

**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-012038**Date Inspected:** 10-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai**CWI Name:** ZPMC and ABF**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 Mr. Wai Pau, was present during the times noted above for observations relative to the work being performed.

**Bay #7**

Traveler rail: - Caltrans QA inspector observed four ZPMC welders performed FCAW process on the flange to web plate of traveler rail #22TR3-003, 22TR4-002, 22TR3-002 and 22TR1-002. This 22TR type component has been changed design to all CJP weld along on both side of top and bottom flanges. All the welding areas have been pre-heating prior FCAW welding. The FCAW process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

Traveler rail: - Caltrans QA Inspector observed three ZPMC grinders performed re-bevel grinding process on CJP joint of travelers. The surface of CJP bevels has been back gouged. The traveler rails ID are 22TR2-001, 22TR4-003, 22TR2-002 and 22TR4-003. The grinding process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

**Bay #5**

Traveler rail: - Caltrans QA inspector observed four ZPMC welders performed FCAW process on the flange to web plate of traveler rail #11TR1-003, 10TR1-010, 11TR1-006, 10TR3-003, 10TR3-006 and 11TR1-001. This type component designed has CJP and PJP weld along on one side of full weld length and other side has CJP only. All the welding areas have been pre heating prior FCAW welding. The FCAW process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

Traveler rail: - Caltrans QA inspector observed two ZPMC welders performed SMAW noncritical repair weld process on the flange to web of traveler rail # 10TR2-019 and 10TR2-020. The repair areas are located at top and

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

bottom flanges to web and total six spots and length for 50mm to 250mm. All of repair areas have been pre heating prior SMAW repair welding. The SMAW repair process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

## CLOSING STATEMENT

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

## Summary of Conversations:

As notes within report above.

## 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>	Pau,Wai	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

---