

**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-010582**Date Inspected:** 28-Nov-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:** Zhu Zhong Hai**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, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

**Segment 10CW**

During random visual inspection of OBG segment 10CW, this QA inspector observed that the second "T rib" stiffener, weld# BP050-009, 010, of Bottom Plate BP-50 was distorted during handling. The distortion measured is 18 mm. For further information, please find attached pictures.

**Bay#14**

SAW welding of weld joint 1G-007 located on PCMK SEG073\* of 11EW welder is identified as 045265.ZPMC QC is identified as Mr. Wang xu . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2C-S-2.

FCAW welding of weld joint 2G-003 located on PCMK CA089 of 11DW welder is identified as 045240.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.

FCAW welding of weld joint 2G-003 located on PCMK CA091 of 11EW welder is identified as 045240.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.

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# WELDING INSPECTION REPORT

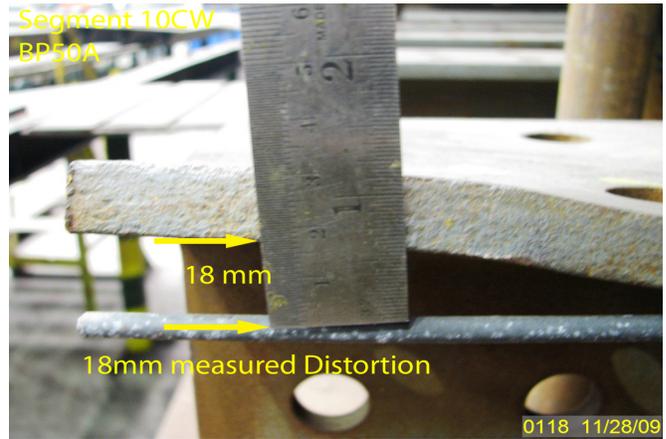
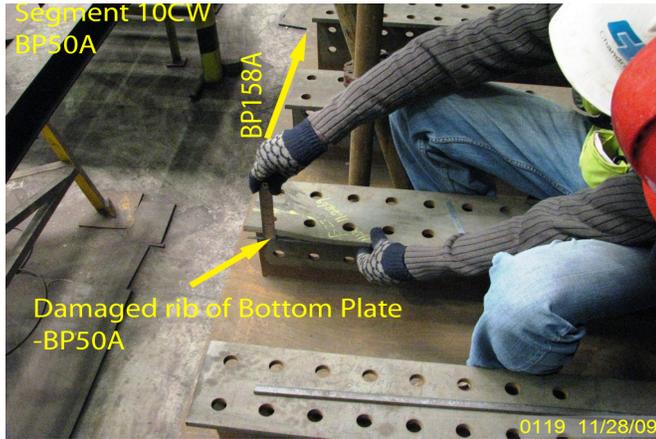
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FCAW welding of weld joint 2F-013 located on PCMK SEG061B of 10BW welder is identified as 047866.ZPMC QC is identified as Mr. Wang xu. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

Unless otherwise noted, all 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>	Patel,Hiranch	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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