

**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-012399**Date Inspected:** 30-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.

**Bay#14**

This QA inspector observed that ZPMC QC found distortion in traveler rail flange and plate. Measured distortion is 10~20 mm in 10 meter length. Heat straitening performed by ZPMC personal on traveler rails 11TR-2 and 11TR-1 as per heat straitening reports HSR-8139 and HSR-8140.

For further information please find attached pictures.

**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.

For further information please find attached pictures.

**Bay#14**

Weld buttering performed SMAW welding on traveler rail 10TR3. Welder is identified as 054013 (1G). ZPMC QC is identified as Guo Pan. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-1G(1F)-Repair.

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# WELDING INSPECTION REPORT

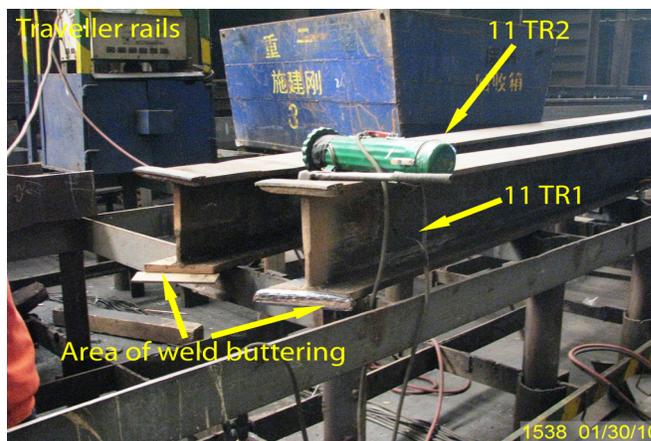
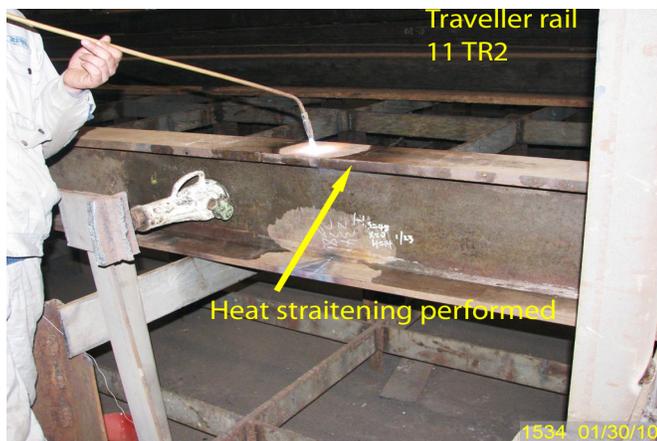
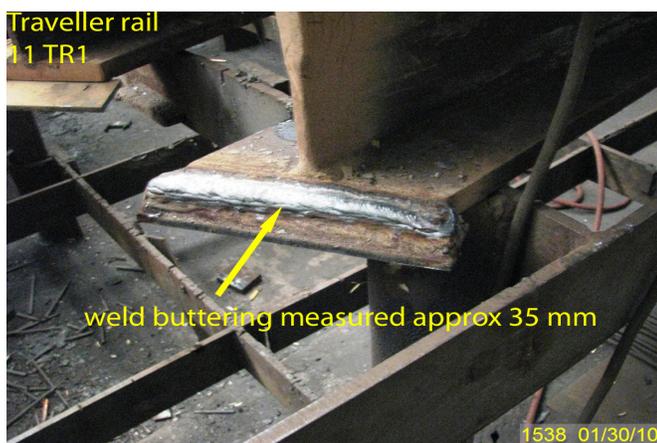
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Weld buttering performed SMAW welding on traveler rail 11TR1. Welder is identified as 054013 (1G). ZPMC QC is identified as Guo Pan. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-1G(1F)-Repair.

Weld buttering performed SMAW welding on traveler rail 11TR2. Welder is identified as 054013 (1G). ZPMC QC is identified as Guo Pan. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-1G(1F)-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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# WELDING INSPECTION REPORT

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<b>Inspected By:</b>	Patel, Hiranch	Quality Assurance Inspector
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<b>Reviewed By:</b>	McClendon, Timothy	QA Reviewer
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