

**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-012195**Date Inspected:** 21-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:** 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.

West of Bay 19-

This QA Inspector observed the following work in progress: Shielded Metal Arc Welding (SMAW) of OBG Segment 9AW side panel SP105A to Corner Assembly CA55A weld, SEG049A-001. ZPMC welder was identified as 067752. ZPMC QC was identified as Wang Xian Pin. ZPMC CWI was identified as Li Yan Hua. The welding appeared to be in conformance with welding procedure specification, WPS-345-SMAW-4G(4F)-FCM-Repair and welding repair report B-WR10088.

Caltrans QA performed random visual inspection of sub assembly Floor beam welds located on OBG segment 7DW. During inspection Two (2) longitudinal linear indications were observed by Caltrans QA and confirmed by ZPMC Magnetic Particle Testing personnel. ZPMC stated that a critical weld repair report would be submitted to Caltrans Engineering for approval prior to repairing these areas. See attached photos below for additional information. The following list the weld number, Y location and length of indication:

FB019-003-092- Y location 4795, 20mm longitudinal linear indication.

FB011-012-003-Y location 21215, 15mm longitudinal linear indication.

Y location was pulled from weld SSD10A-PP56-004.

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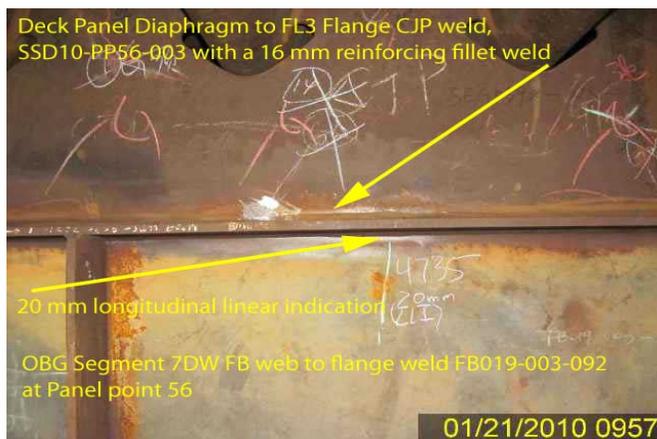
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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

As identified within the contents of this report.

## 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>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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