

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-010955**Date Inspected:** 27-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.

Bay 14-

This QA Inspector observed the following work in progress: Shielded Metal Arc Welding (SMAW) repair of OBG Segment 10 CW horizontal stiffener to edge plate Complete Joint Penetration (CJP) weld, SEG063E-164. ZPMC welder was identified as 058242. ZPMC QC was identified as Li Ming Yang. ZPMC CWI was identified as Liu Hua Jie. The welding appeared to be in conformance with welding procedure specification, WPS-345-SMAW-3G(3F)-Repair.

Flux Cored Arc Welding (FCAW) repair of OBG Segment 10 CW horizontal stiffener to deck panel stiffener CJP weld, SEG063E-160. ZPMC welder was identified as 051348. ZPMC QC was identified as Li Ming Yang. ZPMC CWI was identified as Liu Hua Jie. The welding appeared to be in conformance with welding procedure specification, WPS-345+485-FCAW-3G(3F)-Repair-1.

Shielded Metal Arc Welding (SMAW) repair of OBG Segment 11 DW deck panel DP268A to DP133A CJP weld, SEG071\*-005. ZPMC welder was identified as 058243. ZPMC QC was identified as Li Ming Yang. ZPMC CWI was identified as Liu Hua Jie. The welding appeared to be in conformance with welding procedure specification, WPS-345-SMAW-1G(1F)-Repair.

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

Flux Cored Arc Welding (FCAW) of OBG Segment 11 DE deck panel diaphragm to U rib CJP welds, DP403-001-049 and 053. ZPMC welder was identified as 050988. ZPMC QC was 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.

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.

---

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

---