

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-009475**Date Inspected:** 09-Oct-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

<b>CWI Name:</b>	Xu Xian Ping		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	Yes	No	N/A

**Bridge No:** 34-0006**Component:** OBG & TOWER Components**Summary of Items Observed:**

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

**BAY 2**

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint # 036 located on Floor Beam FB3038 – 001. Welder is identified as 062438.

ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

FCAW process welding of weld joint # 004 located on Floor Beam FB3038 – 001. Welder is identified as 062438.

ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

**BAY 3**

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

## Magnetic Particle Testing

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Component. The weld designations reviewed are as follows:

1. CSD6 – PP096 – 095~100
2. CSD6 – PP097 – 095~100
3. CSD6 – PP095 – 095~100
4. CSD6 – PP101 – 095~100
5. CSD6 – PP102 – 095~100

## BAY 5

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint # 014 located on Traveler Rail 11TR2 – 012. Welder is identified as 068858.

ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

SMAW process welding of weld joint # 068 located on Bike Path BK001 – 031. Welder is identified as 215248.

ZPMC CWI (QC) is identified as Li yang. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2133 – B – U2.

## BAY 6

### Tower

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #1B located on Tower Strut WD1 – A305 – 53M – 1. Welder is identified as 067707. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) – FCM – Repair – 1.

### Cross Beam – 8

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #032 located on Floor Beam FB205 – 019. Welder is identified as 058174. ZPMC QC is identified as Liu Chuan Gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – B – U2 – F.

FCAW process welding of weld joint #029 located on Floor Beam FB205 – 020. Welder is identified as 053742.

---

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

ZPMC QC is identified as Liu Chuan Gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

FCAW process welding of weld joint #032 located on Floor Beam FB205 – 018. Welder is identified as 053609. ZPMC QC is identified as Liu Chuan Gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – B – U2 – F.

Unless otherwise noted, all work 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 - 15000422372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Kumar,Sandeep	Quality Assurance Inspector
----------------------	---------------	-----------------------------

---

<b>Reviewed By:</b>	Hall,Steven	QA Reviewer
---------------------	-------------	-------------