

**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-008693**Date Inspected:** 30-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 Assembly Bay 14

This Quality Assurance Inspector (QA) observed that it appears the contractor will deviate from the weld joint design specified on the approved drawings. The contractor appears to have Fit-Up Floor Beam located at Panel Point (PP) 73 with a root opening of greater than 5mm which will require a CJP weld and not a Fillet weld which is required on the approved drawings.. This condition exists in the following location; OBG segment 9AW @ PP073 for weld joining Floor Beam FB003-131 to Floor Beam FB016-029.

This Quality Assurance Inspector (QA) observed that the contractor corrected misalignment on 9AW PP73 Floor Beam FB009-024 (FL1) to FB009-137 (FL2-2) by removing base metal by grinding from FB003-137. Approximately 5mm of base metal was removed on FB003-137.

Flux Cored Arc Welding (FCAW) on floor beam (FL1) to floor beam (FL2-2) of weld joint SEG058 - SSD19 - PP83 for OBG assembly weld number 135 for Segment 9EE. The ZPMC welders identified as 055564 was welding in the 3G position. The ZPMC QC identified as Zhong Guo Hui was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the

# WELDING INSPECTION REPORT

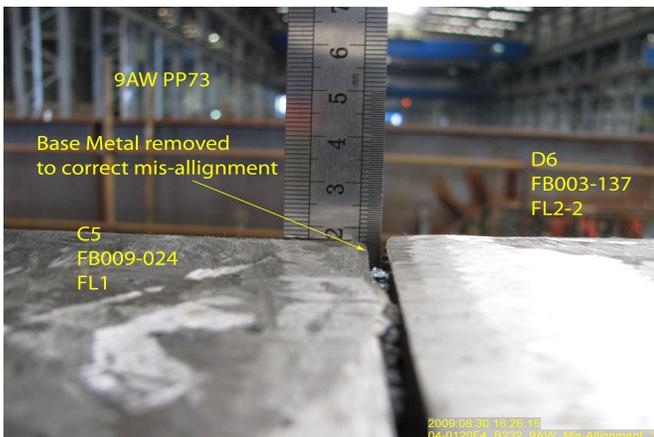
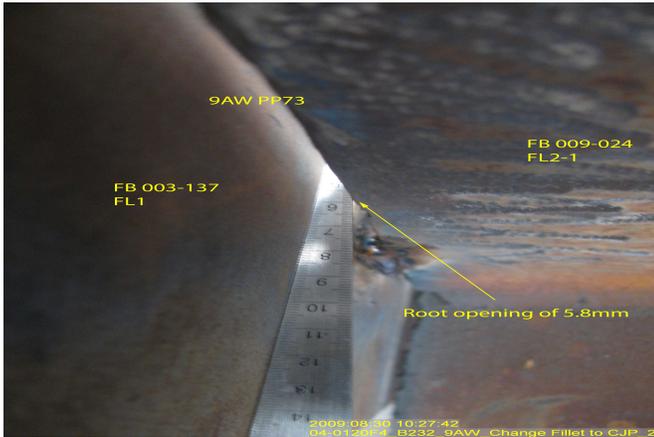
( Continued Page 2 of 3 )

WPS-B-T-2233-B-U2-F.

Flux Cored Arc Welding (FCAW) on floor beam (FL1) to floor beam (FL2-2) of weld joint SEG058 - SSD19A - PP83 for OBG assembly weld number 131 for Segment 9EE. The ZPMC welders identified as 055564 was welding in the 3G position. The ZPMC QC identified as Zhong Guo 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-B-U2-F.

Flux Cored Arc Welding (FCAW) on Longitudinal Diaphragm to bottom panel of weld joint SEG056C for OBG assembly weld number 038 and 039 for Segment 9DE. The ZPMC welders identified as 214945 was welding in the 2F position. The ZPMC QC identified as Zhong Guo 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-2132.

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



---

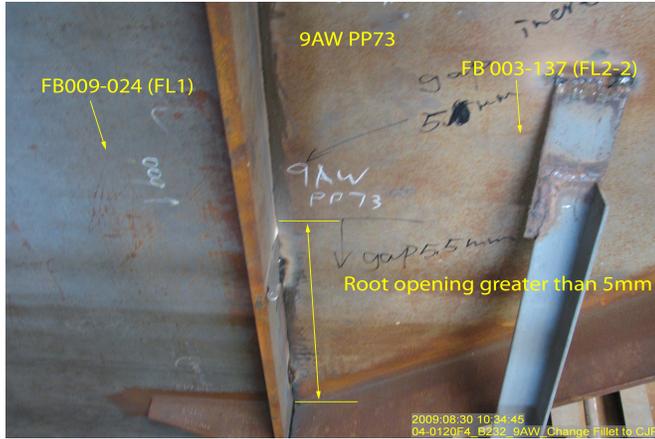
---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---



### 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.

---

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

---