

**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-007606**Date Inspected:** 20-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:

This Caltrans QA inspector monitored activities related internal stiffener replacement for Partial Joint Penetration (PJP) welds exceeding Welding Procedure Specification maximum root gap on OBG segments 1AAW and 1AAE.

1AAW

The following base metal excavation area and base metal repair were tested and accepted by ZPMC MT technicians were verified and accepted by QA.

A32- (Deck Plate Side)

A33- (Deck Plate Side)

A34- (Deck Plate Side)

Verification of stiffener fit up was verified by ZPMC, ABF and Caltrans QA for the following welds:

SEG1E- 164, 254, SEG1C- 026 at location A40

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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SEG1E- 255, SEG1F-023, SEG1C-024 at location A00

1AAE

This QA Inspector observed the following work in progress: FCAW welding of stiffener weld joints SEG2F- 025, 045 located at location A00. ZPMC welder was identified as 048433. ZPMC QC is identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2233-TC-U4c-F.

Bay 3-

This QA Inspector observed the following work in progress: FCAW welding of weld joints 090 and 091 located on FB027-012. ZPMC welder was identified as 044790. ZPMC QC is identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2232-TC-U4b-F.

Bay 7-

This QA Inspector observed the following work in progress: SAW welding of weld joint 097 located on SP3013-001. ZPMC welder was identified as 046830. ZPMC QC is identified as Xu Xian Ping. The welding appeared to be in conformance with welding procedure specification, 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:

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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