

**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-013227**Date Inspected:** 19-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:** Zhou Cheng/Zhu Zhong Hai**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#19**

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-( SB010-042-026)

**Bay#19**

During random in process inspection of Bike Path, BK4A-004, this QA inspector observed ZPMC personal fit up the bearing plate to stringer plates. For further information, please see the attached pictures below.

**Bay#19**

During random in process inspection of Bike Path, BK4A-004, this QA inspector observed following issue. ZPMC performed cutting of vertical anchor house plate. The vertical anchor house plate identified as BKSA1B. According to fit up procedure vertical member shall not be terminated for fit up of bearing plate. ZPMC personal remove total vertical anchor house plate and will install the new vertical anchor house plate. For further information, please see the attached pictures below.

**Bay#14**

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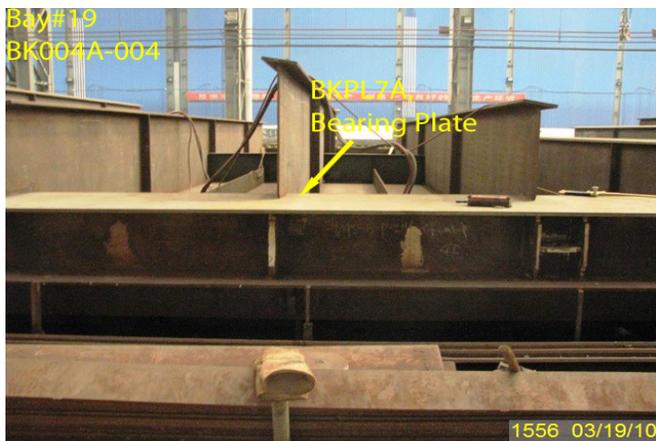
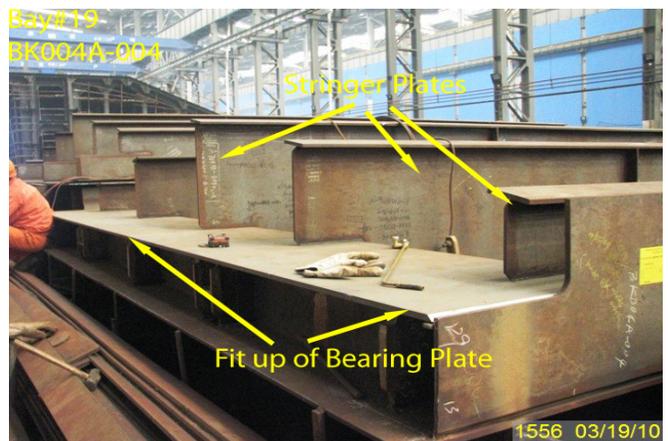
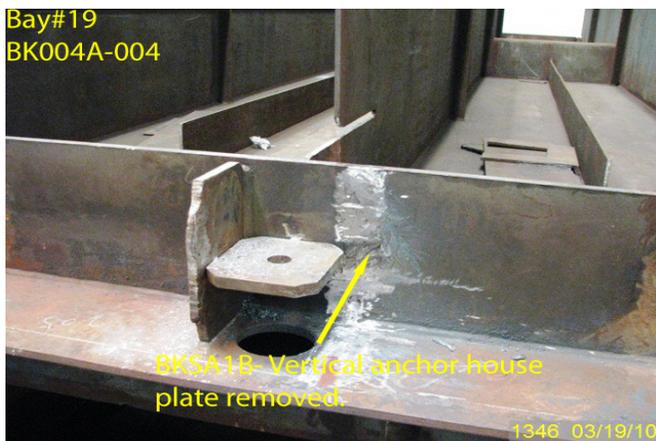
SMAW welding of weld joint SSD19A-PP108-127 located on Lift 11EE. Welder is identified as 066261 (4G). ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SSD19-PP109-131 located on Lift 11EE. Welder is identified as 067904 (4G). ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

FCAW welding of weld joint Seg3003A-001 located on Lift 12CE. Welder is identified as 044774 (1G). ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-B-U2-F.

FCAW welding of weld joint Seg3003A-001 located on Lift 12CE. Welder is identified as 058551 (1G). ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-B-U2-F.

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



## Summary of Conversations:

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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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