

**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-008228**Date Inspected:** 27-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, Du Zhi Gun**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**

Visual Inspection

OBG segment 2AE-2BE

This Quality Assurance (QA) Inspector witnessed final tension verification for 'U' Rib to 'U' Rib (Except big splice location No.7, 23, 32 from north side) of segment 2AE to 2BE at PP 13.5 to 14. Inspected 10% of installed bolts and found tension verification satisfactory. Bolt sizes used are M24 x 65 RC Lot No. DHGM220033 and final Torque required is 470 N-m. Tension verification carried out by Manual Torque wrench with Sr. No. X02-667.

BAY#10

This QA Inspector randomly observed the following work in progress

SAW welding process of weld joint 84B located on PCMK SSSL3-1B/K. Welder is identified as 0503060 ZPMC QC is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the

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WPS-B-T-2221-C-U2B-S-2.

SAW welding process of weld joint 84B located on PCMK SSSL3-1B/K. Welders are identified as 050295 ZPMC QC is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2B-S-2.

BAY#11

FCAW welding process of weld joint 9 located on PCMK ESD1-FESA4-2L/F. Welders are identified as 066484 ZPMC QC is identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F.

FCAW welding process of weld joint 8 located on PCMK ESD1-FESA4-2E/F. Welders are identified as 062126 ZPMC QC is identified as Peng Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F.

SMAW welding process of weld joint 113 located on PCMK WSD1-TL-6E/L. Welders are identified as 040690 ZPMC QC is identified as Cheng Hong Yun. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-B-U2A-2.

SMAW welding process of weld joint 3 located on PCMK WSD1-TL-6C/L. Welders are identified as 049099 ZPMC QC is identified as Cheng Hong Yun. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-B-U2A-2.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT-4AW

FCAW welding process of weld joint 21 located on PCMK SEG-017A. Welder is identified as 220063 ZPMC QC is identified as Li Jia. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-P4B-F.

Visual Inspection

OBG Segment 4AW

This Caltrans Quality Assurance (QA) Inspector observed ZPMC performing weld repair on the weld joint between longitudinal diaphragms to the bottom panel (SEG-017A-20, 21, 23), During the welding operation on 07-27-09 between 21:30 and 22:25 the ZPMC Quality Control (QC) CWI Inspector were not present. This condition exists on OBG segment 4AW at PP at panel point 25. This time frame exceeds the 30 minute maximum allowable time lapse for QC Inspection coverage. Incident report was issued and submitted to task leader and other supervisor.

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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 your project.

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

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