

**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-010837**Date Inspected:** 18-Dec-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:** As identified below**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**Summary of Items Observed:**

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

North of Blast Bay 1-

This QA Inspector performed Magnetic Particle Testing (MT) verification of welds previously tested and accepted by ZPMC on OBG Segment 8AW. See MT report TL-6028 generated this date for additional information.

SSD9-PP61-003

SP763-001-078~081

SP763-002-017~020

Bay 14-

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of OBG Segment 11EE deck panel diaphragm to U rib Complete Joint penetration (CJP) weld, DP377-001-058. ZPMC welder was identified as 050988. ZPMC QC is identified as Zhong Guo Hui. ZPMC CWI was identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2233-TC-U4b-F.

Submerged Arc Welding (SAW) of OBG Segment 11DE deck panel DP349 to DP376A Complete Joint penetration (CJP) butt weld, SEG072\*-005. ZPMC welder was identified as 044771. ZPMC QC is identified as

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## WELDING INSPECTION REPORT

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Zhong Guo Hui. ZPMC CWI was identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, 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:**

Only general conversation occurred between QA and QC this date.

**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>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	Dawson,Paul	QA Reviewer

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