

**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-010310**Date Inspected:** 04-Sep-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 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.

**BAY#14**

FCAW welding of weld joint 2G-004 located on PCMK CA067A of 9EW welder is identified as 0202122.ZPMC QC is identified as Mr. Xuo tao . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-TC-U4b-F.

Weld joint fit-up of following weld joint 2G-003 dimension and tack weld checked with ZPMC QC Mr. Zhang Xian Ji to comply with the WPS-B-T-2231-Tc-U4b-F.

**BAY#13**

This QA Inspector observed the following work in progress:

SMAW welding of weld joint 3G-033 located on PCMK SEG048H of 8CE welder is identified as 058087. ZPMC QC is identified as Mr. Guo xing Hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2213-Tc-U4b-FCM.

SMAW welding of repair weld joint 4G-026 located on PCMK SEG047\* of 8CW welder is identified as 044772.

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# WELDING INSPECTION REPORT

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ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-4G (4F)-repair and WR-7266.

During Visual inspection found five Transverse cracks and one Longitudinal crack found in Segment 8CE,

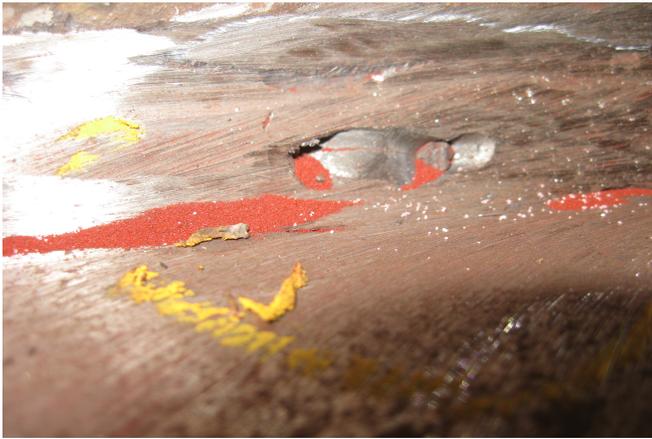
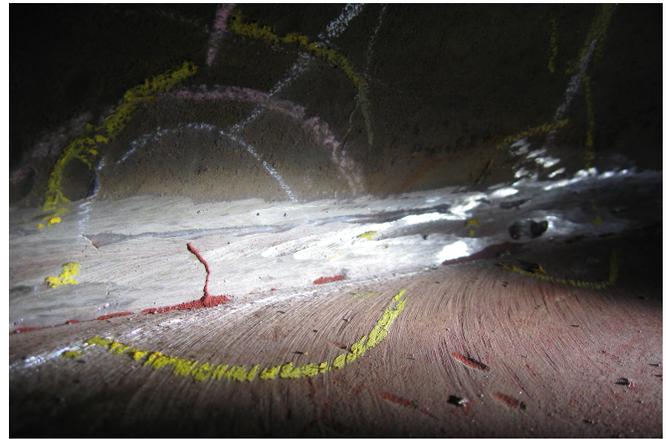
The weld nos are as follows

SSD16A-PP68-005. West side 3 cracks.

SSD18A-PP70-005. East side 3 cracks.

All these cracks marked and informed to ABF QA Mr.Yang Chao and ZPMC QC Mr.Guo xing hui.

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



**Item Description**

**WBS**

**Dwg No.**

**Status**

1

## Summary of Conversations:

No relevant Conversation.

## Comments

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## WELDING INSPECTION REPORT

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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 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
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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