

**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-009405**Date Inspected:** 14-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:** Shen Fu You**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.

**Segment 6BW**

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(Seg029A-007)

-(Seg029A-004)

**Segment 7BE**

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(SSD16A-PP050-003)

-(SSD17A-PP051-003)

This QA inspector observed the following work in progress:

Bay#14, Seg9E

SMAW welding of weld joint Seg064B-033~041 located on Segment 10CE. Welder is identified as 200113 (4G/2G). ZPMC QC is identified as Geng Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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## WELDING INSPECTION REPORT

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FCAW welding of weld joint CSD6-PP090-075~084 located on Segment10BE. Welder is identified as 055564 (2F). ZPMC QC is identified as Geng Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint Seg064C-012, 019 located on Segment10CE. Welder is identified as 214945 (3G). ZPMC QC is identified as Geng Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint Seg064C-002 located on Segment10CE. Welder is identified as 058551 (1G). ZPMC QC is identified as Geng Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint CSD2-PP89.5-133, 134, 135, 136, 139, 140 located on Segment10CE. Welder is identified as 055491 (1G). ZPMC QC is identified as Geng Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint SSD20-PP079-221, 231, 220, 230 located on Segment9CE. Welder is identified as 044795 (1G). ZPMC QC is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint SSD20A-PP079-220, 230, 221, 231 located on Segment9CE. Welder is identified as 044774 (1G). ZPMC QC is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SMAW welding of weld joint Seg52A-026, 024 located on Segment9BE. Welder is identified as 067609/067764 (4G). ZPMC QC 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.

**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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