

**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-014002**Date Inspected:** 11-May-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:** Jhou Cheng/Liu Fa Wen**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 BP026-015-049~53 located on BP026-015. Welder is identified as 062786 (2G). ZPMC QC is identified as Jhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132-Tc-U4b-F.

FCAW welding of weld joint SB012-056-067 located on SB012-056. Welder is identified as 062788 (2G). ZPMC QC is identified as Jhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132-Tc-U4b-F.

FCAW welding of weld joint BK004A-004A6-023, 024 located on BK004A-004. Welder is identified as 208641 (4F). ZPMC QC is identified as Jhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2134.

**Bay#8**

During random in-process inspection of bike path, this QA inspector observed that fit-up of stringer plates to top plate (Bike path-deck plate) was performed by ZPMC personnel. The tack weld was performed by SMAW welding process. This QA inspector observed that ZPMC personnel using mechanical jack for the fit-up to stringer

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plates. ZPMC QC was present during observation.  
For further information, please see attached pictures.



### 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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<b>Inspected By:</b>	Patel,Hiranch	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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