

**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-008259**Date Inspected:** 08-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:** Wei Shong Shi**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.

This QA Inspector randomly observed the following work in progress

BAY#10

SAW welding process of weld joint 5A located on PCMK SSD1-FDSA4-1A/C. Welder is identified as 227745 ZPMC QC is identified as Luwei 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 1A located on PCMK NSD1-A112B/H. Welder is identified as 040252 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2B-F.

SAW welding process of weld joint 97A located on PCMK NSD1-166E/J. Welder is identified as 0503060 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-CU2B-S.

SAW welding process of weld joint 2A located on PCMK NSD1-TL8B/L. Welder is identified as 051413 ZPMC QC is identified as Wei Shong Shi. The welding variables recorded by QC appeared to comply with the

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WPS-B-T-2221-B-L2A-S

BAY#11

SAW welding process of weld joint 25 located on PCMK ESD1-FESA4-2-A/F. Welder is identified as 067993 ZPMC QC is identified as Yuan Wenjie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2321-B-P3-S-2.

SAW welding process of weld joint 17 located on PCMK ESD1-FESA4-2-A/F. Welder is identified as 067888 ZPMC QC is identified as Yuan Wenjie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2321-B-P3-S-2.

SAW welding process of weld joint 18A located on PCMK WSD1-F2-SA4-4A/F. Welder is identified as 047304 ZPMC QC is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221B-U3C-S2.

SAW welding process of weld joint 13A located on PCMK WSD1-F2-SA4-4A/F. Welder is identified as 062611 ZPMC QC is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221B-U3C-S2.

OBG TRIAL ASSEMBLY YARD

SMAW welding process of weld joint 006 located on PCMK CA017. Welder is identified as 220068 ZPMC QC is identified as Zheng Zheng Mao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4B-FCM.

FCAW welding process of weld joint 001 located on PCMK OBE5A. Welder is identified as 053609 ZPMC QC is identified as Zheng Zheng Mao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T.

FCAW welding process of weld joint 002 located on PCMK OBE5A. Welder is identified as 048801 ZPMC QC is identified as Zheng Zheng Mao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T.

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 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