

**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-010318**Date Inspected:** 13-Nov-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:** Shen fu you**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 1G-001 located on PCMK SEG057A of 9EW welder is identified as 066401.ZPMC QC is identified as Mr.Wang xu. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-B-U2-F.

SMAW welding of weld joint 4G-046 located on PCMK SEG055\* of 9DW welder is identified as 045246.ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2214-Tc-U4b-F.

FCAW welding of weld joint 3F-009 located on PCMK DP320-001 welder is identified as 050977.ZPMC QC is identified as Mr. Zhong guo hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2133.

FCAW welding of weld joint 2G-002 located on PCMK SEG063 of 10CW welder is identified as 202122.ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-TC-U4b-F.

BAY#13

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## WELDING INSPECTION REPORT

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SMAW welding of weld joint 4G-015 located on PCMK SEG068A of 11BE welder is identified as 044772.ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-B-U2-FCM-1.

FCAW welding of weld joint 1G-045 located on PCMK SEG066C of 11AE welder is identified as 214945.ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-TC-U4b-F.

This QA inspector performed UT of 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 members are identified as OBG Segment 11BW. The weld designations reviewed are as follows:

SEG067A-011,020.

SEG067A-005- Rejected. Incident report made for this weld.

During random verification Ultrasonic Testing (UT) of the Bottom plate to side plate weld identified as SEG067A-005 in OBG segment 11BW, Caltrans Quality Assurance (QA) Inspector discovered a total of (1) one, rejectable indication that measured 20mm in length. This weld has been previously tested and accepted by ZPMC Quality Control (UT) Technicians. For further information, please see the Incident report 04-0120F4\_TL-15\_B247\_11-13-09\_Seg\_11BW\_Rejectable\_UT\_Indication.

BAY#19

SAW welding of weld joint 1G-001 located on PCMK BP026-013 welder is identified as 062816.ZPMC QC is identified as Mr. Zhu zhong hai. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2C-S-2.

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 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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