

**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-011606**Date Inspected:** 19-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:** Li Yan Hua**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 COMPONENT**Summary of Items Observed:**

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

In process Inspection

OUTSIDE YARD

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG Corner Assembly at segment 9BW, I-rib to stiffener, weld No. SEG-51D-082. The welder is identified as #066413. ZPMC QC is identified as Mr. Wang Wei Ming. The welding variables recorded by QC appear to comply with WPS-345+485-SMAW-3G(3F)-FCM-REPAIR-1.

SMAW in the 3G position for the OBG Corner Assembly at segment 9BW, I-rib to stiffener, weld No. SEG-51D-038. The welder is identified as #045213. ZPMC QC is identified as Mr. Wang Wei Ming. The welding variables recorded by QC appear to comply with WPS-345+485-SMAW-3G(3F)-FCM-REPAIR-1.

SMAW in the 4G position for the OBG segment 9AW, Longitudinal Diaphragm to Floor beam at PP72, weld No. SEG-49C-004. The welder is identified as #067183. ZPMC QC is identified as Mr. Wang Wei Ming. The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

BAY#14

This QA Inspector observed the following work in progress:

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## WELDING INSPECTION REPORT

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SAW in the 1G position for the OBG segment 11DE ,Deck plate DP-511-001 to DP-349-002 , weld No. SEG-072-001. The welder is identified as #215993. ZPMC QC is identified as Mr. Geng Wai. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

FCAW in the 3G position for the OBG segment 11EE ,Deck Panel Diaphragm to U-rib , weld No. DP-350-002-009,015. The welder is identified as #050988. ZPMC QC is identified as Mr. Geng Wei. The welding variables recorded by QC appear to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW in the 3F position for the OBG segment 11EE ,Deck Panel Diaphragm to U-rib , weld No. DP-350-002-016,017. The welder is identified as #050242. ZPMC QC is identified as Mr. Geng Wei. The welding variables recorded by QC appear to comply with WPS-B-T-2133.

Ultrasonic Testing (A,B,C and D-Scan )

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as portion after repair of Side plate to side plate Splice joint of 6AE to 6BE. This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result were recorded onto a data sheet that Caltrans QA and ABF QA have jointly filled out on this date.

The Weld Designation is as follows

OBE5A-003

OBE5A-002

Unless otherwise noted, all work 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>	Bera,Subhasis	Quality Assurance Inspector
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<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer
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