

**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-009553**Date Inspected:** 26-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing / 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 Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Tim McClendon 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 Assembly Bay 14

OBG Assembly 10BE PP89 ZPMC has performed flame cutting in order to fit up Deck Panel Diaphragm to Floor Beam. This cutting operation has produced several areas that are not uniform. See photograph for additional information.

Shielded Metal Arc Welding (SMAW) of Floor Beam (FL 2-2) to (FL 1) on weld joint SEG062 SSD19 PP91 OBG assembly weld numbers 133 and 134 for Segment 10BE. The ZPMC welder identified as 067764 was welding in the 4F position. The ZPMC QC identified as Wang Xu was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2114-FCM-1.

Shielded Metal Arc Welding (SMAW) of Floor Beam (FL 2-2) to (FL 1) on weld joint SEG062 SSD19 PP91 OBG assembly weld number 132 for Segment 10BE. The ZPMC welder identified as 067764 was welding in the 4G position. The ZPMC QC identified as Wang Xu was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2214-Tc-U4b-FCM-1.

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

Shielded Metal Arc Welding (SMAW) of Floor Beam (FL 2-2) to (FL 1) on weld joint SEG062 SSD19 PP91 OBG assembly weld number 138 for Segment 10BE. The ZPMC welder identified as 067764 was welding in the 4G position. The ZPMC QC identified as Wang Xu was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2214-B-U2-FCM-1.

Flux Cored Arc Welding (FCAW) on Floor Beam (FL 1) to (FL 2-2) of weld joint SEG062 SSD19A PP89 OBG assembly weld number 134 for Segment 10BE. The ZPMC welder identified as 050242 was welding in the 1G position. The ZPMC QC identified as Wang Xu was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2231-Tc-U4b-F.

Flux Cored Arc Welding (FCAW) on Floor Beam (FL 1) to (FL 2-2) of weld joint SEG062 SSD19A PP89 OBG assembly weld number 128 for Segment 10BE. The ZPMC welder identified as 050242 was welding in the 1G position. The ZPMC QC identified as Wang Xu was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2231-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 spoken on this date.

### 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>	McClendon, Timothy	Quality Assurance Inspector
----------------------	--------------------	-----------------------------

---

<b>Reviewed By:</b>	Patterson, Rodney	QA Reviewer
---------------------	-------------------	-------------