

**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-013211**Date Inspected:** 03-Mar-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, China

**CWI Name:**                    Zho shong hai  
**Inspected CWI report:**      **Yes**    **No**    **N/A**  
**Electrode to specification:**  **Yes**    **No**    **N/A**  
**Qualified Welders:**          **Yes**    **No**    **N/A**  
**Approved Drawings:**         **Yes**    **No**    **N/A**

**CWI Present:**                  **Yes**    **No**  
**Rod Oven in Use:**             **Yes**    **No**    **N/A**  
**Weld Procedures Followed:**   **Yes**    **No**    **N/A**  
**Verified Joint Fit-up:**       **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, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

**OUTSIDE SHOP**

SMAW welding of repair of excess trimmed floor beam flange (X7) of weld joint 1G-017,018 and 1G-011,012 located on PCMK SEG053B and PCMK SEG053 of 9CW welder is identified as 067588,037748. ZPMC QC is identified as Mr.Wang wei ming . The welding variables recorded by QC appeared to Comply with the WPS-345-1G(1F)-FCM-Repair-1 and WR-10732.

For this repair work ZPMC need CWR, but they don't have any CWR. This is informed to ZPMC QC Mr. Wang wei ming and ABF QA Mr.Liaho. for more information please see the attached photos.

ABF QC UT personnel doing Ultrasonic testing of welds which is identified as SEG053A-004 of Segment 9CW appeared to comply with contract documents.

ZPMC production personnel started their fabrication repair work in OBG segment 9DE.

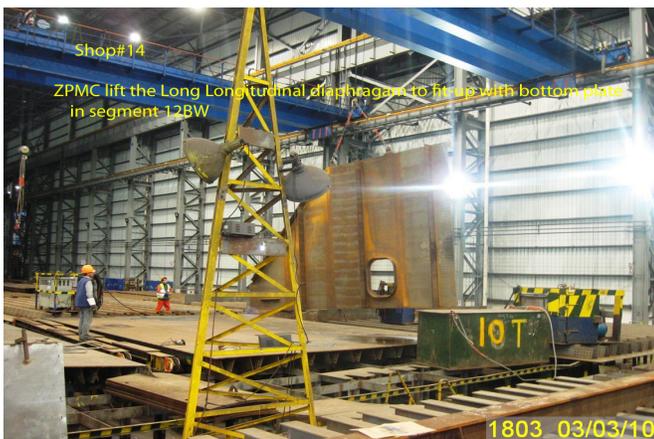
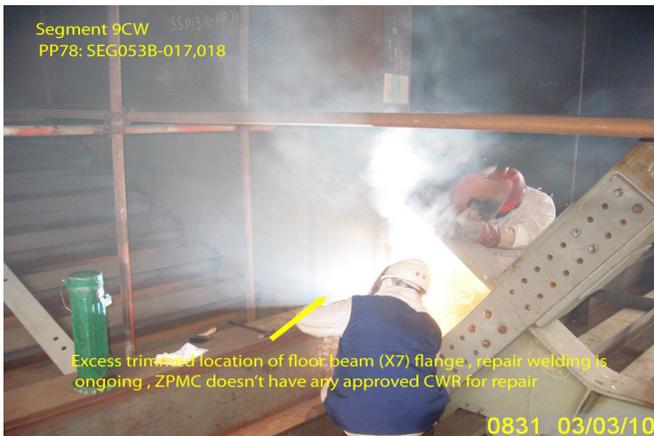
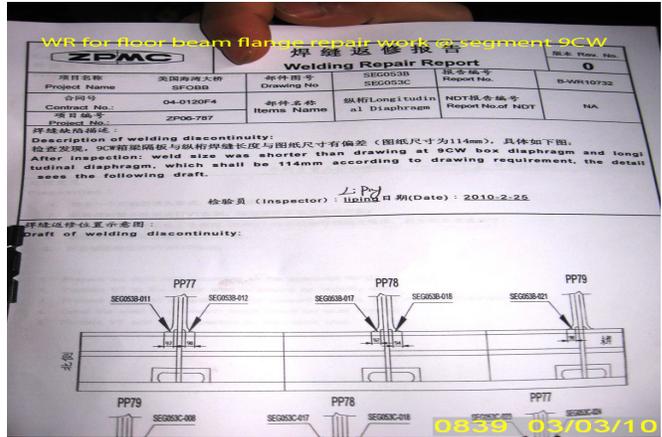
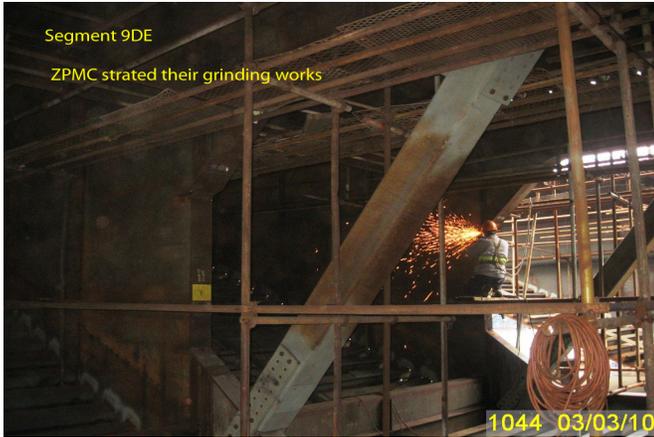
**BAY#14**

FCAW welding of weld joint 2F-185 located on PCMK CA3009C of 12BW welder is identified as 045175.ZPMC QC is identified as Mr.Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

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



**Summary of Conversations:**

No relevant Conversation.

**Comments**

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## WELDING INSPECTION REPORT

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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-15--0042-2372, who represents the Office of Structural Materials for your project.

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

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