

**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-008179**Date Inspected:** 23-Jul-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:** Shen fu you / Lv Liqing  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** Yes No N/A  
**Approved WPS:** Yes No N/A  
**Delayed / Cancelled:** Yes No N/A

**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

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

BAY#2

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as a Floor Beams. The weld designations reviewed as follows:

SSD10A-PP086-006.

SSD11-PP093-131.

SSD13-PP089-137.

SSD13A-PP090-132.

FB003-159-034,046.

FB003-163-034,046.

FB003-164-034,046.

FB003-175-034,046.

FB011-032-045.

FB015-039-045.

FB011-029-045.

Green tag issued for the following Floor beam after NDT carried out successfully

SSD13/13A-PP091- Green tag no-009553.

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

### BAY#1

Ongoing SMAW Welding of Weld Joint 4F-147 Located on CB201G-013 of CB7 Welder no indentified as 067665 and The welding variables recorded by QC ZMPC Mr.Tian Lei to comply with the WPS-B-P-2114-FCM.

Ongoing FCAW Welding of Weld Joint 2G-003 Located on CW001B-PP066 Welder no indentified as 059456 and The welding variables recorded by QC ZMPC Mr.Tian Lei to comply with the WPS-B-T-2232-T2-U4b-F.

### BAY#3

Ongoing FCAW Welding of Weld Joint 2G-125 Located on FB024-010 Welder no indentified as 044824 and The welding variables recorded by QC ZMPC Mr.Yang Qing Feng to comply with the WPS-B-T-2232-Tc-U4b-F.

Ongoing SMAW Welding of Weld Joint 3F-163 Located on CB202G-027 of CB10 Welder no indentified as 058102 and The welding variables recorded by QC ZMPC Mr. Yin Dong Hai to comply with the WPS-B-P-2133.

### BAY#14

During in-process visual inspection of the fabrication of Segment 9EE, Caltrans Quality Assurance Inspector found that a Portion of Floor Beam Leg damaged because of poor handling of FB010-024.For more information please go through the Incident report 040120F4\_TL015\_B255\_07-23-09\_Damaged Floor Beam 9EE

Unless otherwise noted, all 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 Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

---

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

---