

**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-009598**Date Inspected:** 12-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**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**Summary of Items Observed:**

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

Bay 9-

Caltrans QA Inspector performed Magnetic Particle Testing (MT) verification of OBG deck panel U rib tack welds previously tested by ZPMC. The following panels were tested: DP3025-001, DP3008-001 and DP3010-001. ZPMC has performed the initial MT and grinding of indications. ZPMC has not performed the final MT of tack welds. No relevant indications noted. A TL-6028 report was not generated for this in process verification.

Bay 14-

This QA Inspector observed the following work in progress: Shielded Metal Arc Welding (SMAW) welding of OBG Segment 9AW deck panel diaphragm to floor beam flange fillet weld, SSD13-PP72-004. ZPMC welders were identified as 066478, 058243. ZPMC QC is identified as Shen Fu You. The welding appeared to be in conformance with welding procedure specification, WPS-B-P-2112-FCM-1. After welding was completed QA observed ZPMC personnel perform Post Weld Heat Treatment (PWHT) to an area approximately 5 meters of weld length on the cross beam side of the weld. Weld and base metal in the PWHT area ranged from 250 to 300 Celsius with a hold time of one hour.

Flux Cored Arc Welding (FCAW) welding of OBG segment 9DW FL3 floor beam to side panel panel complete

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joint penetration welds, SEG055A-009 and 010 located at panel point 81. ZPMC welders were identified as 045246 and 058242. ZPMC QC is identified as Shen Fu You. The welding appeared to be in conformance with welding procedure specifications, WPS-B-P-2214-TC-U4b-FCM-1.

SMAW welding of OBG segment 10AE FL3 deck panel to edge panel weld, SEG060-039. ZPMC welders were identified as 066401 and 202122. ZPMC QC is identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specifications, WPS-B-P-2214-TC-U4b-FCM.

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

### Summary of Conversations:

Only general conversation occurred between QC and QA 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, 150 0042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	Dawson,Paul	QA Reviewer

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