

**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-009511**Date Inspected:** 08-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**CWI Name:** Li zhi jiang**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**Summary of Items Observed:**

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

This QA Inspector randomly observed the following work in progress:

OBG # BAY 01

Shield Metal Arc Welding Process:

Welding of weld joint -127,128,129 located on PCMK CW001-PP076. Welder is identified as 214453. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS-B-P-2113.

Welding of weld joint -127,128,129 located on PCMK CW001-PP056. Welder is identified as 214453. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS-B-P-2113.

OBG # BAY 02

Flux Cored Arc Welding Process:

Welding of weld joint -029,030 located on PCMK FB3045-001. Welder is identified as 045209. ZPMC QC is identified as Zhan hai feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

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## WELDING INSPECTION REPORT

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Welding of weld joint –036 located on PCMK FB3027-001. Welder is identified as 062438. ZPMC QC is identified as Zhan hai feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

Welding of weld joint –010,028 located on PCMK FB3047-001. Welder is identified as 045209. ZPMC QC is identified as Zhan hai feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

OBG # Cross Beam 12 (OPEN YARD)

Flux Cored Arc Welding Process:

Welding of weld joint –166 located on PCMK CB201G-035. Welder is identified as 066687. ZPMC QC is identified as Sun yan fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint –166 located on PCMK CB201G-034. Welder is identified as 066687. ZPMC QC is identified as Sun yan fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

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

**Summary of Conversations:**

No Relevant Conversation

**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 150-00422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Sukanthan,Dhanasingh	Quality Assurance Inspector
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<b>Reviewed By:</b>	Hall,Steven	QA Reviewer
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