

**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-009325**Date Inspected:** 21-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:** Ma Yun, Lvli 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:** 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.

SMAW welding process of weld joint 12B located on PCMK ED1-A6003-6. Welder is identified as 040333ZPMC QC is identified as Ma Yun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2212-TC-U5-B.

FCAW welding process of weld joint 4B located on PCMK NSD1-SPSA3-56. Welder is identified as 040533ZPMC 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 02 located on PCMK NSD1-A803B/B-6. Welder is identified as 052075 ZPMC QC is identified as Shi Jing Wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2131-TC-P4-F.

FCAW welding process of weld joint 06 located on PCMK NSD1-A683B/B-2. Welder is identified as 057180 ZPMC QC is identified as Pan Wen Long. The welding variables recorded by QC appeared to comply with the

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WPS-B-T-2133-TC-F.

BAY#11

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 28 located on PCMK WSTL3-4K/K. Welder is identified as 049220 ZPMC QC is identified as Guo Peng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2A-F.

FCAW welding process of weld joint 12 located on PCMK WSTL3-4K/K. Welder is identified as 040713 ZPMC QC is identified as Guo Peng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2A-F.

FCAW welding process of weld joint 36 located on PCMK WSTL3-4K/K. Welder is identified as 046706 ZPMC QC is identified as Guo Peng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2A-F.

BAY#14

This QA Inspector randomly observed the following work in progress.

SAW welding process of weld joint 002 located on PCMK SEG074A. Welder is identified as 062406 ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2C-S-2.

SMAW welding process of weld joint 004 located on PCMK SEG060. Welder is identified as 200113 ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F) Repair.

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

DP3041-001-001 through 008

DP3040-001-001 through 006

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

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**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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