

**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-008240**Date Inspected:** 26-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Weing Wei**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**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.

BAY # 1

Ultrasonic Inspection

This QA Inspector performed Ultrasonic Testing of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (UT) report for this date. The members are identified as the Cross Beam Designation are as follows.

CB201C-007-001, 002, 004

BAY # 3

Ultrasonic Inspection

This QA Inspector performed Ultrasonic Testing of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (UT) report for this date. The members are identified as the Floor Beam Designation are as follows.

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FB016-044-045

BAY # 3

Magnetic Particle Inspection

This QA Inspector performed Magnetic Particle Testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (MT) report for this date. The members are identified as the Floor Beam Designation are as follows.

FB012-038-001, 011, 012, 020, 032, 031

FB011-034-003, 009, 019, 034, 020, 011

FB015-042-001, 011, 019, 020, 024, 032

FB011-037-001-001, 003, 011, 020, 046

CB202B-010-001, 002, 004

CB202C-010-004

This QA Inspector randomly observed the following work in progress

BAY#03

FCAW welding process of weld joint 127 located on PCMK FB027-012. Welder is identified as 066746 ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4B-F.

FCAW welding process of weld joint 135 located on PCMK SSD12-PP100. Welder is identified as 044824 ZPMC QC is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-TC-U4B-F.

FCAW welding process of weld joint 040 located on PCMK FB204-026. Welder is identified as 044830 ZPMC QC is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-3G (3F) Repair.

FCAW welding process of weld joint 001 located on PCMK FB010-036. Welder is identified as 204338 ZPMC QC is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the WPS-2132-3.

FCAW welding process of weld joint 041 located on PCMK CA57. Welder is identified as 044830 ZPMC QC is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-TC-U4B-F

BAY#02

SMAW welding process of weld joint 146 located on PCMK FB028-009. Welder is identified as 205098 ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the

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WPS-345-SMAW-2G (2F) Repair.

Unless otherwise noted, all work observed on this dated 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.

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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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