

**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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013397**Date Inspected:** 24-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Liu Hua Jie**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 Segment**Summary of Items Observed:**

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

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 044801 perform Flux Cored Arc Welding (FCAW) welding on OBG Segment 12CE Corner Assembly, weld joint identified as CA3004D-001~012 and 211~212. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4133.

This QA inspector observed ZPMC qualified welding personnel identified as 055491 perform FCAW welding on OBG Segment 12CE Corner Assembly, weld joint identified as CA3004E-001~012 and 211~212. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4133.

This QA inspector observed ZPMC qualified welding personnel identified as 055491 perform FCAW welding on OBG Segment 12CE Corner Assembly, weld joint identified as CA3004D-015~022 and 215~222. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 044801 perform FCAW welding on

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OBG Segment 12CE Corner Assembly, weld joint identified as CA3004E-015~022 and 215~222. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 044801 and 055491 perform FCAW welding on OBG Segment 12CE Corner Assembly, weld joint identified as CA3004-004. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 045246 and 067665 perform FCAW Welding on OBG Segment 12CW, weld joint identified as SEG3006D-015, 016, 012, 013, and 090~119. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133.

This QA inspector observed ZPMC qualified welding personnel identified as 045246 and 067665 perform FCAW Welding on OBG Segment 12CW, weld joint identified as SEG3006D-017, 018 and 014. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 070212 and 204730 perform FCAW Welding on OBG Segment 12CW, weld joint identified as SEG3006B-015, 016, 012, 013, and 086~115. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133.

This QA inspector observed ZPMC qualified welding personnel identified as 045246 perform SMAW Welding on OBG Segment 12CW, weld joint identified as SEG3006B-008 and 009. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 070212 and 045218 perform FCAW Welding on OBG Segment 12CW, weld joint identified as SEG3006C-016, 017, 014, 013, and 089~119. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133.

This QA inspector observed ZPMC qualified welding personnel identified as 204730 perform SMAW Welding on OBG Segment 12CW, weld joint identified as SEG3006C-011 and 012. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 204730 and 066002 perform FCAW Welding on OBG Segment 12CW, weld joint identified as SEG3006J-016, 017, 014, 013, and 097~132. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133.

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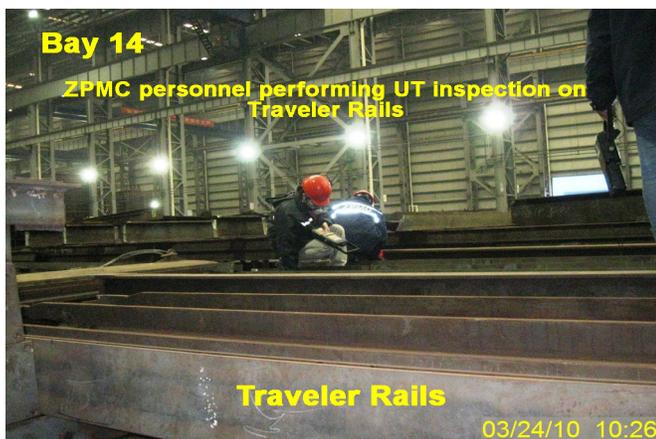
This QA inspector observed ZPMC qualified welding personnel identified as 2233 perform SMAW Welding on OBG Segment 12CW, weld joint identified as SEG3006J-011 and 012. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-FCM-1. See the attached pictures.

## Visual Inspection after Blast

### Segment 9AW

This QA Inspector performed a preliminary random visual inspection after the grit blast of the exterior components of the deck panel, floor beams 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.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



## Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

## 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

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remedial efforts please contact , who represents the Office of Structural Materials for your project.

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