

**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-008341**Date Inspected:** 11-Jul-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

<b>CWI Name:</b>	Zhu Zheng Hai & Shen Fu You			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	OBG Bays 13 & 14		

**Summary of Items Observed:**

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

This QA Inspector randomly observed the following work in progress:

OBG - BAY No. 13

Shielded Metal Arc Welding Process:

Welding of weld joint SEG043A-010 located on OBG Segment 8AW. Welder is identified as 067656. ZPMC QC is identified as Zhu Zheng Hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2214-TC-U4b-FMC-1.

Welding of weld joint SEG045-024 located on OBG Segment 8BW. Welder is identified as 201087. ZPMC QC is identified as Zhu Zheng Hai. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-B-U2.

OBG - BAY No. 14

Flux Cored Arc Welding Process:

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## WELDING INSPECTION REPORT

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Welding of weld joint SSD14A-PP53-242 located on OBG Segment 7CW. Welder is identified as 045175. ZPMC QC is identified as Shen Fu You. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

**Summary of Conversations:**

Only general conversation was held between QA and QC concerning this project.

**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 Eric Tsang, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	O'Kane,Rory	Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer
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