

**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-007359**Date Inspected:** 04-Jun-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:** Chen Xi**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.

## Bay 2 &amp; Paint Bay 1-

This Caltrans QA inspector verified Partial Joint Penetration (PJP) root gap measurements previously taken by ZPMC and ABF QC on OBG Segments 1AAE and 1AAW end and strand stiffeners. Measurements varied from ABF and ZPMC reports for the root gap dimensions. ZPMC Quality Control (QC) Chen Xi, ABF QC Kelvin Cheung and Caltrans QA measured all areas in question and physically verified and recorded the final dimensions of the root gap for the above mentioned components. The measurements were recorded and ZPMC, ABF and Caltrans got a copy of the final measurements.

## Bay 10-

This QA Inspector observed the following work in progress: SAW welding of weld joints, 5A-2, 18, 8A, 20, 12A, 22 and 14A located on East Tower Lift 4 Skin A ESD1-FESA4-2- A/F. ZPMC welders were identified as 040665 and 062143. ZPMC QC is identified as Xu Yumin. The welding appeared to be in conformance with welding procedure specifications, WPS-B-T-2321-B-P3-S-2 (PJP) and WPS-B-T-2221-B-U3c-S-2 (CJP).

## Bay 11-

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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This QA Inspector observed the following work in progress: SAW welding of weld joints 1A located on North Tower Lift 2 Skin D to E corner Joint NSD1-TL 8 B/L. ZPMC welders were identified as 051413, 050295, 0503060, 040252 and 207745. ZPMC QC is identified as Shi Wei Song. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-C-U2b-S.

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

### Summary of Conversations:

As identified within the contents of this report.

### 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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