**DEPARTMENT OF TRANSPORTATION**
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

# WELDING INSPECTION REPORT

**Resident Engineer:** Pursell, Gary
**Address:** 333 Burma Road
**City:** Oakland, CA 94607

**Report No:** WIR-008649
**Date Inspected:** 16-Aug-2009

**Project Name:** SAS Superstructure
**Prime Contractor:** American Bridge/Fluor Enterprises, a JV
**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

**OSM Arrival Time:** 700
**OSM Departure Time:** 1900
**Location:** Shanghai,China

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|---|---|---|---|---|---|---|---|
| **CWI Name:** | Lv Li Qing / Shen Fu You | | | **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:** OBG Assembly

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Tim McClendon 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. 14

The QA inspector observed the Root opening on 9CE SSD 020 PP77 fillet weld 129/130 of 10mm for 700mm of weld length. As per AWS D1.5 the maximum root opening for a fillet weld shall be 5mm. ZPMC will change fillet weld 129/130 to intermittent fillet and Complete Joint Penetration weld for the length where the root opening exceeds 5mm. See photographs for more information.

Shielded Metal Arc Welding (SMAW) on Floor Beam (FL2-1) to Floor Beam (FL1) of SEG 052 SSD 017A PP75 weld Number 009 for Segment 9BE. The ZPMC welder identified as 043661 were welding in the 4G position. The ZPMC QC identified as Li Ming Yang was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-P2214-B-4Ub-FCM-1.

Shielded Metal Arc Welding (SMAW) on Floor Beam (FL2-1) to Floor Beam (FL1) of SEG 052 SSD 17A PP75 weld Number 010 for Segment 9BE. The ZPMC welder identified as 200113 were welding in the 4G position. The ZPMC QC identified as Li Ming Yang was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-P2214-B-4Ub-FCM-1

# WELDING INSPECTION REPORT

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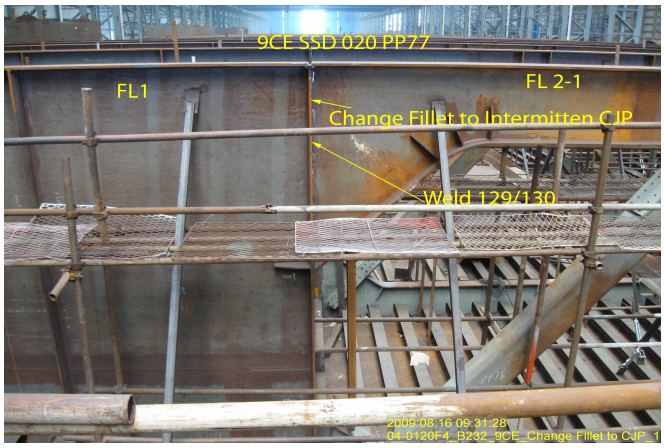
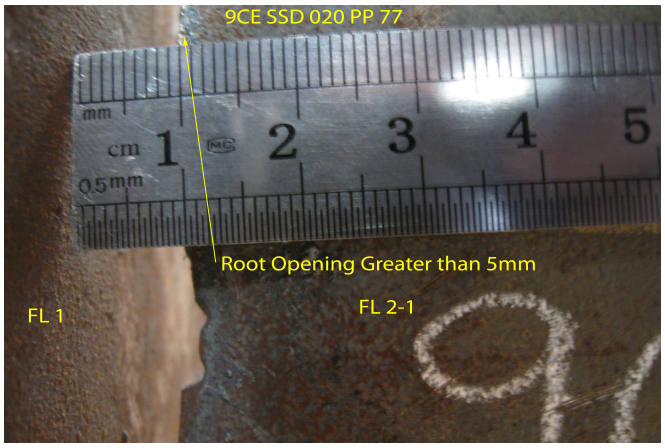
Flux Cored Arc Welding (FCAW) of Longitudinal Diaphragm to Floor Beam (FL1) for SEG 50C weld number 032, 033, 034 for Segment 9AE. The ZPMC welder identified as 048038 was welding in the 2G position. The ZPMC QC identified as Guo Xing Hui was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2233-Tc-4Ub-F.

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




**Summary of Conversations:**

No relevant conversations spoken on this date.

**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 (15000422372), who represents the Office of Structural Materials for your project.

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|---|---|---|
| **Inspected By:** | McClendon,Timothy | Quality Assurance Inspector |
| **Reviewed By:** | Patterson,Rodney | QA Reviewer |