

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-008132**Date Inspected:** 29-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, Peng Guo**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.

OBG segment 2AE

Green Tag

This QA Inspector issued green tags No 178, 179, 180, 181 for OBG components after completing the final tension verification requirements. The components detail as Longitudinal Diaphragm splices (4750mm above BP-North and South side).

BAY#11

This QA Inspector randomly observed the following work in progress

SAW welding process of weld joint 82B located on PCMK ESTL3-4B/K. Welder is identified as 047304 ZPMC QC is identified as Peng Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2B-S.

SAW welding process of weld joint 82B located on PCMK ESTL3-4B/K. Welder is identified as 044566 ZPMC QC is identified as Peng Guo. The welding variables recorded by QC appeared to comply with the

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WPS-B-T-2221-C-U2B-S.

BAY#10

This QA Inspector randomly observed the following work in progress

FCAW welding process of weld joint 7 located on PCMK SSD1-FESA4-1B/F. Welders are identified as 053116 ZPMC QC is identified as Liu Zhong An. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F.

FCAW welding process of weld joint 16 located on PCMK SSD1-FESA4-2B/F. Welders are identified as 040349 ZPMC QC is identified as Liu Zhong An. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F.

FCAW welding process of weld joint 12 located on PCMK SSD1-FESA4-2C/F. Welders are identified as 057244 ZPMC QC is identified as Deng Zhi Bing. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT-3AE

FCAW welding process of weld joint 004 located on PCMK SSD18A-PP22. Welder is identified as 051356 ZPMC QC is identified as Li Jia. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F) Repair.

FCAW welding process of weld joint 004 located on PCMK SSD18A-PP22. Welder is identified as 044795 ZPMC QC is identified as Li Jia. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F) Repair.

FCAW welding process of weld joint 20 located on PCMK SEG14B. Welder is identified as 220066 ZPMC QC is identified as Li Jia. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-1G (1F) Repair-1.

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 Serge Sinevod 13482570045, who represents the Office of Structural Materials for

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your project.

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