

**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-014610**Date Inspected:** 23-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

<b>CWI Name:</b>	Xu tao / Zhou zhongai / Xu tao	<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
		<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006	<b>Component:</b>	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#13

SAW welding of weld joint 1G-002 located on PCMK BP3032-001 of Segment 13AE 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-2221-2. (One side completed) CWI is identified as Mr.Zhou zhong hai.

BAY#16

SAW welding of bottom plate to bottom plate of Lift 13 weld joint 1G-002 located on PCMK BP3072-001 of Segment 13AW welder is identified as 045265. ZPMC QC is identified as Mr. Tao wei . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-U2C-S-2.

Ongoing heat straightening of Bottom plate is identified as BP3074 of Lift 13 segment 13AW before welding, heating temperature and dimension checked with ZPMC QC Mr.Tao wei and recorded by QC is appeared to comply with #787-B-QCR-20R.

BAY#19

# WELDING INSPECTION REPORT

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This QA inspector went for MT inspection of OBG Bike path which is previously tested and accepted by ZPMC Quality Control personnel (NWIT-005805), when this QA inspector start his VT lot of location weld spatter, undercut, closed cope hole etc found. Following weld no are BK004A3-004-017,018,041,042 not comply with drawing as per drawing 12mm fillet size need, but in actual the fillet size was 5mm. this is informed to ZPMC CWI Mr.Zhou cheng, he agreed and cancelled the notification.

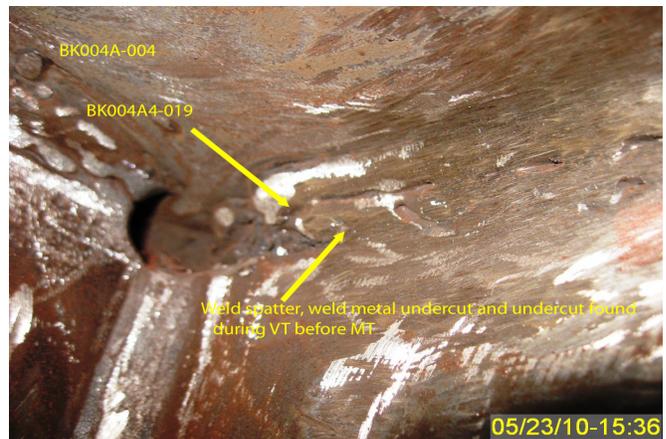
Visual inspection of weld joint fit-up connects intermediate stiffener to bearing plate BK004A-004 and BK004A-002 checked with ZPMC QC Mr.Zhou cheng is appeared to comply with the WPS-B-T-2134-FCM-1.

BAY#14

FCAW welding of weld joint 1G-240 located on PCMK SEG3001J of Segment 12AE welder is identified as 055564. ZPMC QC is identified as Mr. Zhong guo hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-Tc-U4b-F.

SMAW welding of weld joint 4G-003 located on PCMK SEG3004AA of Segment 12AW welder is identified as 047864. ZPMC QC is identified as Mr. Zhong yong gang . The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

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



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## 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 your project.

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**Inspected By:** Kumar, Chadra

Quality Assurance Inspector

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**Reviewed By:** McClendon, Timothy

QA Reviewer