

**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-010353**Date Inspected:** 16-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-005 located on PCMK SEG300L of 12BW 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-2231-B-U2-F.

FCAW welding of weld joint 1G-241 located on PCMK SSD10A-PP92 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-2231-TC-U4b-F-2.

FCAW welding of weld joint 1G-250 located on PCMK SSD10-PP80 of 9DW welder is identified as 047866. ZPMC QC is identified as Mr.Wang xu. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-TC-U4b-F-2.

FCAW welding of weld joint 2F-207 located on PCMK SSD29-PP89.5 of 10BW 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-2232.

During Visual in process inspection it is found that fillet weld joint fit up of Corner section diaphragm connecting

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to Deck plate in segment 10AW root gap of the joint exceeding 5 mm.

This is found and informed to ZPMC QC Mr.Xu tao, he agreed and noted down those weld joints

For Engineer approval to convert into complete joint penetration joints. The welds no of the joints are as follows.

SSD10A-PP86-140/141, 144/145, 148/149. (Min R=8 mm, max R= 15 mm).

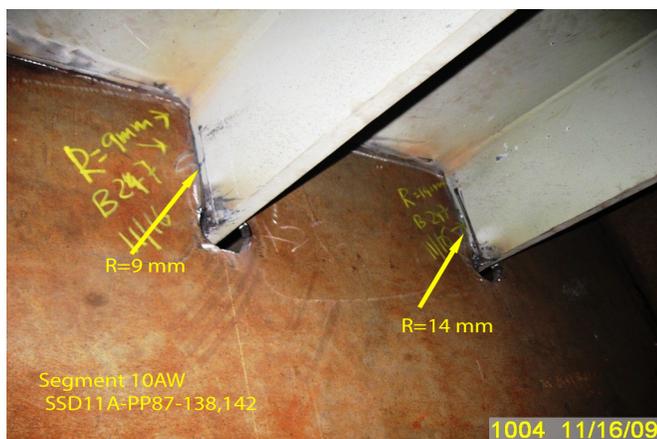
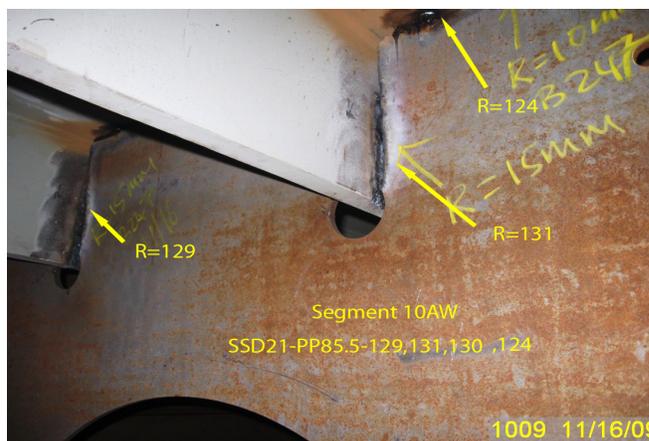
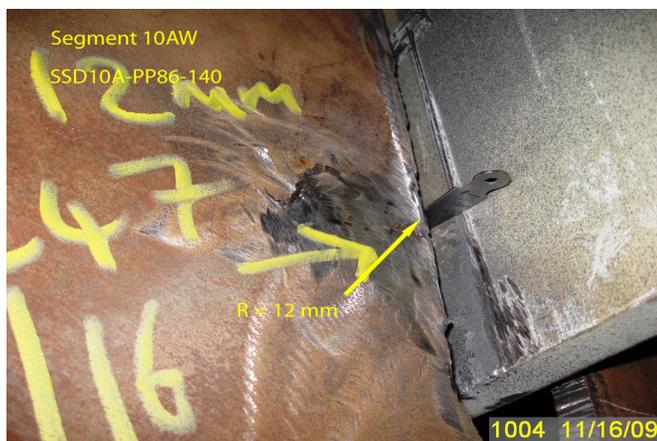
SSD11A-PP87-138/139, 142/143, 146/147.(Min R=7 mm, Max R=12 mm).

SSD21-PP85.5-129/130, 131/132, 123/124.(Min R=8mm, Max R=12 mm).

Visual inspection of weld joint fit up of Corner Assembly of Lift 11DW checked with ZPMC QC

Mr.Xu tao and dimension recorded.

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 Eric Tsang-150-0042-2372, 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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