

**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-008891**Date Inspected:** 06-Sep-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**CWI Name:** Chen Xi**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 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.

This QA inspector observed the following work in progress:

Bay#1

FABRICATION/NDE IN PROGRESS:-

Counter Weights; Cross Beam and Cable tray supports

Counter weights (components):-

Total 19 Numbers of counter weights CW001 for Panel Point Lift- PP048~PP080

Total 10 Numbers of counter weights CW002 for Panel Point Lift- PP082~PP104

Cross Beam (CB 007):- 100% welding completed, Rectification work is in progress. All NDT work completed except Floor Beam joints (Web to Flange). Completion 90%

Cross Beam (CB 015):- Welding of Side plates completed. All other welding is in progress. NDT of all Side plate Butt Weld joint is completed. Completion 20%

FCAW welding of weld joint CW002B-PP096-004~023 located on Counter Weight CW002B-PP096. Welder is identified as 054460 (2F/3F). ZPMC QC-CWI is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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FCAW welding of weld joint CW002B-PP098-004~023 located on Counter Weight CW002B-PP098. Welder is identified as 059450 (2F/3F). ZPMC QC-CWI is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay#2

FABRICATION/NDE IN PROGRESS:-

Deck Plate of lift 9CW/9DW, FL1, FL2

Welding of Floor Beam (FL1 & FL2) of lift 12 is in progress

Welding of Deck Plate for Lift 9CW and 9DW is in Progress.

Lift 9CW Weld#Seg053\*-002, Seg053\*-005 and Seg053\*-006

Lift 9DW Weld#Seg055\*-003

FCAW welding of weld joint Seg053-003 located on Seg9CW. Welder is identified as 207540 (1G). ZPMC QC-CWI is identified as Zhu Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SAW welding of weld joint Seg055-004 located on Seg9DW. Welder is identified as 050323 (1G). ZPMC QC-CWI is identified as Zhu Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3043-001-001, 002 located on FB3043-001. Welder is identified as 045203 (2F). ZPMC QC-CWI is identified as Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3018-001-010, 028, 006 located on FB3018-001. Welder is identified as 062438 (2F). ZPMC QC-CWI is identified as Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay#3

FABRICATION/NDE IN PROGRESS:-

Cross Beam (CB-14): Welding of Side Plate, Bottom Plate and Deck Plate are completed. NDT is completed on Side Plate# CB202D and CB202F is complete.

Floor Beam (FL3) Lift-11 (3Nos) are in progress.

Corner Segment Assembly: Approximately 50% welding of corner segment assembly of lift 11 and 10 are completed by ZPMC. 30% NDT work is complete by ZPMC and CT.

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

**Summary of Conversations:**

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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
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<b>Reviewed By:</b>	Prue,Erik	QA Reviewer
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