

**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-008687**Date Inspected:** 22-Aug-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**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 West Assembly

Currently ZPMC has placed floor beam segments at various panel point in west segments. Fit-up on these Floor beam segments is not complete at the present time and the floor beams are held in place at their proper location using temporary attachments. ZPMC will perform proper fit-up at a later date. See photographs for additional information.

OBG Bay No. 14 East Assembly

Shielded Metal Arc Welding (SMAW) of CJP welds of T - Stiffeners on Side Panel SP626 - 001 OBG assembly weld number 067 ~ 072 for Segment 9DE. The ZPMC welder identified as 043661 was welding in the 4G position.

The ZPMC QC identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2214-B-U2-FCM-1.

Shielded Metal Arc Welding (SMAW) of CJP welds of T - Stiffeners on Side Panel SP587 OBG assembly weld numbers 037, 039 ~ 042, 046, 047 for Segment 9DE. The ZPMC welder identified as 200113 was welding in the

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# WELDING INSPECTION REPORT

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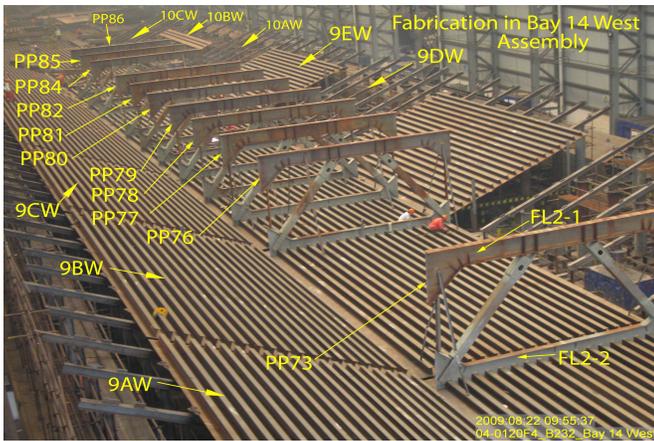
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4G position. The ZPMC QC identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2214-B-U2-FCM-1.

Flux Cored Arc Welding (FCAW) of Deck Panel Diaphragm to Floor Beam on weld joint SEG 050 SSD019 – PP73 for OBG assembly weld numbers 004/005 for Segment 9AE. The ZPMC welders identified as 066064 and 066825 were welding in the 2F position. The ZPMC QC identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2132.

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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<b>Inspected By:</b>	McClendon, Timothy	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson, Rodney	QA Reviewer

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