

**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-009208**Date Inspected:** 21-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:** Li Ming**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 Bay 2-

This QA Inspector observed the following work in progress: FCAW welding of OBG segment Floor beam weld FB3090-001-056. ZPMC welder was identified as 045203. ZPMC QC is identified as Li Zhi Jiang. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132-3.

FCAW welding of OBG segment Floor beam weld FB3098-001-007. ZPMC welder was identified as 206358. ZPMC QC is identified as Li Zhi Jiang. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132-3.

Bay 10-

This QA Inspector observed the following work in progress: SMAW tack welding of South Tower Skin A to B corner joint SSTL4-1 B/L-4A. ZPMC welder was identified as 040453. ZPMC QC is identified as Li Ming. The welding appeared to be in conformance with welding procedure specification, WPS-B-P-3214-C-U2.

SMAW tack welding of South Tower Skin Plate B to C corner joint SSTL4-1 B/L-5A. ZPMC welder was identified as 040256. ZPMC QC is identified as Li Ming. The welding appeared to be in conformance with welding procedure specification, WPS-B-P2214-C-U2.

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# WELDING INSPECTION REPORT

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Bay 9-

This Caltrans QA Inspector performed Magnetic Particle Testing verification of OBG Deck Panel DP3030-001-001 through 010 tack welds after ZPMC initial MT inspection. ZPMC personnel have made repairs of areas found unacceptable. ZPMC has not performed the final MT of the repair areas. No relevant indications were found during this in process inspection.

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

**Summary of Conversations:**

Only general conversation between QC and QA occurred 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, 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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