

**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-009203**Date Inspected:** 13-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shi Lin**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 and Tower**Summary of Items Observed:**

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

**OBG Trial Assembly-**

This Quality Control Inspector observed ZPMC personnel performing the following work: Shielded Metal Arc Welding of OBG segment 1AAE bottom panel base material adjacent to 1AAE to 1AE transverse Splice weld (bike path side) and 1AE side panel base material adjacent to the bottom panel to Side panel longitudinal splice weld. The welding appeared to be for correcting distortion. Caltrans QA generated an incident report for this date. The welder was identified as 045196. ZPMC QC was identified as Shi Lin. The welding procedure specification listed on the Weld repair report 7493 and 7494 was WPS-345-SMAW-4G (4F)-FCM Repair. See attached photograph.

QA observed ZPMC repairing OBG segment 2AW lower Floor Beam to Longitudinal diaphragm cope holes at panel point 13 and 14 on the counterweight side.

QA observed ZPMC grit blasting OBG segment 3BE side panels.

**Bay 10-**

This QA Inspector observed the following work in progress: FCAW welding of North Tower Lift 3 diagonal plate

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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internal stiffener weld NSTL3-3 I/K-113 . ZPMC welder was identified as 057244. ZPMC QC is identified as Liu Zhong An. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2233-B-U2-F.

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



### Summary of Conversations:

As identified within the contents of this report.

### 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>	Viars,Larry	Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer
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