

**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-013452**Date Inspected:** 12-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:** Li yan hua**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, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

FCAW welding of weld joint 1G-002 located on PCMK SEG3006\* of 12CW welder is identified as 204730. ZPMC QC is identified as Mr.Li ming yang . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-U2-F.

SAW welding of weld joint 1G-009 located on PCMK SEG3003\* of 12CE welder is identified as 044771.ZPMC QC is identified as Mr. Guo xing hui . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2c-S-1.

SAW welding of weld joint 1G-002 located on PCMK SEG3003\* of 12CE welder is identified as 044771.ZPMC QC is identified as Mr. Guo xing hui . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2c-S-1.

SMAW repair welding of weld joint 4G-001 on PCMK SEG3006A of 12CW welder is identified as 066258. ZPMC QC is identified as Mr.Li ming yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G(4F)-FCM-repair-1 and B-WR1106.

NWIT 005317 was given by ZPMC this morning for UT, MT, VT of Corner assembly X37 plates.

# WELDING INSPECTION REPORT

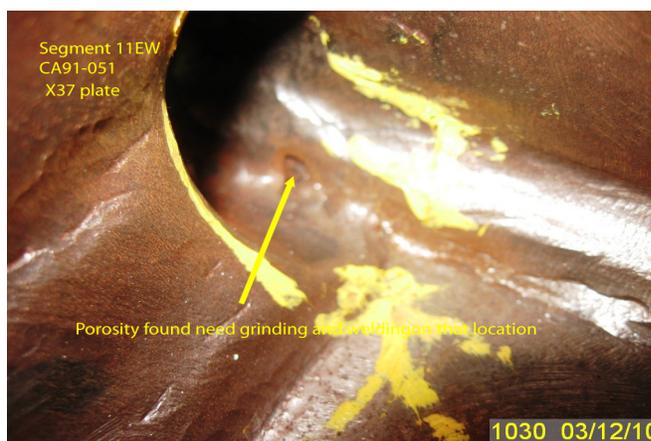
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When we started our inspection we found lot of place Base metal notches up to 4mm depth, Porosity and undercut. There was no evidence of ZPMC UT, MT, and VT signature on the job. We called ZPMC QC Mr.Li ming yang , he told ZPMC cancelled this notification and once confirm with ZPMC UT,MT QC personnel for NDT and finish their VT markings then re offer for CT inspection.

## OUTSIDE SHOP

SMAW repair welding of weld joint 2G-003 on PCMK CA061 of 9CW welder is identified as 045133.ZPMC QC is identified as Mr.Li Ping. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G(2F)-FCM-repair and B-WR1054.

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



## Summary of Conversations:

No relevant Conversation.

## 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-15--0042-2372, who represents the Office of Structural Materials for

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# WELDING INSPECTION REPORT

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your project.

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