

**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-009449**Date Inspected:** 30-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 Ming, Tu Jun**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.

This QA Inspector observed ZPMC welder Yu Chaoye stencil 053869 performing FCAW process for the weld joint 3B located on PCMK SSSL4-1B/L. The QA Inspector observed that welder Yu Chaoye is certified to make this weld. ZPMC QC Mr. Li Ming monitoring this welding. The welding variables recorded by QC appeared to comply with the Caltrans engineer approved procedure i.e. WPS-B-T-2332-TC-U4B-F.

This QA Inspector observed ZPMC welder Ni Xiuba stencil 040533 performing FCAW process for the weld joint 5B located on PCMK SSSL4-1B/L. The QA Inspector observed that welder Ni Xiuba is certified to make this weld. ZPMC QC Mr. Li Ming monitoring this welding. The welding variables recorded by QC appeared to comply with the Caltrans engineer approved procedure i.e. WPS-B-T-2332-TC-U4B-F.

This QA Inspector observed ZPMC welder Wang Gong Zhi stencil 050041 performing FCAW process for the weld joint 4B located on PCMK SSSL4-1B/L. The QA Inspector observed that welder Wang Gong Zhi is certified to make this weld. ZPMC QC Mr. Li Ming monitoring this welding. The welding variables recorded by QC appeared to comply with the Caltrans engineer approved procedure i.e. WPS-B-T-2332-B-U4B-F-1.

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This QA Inspector observed ZPMC welder Dong Yumei stencil 054069 performing FCAW process for the weld joint 29 located on PCMK NSTL3-3K/K. The QA Inspector observed that welder Dong Yumei is certified to make this weld. ZPMC QC Mr. Tu Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the Caltrans engineer approved procedure i.e. WPS-B-T-2233-B-U2A-F-1.

This QA Inspector observed ZPMC welder Buxue Zhen stencil 052075 performing FCAW process for the weld joint 34 located on PCMK NSTL3-3K/K. The QA Inspector observed that welder Buxue Zhen is certified to make this weld. ZPMC QC Mr. Tu Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the Caltrans engineer approved procedure i.e. WPS-B-T-2233-B-U2A-F-1.

BAY#11

This QA Inspector randomly observed the following work in progress.

This QA Inspector observed ZPMC welder Wang Bing stencil 040713 performing FCAW process for the weld joint 25 located on PCMK ED1-A435B/C-2. The QA Inspector observed that welder Wang Bing is certified to make this weld. ZPMC QC Mr. Yuchi Guo monitoring this welding. The welding variables recorded by QC appeared to comply with the Caltrans engineer approved procedure i.e. WPS-B-T-2331-TC-P4-F.

This QA Inspector observed ZPMC welder Li Xiuchun stencil 040733 performing SMAW process for the weld joint 1A located on PCMK ED1-SA183-38M-4. The QA Inspector observed that welder Li Xiuchun is certified to make this weld. ZPMC QC Mr. Li Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the Caltrans engineer approved procedure i.e. WPS-485-SMAW-2G (2F) Repair.

FCAW welding process of weld joint 40 located on PCMK ESTL4-2C/C. Welder is identified as 070140 ZPMC QC is identified as Cao Cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-4132.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 5BW- 5CW

This QA Inspector observed ABF NDT Inspectors performing magnetic particle inspection on the weld deck panel diaphragm to upper floor beam flange at PP33, 34, 35, and 36 both east and west side.

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

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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
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<b>Reviewed By:</b>	Dawson,Paul	QA Reviewer
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