

**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-008543**Date Inspected:** 29-May-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:** Li Ming**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 4A located on PCMK SSD1-FASA4-1A/E. Welder is identified as 201750 ZPMC QC is identified as Weng Zhong wan. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U3C-S2.

BAY#11

SAW welding process of weld joint 121A located on PCMK WSD1-A115E/J. Welder is identified as 056975 ZPMC QC is identified as Li Hong Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2B-S.

SAW welding process of weld joint 1A located on PCMK WSD1-A423B/H. Welder is identified as 042195 ZPMC QC is identified as Li Hong Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2B-S.

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## WELDING INSPECTION REPORT

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SAW welding process of weld joint 5A located on PCMK ESD1-FDSA4-2A/D. Welder is identified as 040772 ZPMC QC is identified as Yun Xiaw. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U2C-S2.

### OBG TRIAL ASSEMBLY YARD

This QA inspector performed weld joint fit up inspection of OBG Segment 5AW to Segment 5BW, prepared fit up report for root gap, offset and groove angle measurements and recorded the measurements on the data sheet that was provided by day shift personnel and handed over to the day shift CALTRANS OSM Quality Assurance Inspector. The members are identified as the weld joint between segment 5AW and 5BW.

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

#### **Summary of Conversations:**

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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