

**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-009324**Date Inspected:** 19-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia, 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:** Tower/OBG**Summary of Items Observed:**

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

BAY#10

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 84A located on PCMK SSSL3-1B/K. Welder is identified as 040261ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F) Repair.

FCAW welding process of weld joint 2A located on PCMK NSD1-SPSA3-56. Welder is identified as 040533 ZPMC QC is identified as Ma Yun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U5-F.

FCAW welding process of weld joint 84A located on PCMK SSSL3-1B/K. Welder is identified as 053980 ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F) Repair.

FCAW welding process of weld joint 84A located on PCMK SSSL3-1B/K. Welder is identified as 040343ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the

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WPS-345-FCAW-2G (2F) Repair.

FCAW welding process of weld joint 84A located on PCMK SSSL3-1B/K. Welder is identified as 050041ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F) Repair.

BAY#11

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 77 located on ESTL3-4K/J. Welder is identified as 041271 ZPMC QC is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F) Repair.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 1AAE-1AE

SMAW welding process of weld joint 001 located on PCMK OBE1. Welder is identified as 045196 ZPMC QC is identified as Zhang Hai Tao. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F) Repair. The weld repair report appeared a B-WR7711 and ZPMC Ultrasonic report noted as B787-UT-8332-4

OBG SEGMENT 1AAW-1AW

FCAW welding process of weld joint 003 located on 0BW1A. Welder is identified as 048659 ZPMC QC is identified as Feng Ya Jun. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1. The weld repair report appeared as a B-WR7652 and ZPMC Ultrasonic report noted as B787-UT-8723

OBG SEGMENT 4AW-4BW

This QA Inspector observed ZPMC personnel performing spray painting in OBG segment 4AW and 4BW

BAY#09

MAGNETIC PARTICLE INSPECTION

This Caltrans QA Inspector performed approximately 15% Magnetic Particle Testing verification of OBG Deck panel U rib 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. The Following panels were tested

DP3003-001-001 through 008

DP3043-001-001 through 008

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Unless otherwise noted, all work observed on this dated 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 Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

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

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