incident report (040120F4\_TL015\_B227\_06-22-09\_Weld tabs have not been used).

### BAY 5

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #004 located on Traveler Rail TR1B – PP17. Welder is identified as 250534. ZPMC QC is identified as Xu Hong Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – u4b – F – 1.

SMAW process welding of weld joint #028 located on Bike Path BK001 – 022. Welder is identified as 215169. ZPMC QC is identified as Xu Hong Min. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112 .

### BAY 7

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #036 located on Side Plate SP3002 – 001. Welder is identified as 062300. ZPMC QC is identified as Zhong Dian Xing. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112 (FCM).

SAW process welding of weld joint #098 located on Side Plate SP3013 – 001 – 098. Welder is identified as 053748. ZPMC QC is identified as Zhong Dian Xing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2C – S – 2.

### BAY 8

This QA Inspector observed the following work in progress:

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FCAW process welding of weld joint #002 located on Cross Beam CB201F – 012. Welder is identified as 066687. ZPMC QC is identified as Guo Yan Tei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – u2 – F.

SAW process welding of weld joint #001 located on Cross Beam CB201D – 012. Welder is identified as 207463. ZPMC QC is identified as Guo Yan Tei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2C – S – 2.

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>	Kumar,Sandeep	Quality Assurance Inspector
<b>Reviewed By:</b>	Prue,Erik	QA Reviewer

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