

**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-009723**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**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 # Cross Beam 08 (BAY 06)

Flux Cored Arc Welding Process:

Welding of weld joint -029 located on PCMK FB205-020. Welder is identified as 053742. 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.

Welding of weld joint -039,040 located on PCMK 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-TC-U4b-F.

Welding of weld joint -039,040 located on PCMK FB205-020. 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-TC-U4b-F.

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Welding of weld joint –029 located on PCMK FB205-018. Welder is identified as 053742. 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.

OBG # Cross Beam 07 (OPEN YARD)

Flux Cored Arc Welding Process:

Welding of weld joint –097 located on PCMK CB201G-016. Welder is identified as 219188. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F)-Repair-1.

Welding of weld joint –063 located on PCMK CB201G-015. Welder is identified as 219188. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F)-Repair-1.

Welding of weld joint –097 located on PCMK CB201G-015. Welder is identified as 219188. ZPMC QC is identified as Tian Lie. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F)-Repair-1.

OBG # Cross Beam 12 (OPEN YARD)

Flux Cored Arc Welding Process:

Welding of weld joint –166,148 located on PCMK CB201G-036. 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.

OBG # Bay 03

This QA inspector verified that the percentages for QA NDT verification have been completed to date and issued AB F green tags for the following OBG CSD components.

(CSD3-PP095-033~038) Green Tag # 10997  
(CSD3-PP097-033~038) Green Tag # 10998  
(CSD3-PP098-095~105) Green Tag # 10999  
(CSD3-PP100-095~105) Green Tag # 10000  
(CSD3-PP101-033~038) Green Tag # 10001  
(CSD3-PP103-033~038) Green Tag # 10002  
(CSD4-PP098-095~105) Green Tag # 10003  
(CSD4-PP100-095~105) Green Tag # 10004  
(CSD5-PP095-033~038) Green Tag # 10005  
(CSD5-PP097-033~038) Green Tag # 10006  
(CSD5-PP099-095~105) Green Tag # 10007  
(CSD5-PP101-033~038) Green Tag # 10008

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(CSD5-PP103-033~038) Green Tag # 10009  
(CSD6-PP095-033~038) Green Tag # 10010  
(CSD6-PP096-033~038) Green Tag # 10011  
(CSD6-PP097-033~038) Green Tag # 10012  
(CSD6-PP101-033~038) Green Tag # 10013  
(CSD6-PP102-033~038) Green Tag # 10014  
(CSD6-PP103-033~038) Green Tag # 10015  
(CSD6-PP103-095~100) Green Tag # 10021  
(CSD7-PP096-033~038) Green Tag # 10022  
(CSD7-PP102-033~038) Green Tag # 10023  
(CSD9-PP096-095~100) Green Tag # 10024  
(CSD9-PP099-033~038,063,064,140,141,142) Green Tag # 10025  
(CSD9-PP102-095~100) Green Tag # 10026

OBG # Cross Beam 08 (BAY 06)

During random in process inspection Cross Beam 08 in bay 06, this QA inspector observed ZPMC Personnel performing heat straightening the FCW CB202D-008-002 weld joint. See attached photos.

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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**Inspected By:** Sukanthan,Dhanasingh

Quality Assurance Inspector

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**Reviewed By:** Hall,Steven

QA Reviewer