

**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-007981**Date Inspected:** 25-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:** WU ZHICHENG**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 COMPONENT**Summary of Items Observed:**

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

In process Inspection

**OUTSIDE SEGMENT ASSEMBLY AREA**

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position at the segment 2AW weld No. SEG-007-030 . Welder is identified as #066261. The welding variables recorded by QC appear to comply with WPS- B – P-2214-Tc-U4b-FCM-1.

Shielded Metal Arc Welding (SMAW) in the 4F position at the segment 1BW ,welds No. EP-097-001-009~012. Welder is identified as #037748. The welding variables recorded by QC appear to comply with WPS- B – P-2114 -FCM-1.

This QA Inspector was instructed by task leaders to carry out a close up inspection of the X37 Deck Panel brackets in way of the corner assemblies for Lifts 1-5 East and West. This QA inspector found that a number of locations were welded using a CJP instead of a fillet weld as detailed on the drawings. A spread sheet was created for reference as to what locations were fabricated as mentioned above.

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# WELDING INSPECTION REPORT

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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 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Bera,Subhasis	Quality Assurance Inspector
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<b>Reviewed By:</b>	Prue,Erik	QA Reviewer
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