

**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-010103**Date Inspected:** 17-Nov-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:** Lv Li Qing**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.

South of Blast Bay-

This QA inspector performed Ultrasonic Testing (UT) verification of the areas previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member was identified as OBG Segment 7AW. The weld identification numbers are as follows:

Floor beam to deck panel diaphragm welds, SSD13-PP48-004 and SSD13-PP49-004

FL2 to FL1 floor beam flange repair weld, SSD13-PP48-131

Side plate to side plate weld SEG033A-002 (R1) and 010. SEG033A-010 (R1) was found to be noncompliant with AWS D1.5 table 6.3. A 15 mm longitudinal indication with a +2 class A rating was found during testing. Caltrans QA issued an incident report for the missed UT indication.

Bay 13-

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of OBG Segment 11CE lifting lug to Floor beam weld, SSD20-PP103-220. ZPMC welder was identified as 050242. ZPMC QC was

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identified as Zhang Qiao. ZPMC CWI was identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2231-TC-U4b-F-2.

Flux Cored Arc Welding (FCAW) of OBG Segment 11BE floor beam to bottom panel welds, SSD11-PP99-106 and 108. ZPMC welder was identified as 044765. ZPMC QC was identified as Zhang Qiao. ZPMC CWI was identified as Lv Li Qing The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132.

North of Bay 14-

Caltrans QA observed the following work in progress:

ABF UT technicians testing 7BW deck panel diaphragm to floor beam flange CJP weld at PP52.

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

**Summary of Conversations:**

As identified within the contents of this report.

**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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