

**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-010179**Date Inspected:** 30-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

<b>CWI Name:</b>	Wu Zhi Cheng/Zheng Hai Tao	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG Components	

**Summary of Items Observed:**

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

**1AAW**

This QA inspector performed UT of Bolt Hole repaired area (Base metal) approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The Plate Number designations reviewed are as follows:

-(1AAW-PL1145R, Bottom Plate)

**1AAW+1AW**

SMAW repair welding on weld joint 003 located at OBW1A bottom plate (internal). Welder is identified as 049769. ZPMC QC is identified as Song Hui. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and CWR repair procedure #BCWR-876.

Y Location of excavation by above noted welder 049769 is located at approximately 3225 mm and is 120 mm in length.

SMAW repair welding on weld joint 003 located at OBW1A bottom plate (internal). Welder is identified as 049769. ZPMC QC is identified as Song Hui. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and CWR repair procedure #BCWR-876.

Y Location of excavation by above noted welder 049769 is located at approximately 2200 mm and is 150 mm in

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length.

SMAW repair welding on weld joint 003 located at OBW1A bottom plate (internal). Welder is identified as 049769. ZPMC QC is identified as Song Hui. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and CWR repair procedure #BCWR-876.

Y Location of excavation by above noted welder 049769 is located at approximately 1400 mm and is 140 mm in length.

SMAW repair welding on weld joint 004 located at OBW1A Side Plate (Cross Beam Side). Welder is identified as 054467. ZPMC QC is identified as Song Hui. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and CWR repair procedure #BCWR-876.

Y Location of excavation by above noted welder 054467 is located at approximately 2920 mm and is 130 mm in length.

SMAW repair welding on weld joint 004 located at OBW1A Side Plate (Cross Beam Side). Welder is identified as 054467. ZPMC QC is identified as Song Hui. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and CWR repair procedure #BCWR-876.

Y Location of excavation by above noted welder 054467 is located at approximately 2730 mm and is 150 mm in length.

SMAW repair welding on weld joint 004 located at OBW1A Side Plate (Cross Beam Side). Welder is identified as 054467. ZPMC QC is identified as Song Hui. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and CWR repair procedure #BCWR-876.

Y Location of excavation by above noted welder 054467 is located at approximately 150 mm and is 130 mm in length.

1AE+1BE

SMAW repair welding on weld joint 008 located at OBE1A bottom plate (internal). Welder is identified as 045196. ZPMC QC is identified as Zheng Hai Tao. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and CWR repair procedure #BCWR-874.

Y Location of excavation by above noted welder 045196 is located at approximately 4675 mm and is 240 mm in length.

SMAW repair welding on weld joint 008 located at OBE1A bottom plate (internal). Welder is identified as 045246. ZPMC QC is identified as Zheng Hai Tao. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and CWR repair procedure #BCWR-874.

Y Location of excavation by above noted welder 045246 is located at approximately 8140 mm and is 350 mm in length.

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

## Summary of Conversations:

No relevant conversations.

## Comments

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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>	Patel,Hiranch	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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