

**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-009116**Date Inspected:** 02-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:** Lv Li qing**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, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

**BAY#13**

This QA Inspector observed the following work in progress:

FCAW welding of weld joint 1G-009 located on PCMK SEG070A of 11CE welder is identified as 044801. ZPMC QC is identified as Mr. Tang ya jun . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-B-U2-F.

SAW welding of weld joint 1G-003 located on PCMK SEG070A of 11CE welder is identified as 068753. ZPMC QC is identified as Mr. Tang ya jun. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2c-S-2.

SMAW welding of weld joint 4F-137 located on PCMK SSD10A-PP62 of 8AW welder is identified as 067764. ZPMC QC is identified as Mr. Gang xing Hui. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-FCM-1.

SMAW welding of weld joint 4G-253 located on PCMK SSD12A-PP64 of 8AW welder is identified as 067656. ZPMC QC is identified as Mr. Gang xing hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2214-Tc-U4b-FCM.

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## WELDING INSPECTION REPORT

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Fit up of weld joint SEG069A 1G-008 Dimension and Tack weld checked with ZPMC QC Mr.Tang ya jun to comply with the WPS-B-T-2221-B-L2c-S-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 members are identified as Segment 10AE. The weld designations reviewed are as follows:

SEG060A-007,015.

SEG060A-011-Rejected.

During a random 10% verification Ultrasonic Testing (UT) on weld joint is identified as SEG060A-011 the Caltrans Quality Assurance inspector discovered an indication coming under class A Flaw. that non conforming indication measuring approximately 20 mm in length. This weld was previously tested and accepted by ZPMC QC UT technician. For more information please the Incident report 04-0120F4\_TL-15\_B255\_09-02-09\_Seg 10AE Rejectable\_UT\_Indication

BAY#19

Witnessed of ongoing ZPMC MT of BP025A-007 carried out. The MT technician identified as a Mr. Xu Hua Qing.

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

**Summary of Conversations:**

No Relevant Conversation.

**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 Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Chadra	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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