

**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-010319**Date Inspected:** 14-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#11

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as Tower Skirt. The weld designations reviewed are as follows:

WD1-A597-A/C-01,03,04,09,13,14,22,24.

WD1-A597-B/C-1-03,06,07.

WD1-A597-B/C-2-01,02,03.

WD1-A597-B/C-3-05,07,11.

WD1-A597-B/C-4-02,05,08.

WD1-A597-B/C-5-01,04,06.

WD1-A597-B/C-6-02,03,04.

WD1-A597-B/C-7-03,05.

WD1-A597-B/C-8-07,11.

WD1-A597-C/C-1-08,09,11.

WD1-A597-C/C-2-03,04.

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WD1-A597-C/C-3-01,02.  
WD1-A597-C/C-4-05,06.  
WD1-A597-C/C-5-11,12.  
WD1-A597-C/C-6-02,09.  
WD1-A597-C/C-7-03,05.  
WD1-A597-C/C-8-01,02.

Following Partial joint penetration weld joint not welded as per drawing, this is confirmed with ABF QA Mr.Li shi you. ZPMC sent this issue to CT Engineer. Green tag not issued.  
WD1-A597-B/C-4-03 .

BAY#14

FCAW welding of weld joint 3F-013 located on PCMK SSD22-PP81.5 of 9DW welder is identified as 215676. ZPMC QC is identified as Mr.Wang xu. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2133.

FCAW welding of weld joint 1G-031 located on PCMK SEG063A of 10CW welder is identified as 201215.ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231T.

FCAW welding of weld joint 3G-008 located on PCMK SSD11-PP93 of 10CW welder is identified as 201215. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-B-U2a-F.

SAW welding of weld joint 1G-006 located on PCMK SEG069\* of 11CW welder is identified as 062406.ZPMC QC is identified as Mr. Geng wei. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2C-S-2.

### OUTSIDE SEGMENTS

FCAW welding of weld joint 2G-004 located on PCMK SSD10-PP57 of 7DW welder is identified as 045280. ZPMC QC is identified as Mr.Wang xian pin. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

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

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## 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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**Inspected By:** Kumar, Chadra

Quality Assurance Inspector

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**Reviewed By:** Patterson, Rodney

QA Reviewer