

**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-011269**Date Inspected:** 06-Jan-2010**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:** Liu Fawen**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:** Orthotropic Box Girder (OBG) Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

**BAY 3**

This QA Inspector observed the following work in progress:

**Shielded Metal Arc Welding (SMAW):**

Weld joint # 069 located on Floor Beam FB204 – 043. Welder is identified as 057795. ZPMC Quality Control (QC) Inspector is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2212 – B – U2.

Weld joint # 166 located on Cross Beam CB202G – 041. Welder is identified as 069683. ZPMC Quality Control (QC) Inspector is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2114 – FCM.

**Flux Core Arc Welding (FCAW):**

Weld joint # 038 located on Corner Assembly CA3003C. Welder is identified as 051356. ZPMC Quality Control (QC) Inspector is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

Weld joint # 271 located on Corner Assembly CA3005E. Welder is identified as 051356. ZPMC Quality Control (QC) Inspector is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

### BAY 5

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 014 located on Traveler Rail 11TR3 – 008. Welder is identified as 067275. ZPMC Quality Control (QC) Inspector is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

Weld joint # 014 located on Traveler Rail 10TR3 – 003. Welder is identified as 204342. ZPMC Quality Control (QC) Inspector is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

Weld joint # 008 located on Traveler Rail 11TR3 – 001. Welder is identified as 215689. ZPMC Quality Control (QC) Inspector is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 005 located on Traveler Rail 10TR1 – 018. Welder is identified as 250353. ZPMC Quality Control (QC) Inspector is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

### BAY 7

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 001 located on Traveler Rail 22TR3 – 001. Welder is identified as 066695. ZPMC Quality Control (QC) Inspector is identified as Liu Chuan gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

Weld joint # 003 located on Traveler Rail 22TR3 – 001. Welder is identified as 066471. ZPMC Quality Control (QC) Inspector is identified as Liu Chuan gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

Weld joint # 005 located on Traveler Rail 22TR3 – 001. Welder is identified as 066734. ZPMC Quality Control (QC) Inspector is identified as Liu Chuan gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

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

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

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 - 15000422372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Kumar,Sandeep	Quality Assurance Inspector
----------------------	---------------	-----------------------------

---

<b>Reviewed By:</b>	Hall,Steven	QA Reviewer
---------------------	-------------	-------------