

**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-013772**Date Inspected:** 07-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:** Gong Wei**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 COMPONENT**Summary of Items Observed:**

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

In process Inspection

Bay #14

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG Segment 12CE at corner assembly, weld No.CA3005C-013. The welder is identified as #052696. ZPMC QC is identified as Mr. Guo Xing Hai. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

FCAW in the 2F position for the OBG Segment 12CE at corner assembly, weld No.CA3005D-022. The welder is identified as #044774. ZPMC QC is identified as Mr. Guo Xing Hai. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

FCAW in the 2F position for the OBG Segment 12AE at corner assembly, weld No.CA3001A-187/188. The welder is identified as #0455491. ZPMC QC is identified as Mr. Guo Xing Hai. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

SAW in the 1G position for the OBG Segment 12AW, weld No.SEG-3004\*-005. The welder is identified as #045265. ZPMC QC is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appear to comply

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with WPS-B-T-2221-B-L2C-S-2.

SMAW in the 4G position for the OBG Segment 12AW, weld No.CA3004D-016. The welder is identified as #037723. ZPMC QC is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appear to comply with WPS-B-T-2214-Tc-U4b-FCM-1.

During Quality Assurance random in-process observations of the assembly of Orthotropic Box Girder (OBG) segment 12AE, this Quality Assurance Inspector (QA) discovered the weld access holes have been omitted from the ends of Floor Beam FB3014 at Panel Point PP112.5. Approved shop drawing FB3014 specifies 30mm radii weld access holes at each end of the floor beam web where it butts into longitudinal diaphragms LD3007 and LD3008.

This QA Inspector generated an incident report for this date.

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



## Summary of Conversations:

No relevant conversations

## Comments

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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>	Bera,Subhasis	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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