

**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-012317**Date Inspected:** 31-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:** Geng Wei**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 Components**Summary of Items Observed:**

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

**Segment 7EW**

This QA Inspector performed a preliminary random visual inspection after the grit blast of the external parts side plates, bottom plates, deck plates and corner assemblies of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

**Bay#14**

This QA inspector observed that ZPMC QC found the length of traveler rails 10TR3, 11TR1 and 11TR2 are 15~27 mm shorter than required as per approved drawings. This QA inspector found that ZPMC personal performed weld buttering by SMAW welding process on the end of traveler rail to make it in a proper length. This weld buttering was performed as per approved CWR report#B-CWR1086.

**Bay#14**

Weld buttering performed SMAW welding on traveler rail 10TR3-020. Welder is identified as 216086 (2G). ZPMC QC is identified as Guo Pan. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G(2F)-FCM-Repair.

Weld buttering performed SMAW welding on traveler rail 11TR2-013. Welder is identified as 048047 (2G).

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## WELDING INSPECTION REPORT

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ZPMC QC is identified as Guo Pan. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G(2F)—FCM-Repair.

Weld buttering performed SMAW welding on traveler rail 11TR2-007. Welder is identified as 049339 (2G). ZPMC QC is identified as Guo Pan. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G(2F)-FCM-Repair.

Weld buttering performed SMAW welding on traveler rail 11TR2-005. Welder is identified as 054013 (2G). ZPMC QC is identified as Guo Pan. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G(2F)-FCM-Repair.

Unless otherwise noted, all 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>	Patel,Hiranch	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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