

**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-011876**Date Inspected:** 22-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:** 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

Bay #19

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG Suspender Bracket , weld No.SB009-042-061. The welder is identified as #062763. ZPMC QC is identified as Mr. Zhou Cheng. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW in the 2G position for the OBG Suspender Bracket , weld No.SB007-046-037. The welder is identified as #062732. ZPMC QC is identified as Mr. Zhou Cheng. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW in the 2G position for the OBG Suspender Bracket , weld No.SB007-046-004. The welder is identified as #062761. ZPMC QC is identified as Mr. Zhou Cheng. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW in the 2F position for the OBG Suspender Bracket , weld No.SB009-042-014/015. The welder is identified as #062763. ZPMC QC is identified as Mr. Zhou Cheng. The welding variables recorded by QC appear

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to comply with WPS-B-T-2132.

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 Deck plate to Edge plate corner joint of segment 9AE. This Inspection was performed after ABF UT Inspectors performed UT of this joint.

The Weld Designations are as follows

CA057-004

CA058-004

During the Quality Assurance (QA) random in-process visual inspection this QA inspector discovered that OBG Counter Weight CW80 back side brackets (second and last) were found bent. It was also observed that nine (9) Counter Weights CW40, CW50, CW80, CW60, CW98, CW78, CW72, CW68 and CW104 were improperly stored. These Counter Weights are stored on the ground and are stacked unevenly on each other without the proper storage supports.

This QA Inspector generated an incident report for this date.

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



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## 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
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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