

**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-008700**Date Inspected:** 17-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Zhan Hai Feng/ Guo Yuan Ting	<b>CWI Present:</b>	Yes	No	
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes	No	N/A
		<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG Components		

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

**Bay #1**

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

- ( CB201F-007-002)
- ( CB201C-007-001)
- ( CB201C-007-002)
- ( CB201C-007-003)

**Bay #2**

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

- ( FB3060-001-020)
- ( FB3062-001-020)
- ( FB3067-001-002)
- ( FB3067-002-014)
- ( FB3066-001-002)
- ( FB3064-001-014)
- ( FB3011-001-002)

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This QA inspector observed the following work in progress:

### Bay#1

FCAW welding of weld joint FB204-013-063, 065 located on CB007. Welder is identified as 054460(3G). ZPMC QC-CWI is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB204-014-063, 065 located on CB007. Welder is identified as 054460(3G). ZPMC QC-CWI is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB204-015-063, 065 located on CB007. Welder is identified as 216575(3G). ZPMC QC-CWI is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB204-016-063, 065 located on CB007. Welder is identified as 216575(3G). ZPMC QC-CWI is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint CB201G-016-115~138, CB201G-015-115~138 located on CB007. Welder is identified as 216575(3G). ZPMC QC-CWI is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint CB201G-013-115~138, CB201G-014-115~138 located on CB007. Welder is identified as 054460(3G). ZPMC QC-CWI is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

### Bay#2

Root Pass performed by FCAW welding of weld joint FB3081-001-081, 101, 079, 078 located on FB3081-001. Welder is identified as 062708 (1G). ZPMC QC-CWI is identified as Zhan Yaxu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Root Pass performed by FCAW welding of weld joint FB3031-001-081, 101, 079, 078 located on FB3031-001. Welder is identified as 062708 (1G). ZPMC QC-CWI is identified as Zhan Yaxu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3005-002-005~020 located on FB3005-002. Welder is identified as 066164 (1G) & 068918 (1G). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

### Bay#3

FCAW welding of weld joint FB204-041-26, 27, 32, 33, 41, 42, 40, 46 located on FB204-041. Welder is identified as 044830 (3G). ZPMC QC-CWI is identified as Yin Dong Hai. The welding variables recorded by QC appeared

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to comply with the Applicable WPS.

FCAW welding of weld joint FB204-042-26, 27, 32, 33, 41, 42, 40, 46 located on FB204-042. Welder is identified as 044830 (3G). ZPMC QC-CWI is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay#8

SAW welding of weld joint CB202C-013-001 located on CB013. Welder is identified as 207463 (1G). ZPMC QC-CWI is identified as Zhang Jing Xin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

During random visual inspection of subassembly in bay#3, Caltrans Quality Assurance (QA) Inspector discovered that heat straightening performed after NDT on web to flange joint, FB023-011-125, 126 and 127. Required NDT was completed and accepted by CT and ZPMC. According to approved HSR procedure HSR (B)-309 required NDT performed after heat straightening. Weld joint This QA inspector void all NDT performed on these welds. This QA Inspector submits a TL015 Incident report.

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

**Summary of Conversations:**

No relevant conversations.

**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 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Patel,Hiranch	Quality Assurance Inspector
<b>Reviewed By:</b>	Prue,Erik	QA Reviewer

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