

**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-013815**Date Inspected:** 02-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. 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 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 19

This QA inspector observed ZPMC qualified welding personnel identified as 062816 perform Submerged Arc Welding (SAW) Welding on Bike Path, weld joint identified as BK004A1-016-009. ZPMC QC is identified as Mr. Zhou Cheng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 062816 perform Submerged Arc Welding (SAW) Welding on Bike Path, weld joint identified as BK004A1-017-009. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

## Outside Yard 9BE

This QA inspector observed ZPMC qualified welding personnel identified as 054013 perform Shielded Metal Arc Welding (SMAW) Welding on OBG Segment 9BE, weld joint identified as SEG052A-001. ZPMC QC is identified as Mr. Li Yan Hua. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair, which is used as per Welding Repair

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Report (WRR) B-WR11530.

This QA inspector observed ZPMC qualified welding personnel identified as 054013 perform SMAW Welding on OBG Segment 9BE, weld joint identified as SEG052\*-018. ZPMC QC is identified as Mr. Li Yan Hua. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3G (3F)-Repair, which is used as per Welding Repair Report (WRR) B-WR11531.

Visual Inspection after Blast

Segment 9BW

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.

Visual Inspection Details: During random Quality Assurance Visual review of welds located on segment 12CE, this Quality Assurance Inspector (QA) discovered Fillet joints are having more than 5mm gap. The exceed gap area are clearly marked on the material near the weld and also inform to ZPMC QC. The panel points are identified as a PP115, 116 and 117. This weld is a Fillet weld joining the Floor beam Web to Longitudinal Diaphragm. For further information, please see the attached pictures

Bay 13

This QA inspector observed ZPMC qualified welding personnel identified as 050977 perform Flux Cored Arc Welding (FCAW) Welding on Traveler Rail, weld joint identified as 20TR2-016-015. ZPMC QC is identified as Mr. Guo Yuan Ting. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-1G (1F)-Repair-1, which is used as per Welding Repair Report (WRR) B-WR11170.

This QA inspector observed ZPMC qualified welding personnel identified as 206623 perform FCAW Welding on Traveler Rail, weld joint identified as 20TR2-016-013. ZPMC QC is identified as Mr. Guo Yuan Ting. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-1G (1F)-Repair-1, which is used as per Welding Repair Report (WRR) B-WR11169.

This QA inspector observed ZPMC qualified welding personnel identified as 044830 perform FCAW Welding on Traveler Rail, weld joint identified as 20TR2-001-011. ZPMC QC is identified as Mr. Guo Yuan Ting. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-1G (1F)-Repair-1, which is used as per Welding Repair Report (WRR) B-WR11019.

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 058100 perform Submerged Arc Welding (SAW) Welding on OBG Segment 12AE, weld joint identified as SEG3001\*-018. ZPMC QC is

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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-2221-B-L2c-S-2.

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 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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