

**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-010157**Date Inspected:** 30-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**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:** Xu yun min**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 Components**Summary of Items Observed:**

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

**1AAE+1AE**

This QA inspector visually checked excavated areas of weld joint -001 located on PCMK OBE1 Deck Panel of 1AAE-1AE. Excavation was been performed against UT report attached along with Critical Welding Repair Report B-CWR868 Rev.0. Y locations and repair length verified with ZPMC QC Zhang hai tao.

This QA inspector witnessed Magnetic particle Testing (MT) prior to welding of excavated locations of weld joint -001 located on PCMK OBE1 Deck panel of 1AAE-1AE. MT of the area excavated by ZPMC not comply they found transverse indications the locations identified with CWR 868 and Y locations of those area identified approximately 11440,10320,17595,18670,20740.

SMAW repair welding on weld joint 001 located at OBE1 Deck Panel (external). Welder is identified as 045221. ZPMC QC is identified as Zheng Hai Tao. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1 and CWR repair procedure #BCWR-868. Y Location of excavation by above noted welder 045221 is located at approximately 2420 mm and is 130 mm in length.

SMAW repair welding on weld joint 001 located at OBE1 Deck panel (external). Welder is identified as 045138. ZPMC QC is identified as Zheng Hai Tao. The welding variables recorded by QC appeared to comply with

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WPS-345-SMAW-1G (1F)-FCM-Repair-1 and CWR repair procedure #BCWR-868.

Y Location of excavation by above noted welder 045138 is located at approximately 4560 mm and is 140 mm in length.

SMAW repair welding on weld joint 001 located at OBE1 Deck panel (external). Welder is identified as 045221. ZPMC QC is identified as Zheng Hai Tao. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1 and CWR repair procedure #BCWR-868.

Y Location of excavation by above noted welder 045221 is located at approximately 5500 mm and is 400 mm in length.

## OBG # TRIAL ASSEMBLY YARD

This QA inspector performed dimensional check along with ABF on Longitudinal diaphragm for below segments and readings forwarded to OBG SMR for further action.

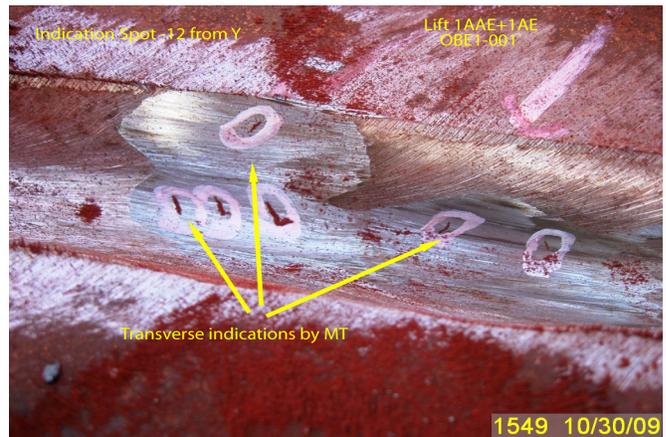
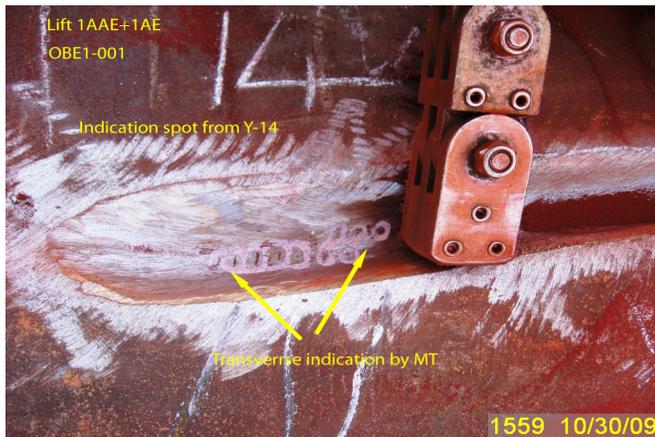
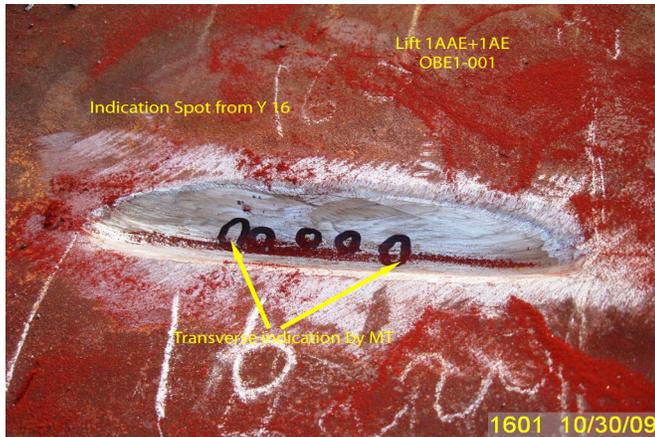
5AE-5BE

5BE-5CE

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

### Summary of Conversations:

No relevant Conversation.



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Item	Description	WBS	Dwg No.	Status
1				

### 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 Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Chadra	Quality Assurance Inspector
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<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer
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