

**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-009403**Date Inspected:** 13-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 Liaing**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, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

During random visual inspection, This QA inspector found a total of twenty (20) linear indications in the tack welds on segment 9CE. The weld number is identified as SSD16A-PP080-004. ZPMC QC ground the tack welds out and confirmed its removal by Magnetic Particle Testing prior to welding. For further information, please see attached pictures.

During random visual inspection of Segment 9CE, This QA inspector found 20mm misalignment on weld joint number SSD020-PP079-009. ZPMC personal were observed using a Chain Hoist to pull that plate and minimize the misalignment. For further information, please see attached pictures.

This QA inspector observed the following work in progress:

Bay#14, Seg9E

SMAW welding of weld joint Seg52A-026, 024 located on Segment 9CE. Welder is identified as 067609/ 067764 (4G). ZPMC QC-CWI is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint SSD020-PP77-221, 231, 241, 251, 220, 230, 240, 250 located on Segment 9CE.

Welder is identified as 044795 (1G). ZPMC QC-CWI is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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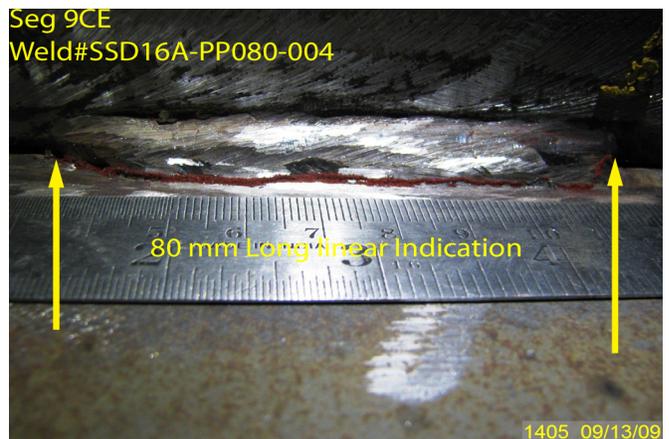
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FCAW welding of weld joint SSD020A-PP77-221, 231, 241, 251, 220, 230, 240, 250 located on Segment9CE. Welder is identified as 044774 (1G). ZPMC QC-CWI is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint Seg52\*-009, 010, 036, 011, 012 located on Segment9CE. Welder is identified as 206623 (3G). ZPMC QC-CWI is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SMAW welding of weld joint Seg52\*-013, 014, 037, 015, 016 located on Segment9CE. Welder is identified as 044779 (3G). ZPMC QC-CWI is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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

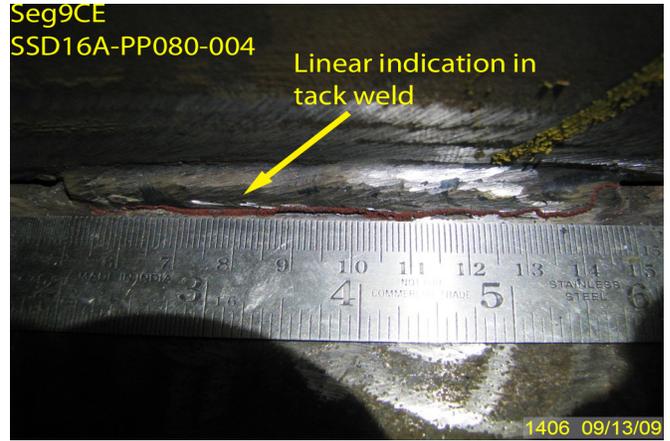


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## Summary of Conversations:

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 Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Patel,Hiranch	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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