

**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-008251**Date Inspected:** 17-Jun-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:** Cheng Ying Xing**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**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.

This QA Inspector randomly observed the following work in progress

BAY#10

SAW welding process of weld joint 14A located on PCMK NSD1-FDSA4-3A/C. Welder is identified as 207746 ZPMC QC is identified as Lu Wei Chao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

SAW welding process of weld joint 8A located on PCMK NSD1-FDSA4-3A/C. Welder is identified as 207745 ZPMC QC is identified as Lu Wei Chao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2

FCAW welding process of weld joint 127B located on PCMK NSD1-FASA4-1E/E. Welder is identified as 040338 ZPMC QC is identified as Cheng Ying Xing. The welding variables recorded by QC appeared to comply with the WPS-B-T-4231-B-U3-F.

SMAW welding process of weld joint 10B located on PCMK SSD1-FESA4-1A/F Welder is identified as 052930 ZPMC QC is identified as Cheng Ying Xing. The welding variables recorded by QC appeared to comply with the

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WPS-345-SMAW-1G (1F) Repair.

SAW welding process of weld joint 106B located on PCMK NSD1-FASA4-1E/E. Welder is identified as 0503060 ZPMC QC is identified as Cheng Ying Xing. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

SMAW welding process of weld joint 5A/B located on PCMK NSD1-TL8B/L. Welder is identified as 052771 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F) Repair.

FCAW welding process of weld joint 7 located on PCMK SSSL-1D/K. Welder is identified as 054069 ZPMC QC is identified as Chen Yu Xing. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

FCAW welding process of weld joint 6 located on PCMK SSSL-1D/K. Welder is identified as 053116 ZPMC QC is identified as Chen Yu Xing. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

FCAW welding process of weld joint 7 located on PCMK SSSL-1I/K. Welder is identified as 057844 ZPMC QC is identified as Chen Yu Xing. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

FCAW welding process of weld joint 98 located on PCMK SSSL-1G/K. Welder is identified as 050041 ZPMC QC is identified as Chen Yu Xing. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

FCAW welding process of weld joint 97 located on PCMK SSSL-1G/K. Welder is identified as 057266 ZPMC QC is identified as Chen Yu Xing. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

BAY#11

FCAW welding process of weld joint 96 located on PCMK WSD1-A115-C-J. Welder is identified as 070212 ZPMC QC is identified as Guo Peng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

FCAW welding process of weld joint 62B located on PCMK ESD1-FBSA4-2A/C. Welder is identified as 070254 ZPMC QC is identified as He Gen. The welding variables recorded by QC appeared to comply with the WPS-B-T-4232-TC-U5-F.

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

### Summary of Conversations:

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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 134-8257-0045, 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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