

**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-007985**Date Inspected:** 22-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia, Liu Zhang Gan**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:** Tower&OBG**Summary of Items Observed:**

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

**TRIAL ASSEMBLY YARD****Magnetic Particle Inspection**

This Q.A Inspector performed Magnetic Particle Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. The members are identified as the Segment 4AE Designation is as follows.

SSD20-PP025-004- Magnetic Particle Inspection on the excavation area of carbon air arc gouged.

**BAY#10**

This QA Inspector randomly observed the following work in progress

FCAW welding process of weld joint 81B located on PCMK SSTL3-1B/K. Welder is identified as 040338 ZPMC QC is identified as Li Zhongan. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-C-U2-F.

FCAW welding process of weld joint 74 located on PCMK NSD1-A22B/E. Welder is identified as 052075 ZPMC

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QC is identified as Shi Jing Wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2G-F-1.

FCAW welding process of weld joint 81B located on PCMK SSSL3-1B/K. Welder is identified as 0550041 ZPMC QC is identified as Li Zhongan. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-C-U2-F.

FCAW welding process of weld joint 2 located on PCMK NSD1-A112C/H. Welder is identified as 052930 ZPMC QC is identified as Zhang Bo. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F) Repair.

BAY#11

SAW welding process of weld joint 81B located on PCMK ESTL3-4B/K. Welder is identified as 041716 ZPMC QC is identified as Yuan Wen Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2B-S.

SAW welding process of weld joint 7B located on PCMK WSD1-FDSA4-4A/D. Welder is identified as 040772 ZPMC QC is identified as Yu Dong Ling. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

### TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

This QA Inspector observed the ZPMC performing Magnetic Particle Testing on the weld joint between Edge panel's stiffeners to Floor beam in segment 1AW at PP9.5 north section.

This QA Inspector observed the ZPMC performing Magnetic Particle Testing on the gouged weld joint between Deck panel diaphragms to floor beam flange welding (SSD020-PP025-004) in segment 4AE.

This QA Inspector observed the ZPMC installing access cover plate at PP9.5 south side in segment 1AE.

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

### Summary of Conversations:

No relevant conversation

### 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 + (86) 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Utekar,Shrikant	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer