

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Vallejo, CA 94592-1133  
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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-010336**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>	Shen Fu You	<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 COMPONENT	

**Summary of Items Observed:**

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

Bay #14

This QA Inspector observed the following work in progress:

SMAW in the 3G position of the OBG Segment at 10AW near PP86 weld No. SEG-060D-021. The welder is identified as #215553. ZPMC QC is identified as Mr. Zhaug Ganohui. The welding variables recorded by QC appear to comply with WPS- B – T-2213-Tc-U4b-FCM.

Flux Core Arc Welding (FCAW) in the 3G position of the OBG Deck Panel 'U'-rib to stiffener weld No. DP-156-001-63,68. The welder is identified as #050988. ZPMC QC is identified as Mr. Zhang Xianji. The welding variables recorded by QC appear to comply with WPS- B – T-2233-Tc-U4b-F.

Flux Core Arc Welding (FCAW) in the 2F position of the OBG 'I'-rib to stiffener weld No. SSD-22-PP-085~112. The welder is identified as #203871. ZPMC QC is identified as Mr. Xu Tao. The welding variables recorded by QC appear to comply with WPS- B – T-2132.

SMAW in the 4G position of the OBG Segment at 9DW near PP80 FL1 to FL2, weld No. SSD10A-PP80-009. The welder is identified as #069896. ZPMC QC is identified as Mr. Xu Tao. The welding variables recorded by QC appear to comply with WPS- B – P-2214-Tc-U4b-FCM-1.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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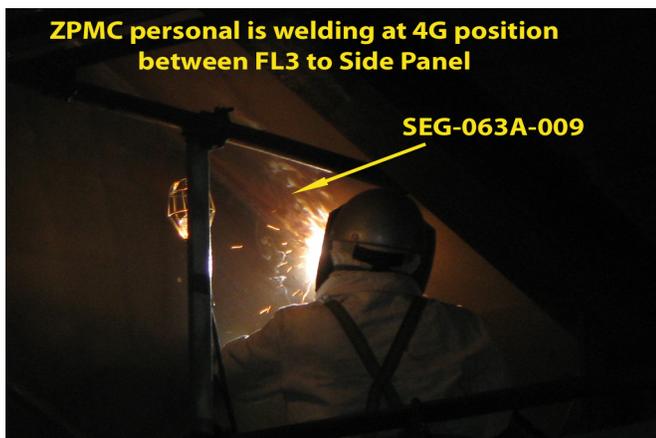
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Flux Core Arc Welding (FCAW) in the 3G position of the OBG segment 10AW between two splice at to of Floor Beam ,weld No. SEG-059-011. The welder is identified as #201215. ZPMC QC is identified as Mr. Xu Tao.The welding variables recorded by QC appear to comply with WPS- B – T-2233-Tc-U2-F.

SMAW in the 4G position of the OBG Segment at location FL3 to Side Panel, weld No. SEG-063A-009. The welder is identified as #066361. ZPMC QC is identified as Mr.Xu Tao.The welding variables recorded by QC appear to comply with WPS- B – P-2214-Tc-U4b-FCM-1.

Flux Core Arc Welding (FCAW) in the 3G position of the OBG Deck Panel ‘U’-rib to stiffener weld No. DP-130-002-81,86. The welder is identified as #214945. ZPMC QC is identified as Mr. Zhang Xianji.The welding variables recorded by QC appear to comply with WPS- B – T-2233-Tc-U4b-F.

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



### Summary of Conversations:

No relevant conversations

### 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 Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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

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