

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-013416**Date Inspected:** 25-Apr-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:** Tian Lei/Zhou Cheng**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**

FCAW welding of weld joint SB014-052-049, 007 located on SB052, lift 7&8. Welder is identified as 062749 (2G). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint SB014-050-037, 043, 018, 011 located on SB050, lift 7&8. Welder is identified as 062757 (2G). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint SB014-050-014, 015 located on SB050, lift 7&8. Welder is identified as 062757 (2F). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint SB014-054-018, 019 located on SB054, lift 7&8. Welder is identified as 062812 (2G). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint SB014-054-014, 013 located on SB054, lift 7&8. Welder is identified as 062812

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

(2F). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint SB012-054-043, 049, 055, 061 located on SB054, lift 7&8. Welder is identified as 062738 (2G). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint SB012-052-043, 049, 031, 037 located on SB054, lift 7&8. Welder is identified as 062807 (2G). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint SB012-050-043, 049, 055, 037 located on SB054, lift 7&8. Welder is identified as 062761 (2G). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

Bay#2

SAW welding of weld joint FB3114-001-005 located on FB3114, Lift 13E. Welder is identified as 050502 (1G). ZPMC QC is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-L2c-S-2.

SAW welding of weld joint FB3120-001-001 located on FB3120, Lift 13E. Welder is identified as 044780 (1G). ZPMC QC is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-L2c-S-2.

FCAW welding of weld joint FB3115-001-001, 002 located on FB3115-Lift 13E. Welder is identified as 050977 (1G). ZPMC QC is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-B-U2-F-1.

FCAW welding of weld joint FB3120-001-003 located on FB3120-Lift 13E. Welder is identified as 050977 (1G). ZPMC QC is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-B-U2-F-1.

FCAW welding of weld joint FB3119-001-001 located on FB3119-Lift 13E. Welder is identified as 206386 (1G). ZPMC QC is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-B-U2-F-1.

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

---

---

## WELDING INSPECTION REPORT

*( Continued Page 3 of 3 )*

---

---

your project.

---

<b>Inspected By:</b>	Patel,Hiranch	Quality Assurance Inspector
----------------------	---------------	-----------------------------

---

<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer
---------------------	-------------------	-------------