

**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-007860**Date Inspected:** 23-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:** Li Yan Hua**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 Assembly**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Segment Repair Yard (North of bay 14)

Segment 6AW

Shielded Metal Arc Welding (SMAW) in the 4F position of side plate stiffeners in way of the access hole cut out. The welder is identified as #069896. The weld designation is SSD11A-PP39-183 and 184. ZPMC QC is identified as Mr. Li Yan Hua. The welding variables recorded by QC appeared to comply with WPS-B-P-2114.

Segment 6BW

Shielded Metal Arc Welding (SMAW) in the 4G position of side panel to bottom panel splice weld that was previously inaccessible due to the jig. The welder is identified as #068097. The weld designation is SEG029A-004. ZPMC QC is identified as Mr. Li Yan Hua. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

Shielded Metal Arc Welding (SMAW) in the 4G position of the base metal repairs in way of the locations where the jig was attached. The welders are identified as #066413 and #068097. The ZPMC QC is identified as Mr. Li Yan Hua. The welding variables recorded by QC appeared to comply with the applicable WPS.

Segment Repair Yard (South of the Blast Shop.)

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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## Segment 7AE

This QA Inspector observed that there was no work being done on this segment at the time of inspection.

## Segment 6BE

This QA Inspector observed that there was no work being done on this segment at the time of inspection.

## Segment 7AE

Shielded Arc Welding (SMAW) in the 4F position of the side plate stiffeners in way of the access hole cut out.

The welder is identified as #044279. The weld designation is SSD17-PP51-177. ZPMC QC is identified as Mr. Li Yan Hua. The welding variables recorded by QC appeared to comply with WPS-B-T-2144.

## BAY 19

### Suspender Brackets

Flux Cored Arc Welding (FCAW) in the 2F of the suspender bracket components. The welder is identified as #062755. The weld designation is SB012-058-002 and 003. ZPMC QC is identified as Mr. Zhong Zang. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

Flux Cored Arc Welding (FCAW) in the 2F of the suspender bracket components. The welder is identified as #062762. The weld designation is SB014-05A-040 and 059. ZPMC QC is identified as Mr. Zhong Zang. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

Flux Cored Arc Welding (FCAW) in the 2F of the suspender bracket components. The welder is identified as #062762. The weld designation is SB014-05A-052. ZPMC QC is identified as Mr. Zhong Zang. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

Flux Cored Arc Welding (FCAW) in the 2F of the suspender bracket components. The welder is identified as #062762. The weld designation is SB014-05A-052. ZPMC QC is identified as Mr. Zhong Zang. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

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>	Patterson,Rodney	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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