

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-008352**Date Inspected:** 21-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>

**Bridge No:** 34-0006**Component:** OBG Bays 13, 14 & 19**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.

OBG - BAY No. 13

Shielded Metal Arc Welding Process:

Welding of weld joint SEG045A-SSD13A-PP65-127 located on OBG Segment 8BW. Welder is identified as 044772. ZPMC QC is identified as Zhu Zheng Hai. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4b-FCM-1.

OBG - BAY No. 14

This QA Inspector noted installation of the following Structural Framing Components:

OBG Segment 9BE (Panel Point 74) FB012-024, FB014-030, SSD16/16A-PP074

OBG Segment 9BE (Panel Point 75) FB012-023, FB014-035, SSD17/17A-PP075

OBG - BAY No. 19

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The components are identified as Suspender Brackets. The weld designations reviewed are as follows:

SB012-054-003, 027, 040, 029, 053, 065, 059

SB014-056-021, 028, 039, 045, 030, 054, 059

SB013-066-002, 027, 040, 029, 053, 035, 060

SB016-070-002, 021, 045, 051, 041, 066, 036

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

**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.

---

<b>Inspected By:</b>	O'Kane,Rory	Quality Assurance Inspector
----------------------	-------------	-----------------------------

---

<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer
---------------------	----------------	-------------