

**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-012204**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:** 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.

Bay 19-

During Random visual inspection of bike path components Caltrans QA Inspector observed that Bike Path Segment 4BK Complete Joint Penetration (CJP) weld BK004A8-006-115 had a Flux Cored Arc Welding (FCAW) cover pass weld bead up to 40 mm in width. ZPMC performed the welding in the 3G (vertical) position. The maximum width of weld bead utilizing the 3G position is 25 mm as per AWS D1.5 (2002) section- AWS D1.5/2002, Section 4.14.1.5 FCAW. Caltrans QA issued an Incident report this date for excessive weld layer width. Please see the attached photos below for further detail.

Bay 14-

This QA Inspector observed the following work in progress: Shielded Metal Arc Welding (SMAW) of OBG Segment 11 AW side panel SP113A to Corner Assembly CA079A weld, SEG065A-001. ZPMC welders were identified as 066764 and 054013. ZPMC QC was identified as Li Ming Yang. ZPMC CWI was identified as Zhu Zhong Hai. The welding appeared to be in conformance with welding procedure specification, WPS-B-P-2214-B-U2.

Shielded Metal Arc Welding (SMAW) of OBG Segment 11AW deck panel to edge panel weld, SEG065\*-045.

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# WELDING INSPECTION REPORT

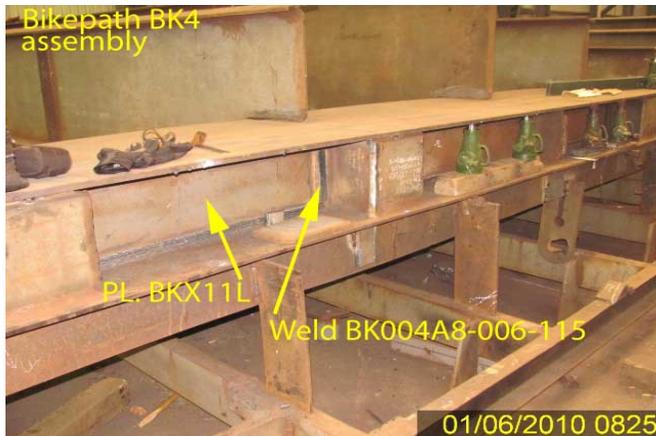
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ZPMC welders were identified as 044772 and 200113. ZPMC QC was identified as Li Ming Yang. ZPMC CWI was identified as Zhu Zhong Hai. The welding appeared to be in conformance with welding procedure specification, WPS-B-P-2214-B-U2-FCM-1.

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
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<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer
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