

**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-013510**Date Inspected:** 30-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:** Chen Xi**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#2**

During random visual inspection of floor beam in Bay#2, this QA inspector observed cluster porosity on the surface of the weld. The weld is identified as FB3206B-010, Lift-13W. Welding was done by FCAW welding process, 2F position. ZPMC QC was present during the observation. The location of porosity was clearly marked on the job near weld.

For further information, please find attached pictures.

**Bay#2**

FCAW welding of weld joint FB3206B-009/007 located on FB3206-Lift 13W. Welder is identified as 045203 (2F). ZPMC QC is identified as Zhu Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132-3.

FCAW welding of weld joint FB3174-001-002, 004 located on FB3174-Lift 13W. Welder is identified as 062418 (2F). ZPMC QC is identified as Zhu Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132-3.

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

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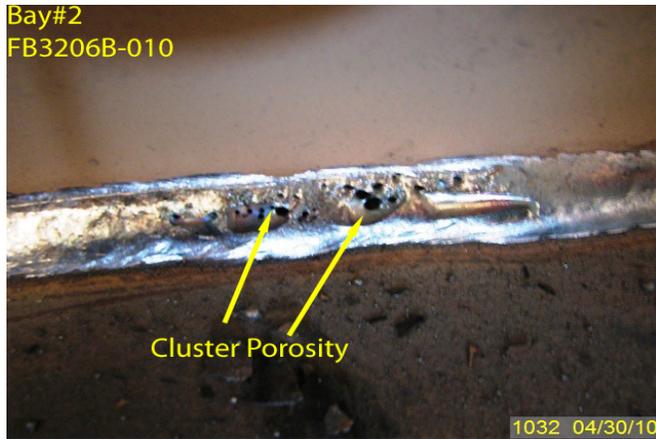
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# WELDING INSPECTION REPORT

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## 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 your project.

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**Inspected By:** Patel, Hiranch

Quality Assurance Inspector

**Reviewed By:** McClendon, Timothy

QA Reviewer