

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-015142**Date Inspected:** 27-Jun-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:** Xu Tao**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

Out Side

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG Segment 11DE, weld No. SEG072E-036. The welder is identified as #201087. ZPMC QC is identified as Mr. Tan Ya Jun. The welding variables recorded by QC appear to comply with WPS-B-P-2213-Tc-U4b-FCM.

SMAW in the 3G position for the OBG Segment 11DE, weld No. SEG072D-154. The welder is identified as #201087. ZPMC QC is identified as Mr. Tan Ya Jun. The welding variables recorded by QC appear to comply with WPS-B-P-2213-Tc-U4b-FCM.

Bay #14

This QA Inspector observed the following work in progress:

During the Quality Assurance visual inspection the QA Inspector observed that the ZPMC personnel performing heat straightening on side plate SP3060 for segment 13AE. The heat straightening report find as HR8663.

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

During the Quality Assurance visual inspection the QA Inspector observed that the ZPMC personnel damaged the base metal of stiffener RS3183T during cutting with Flame gas cutter for side panel SP3063A. The QA Inspector marked all base metal damaged area and informed to ZPMC QC Mr. Gong Wai to provide base metal repair report for all mention location .

## Ultrasonic Testing (UT) for Suspender Bracket

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as suspender brackets.

The weld designation reviewed is as follows:

SB008-048-031,043,055,067,011,001,004,005,007,008,020  
SB007-048-031,043,055,067,011,001,004,005,007,008,020  
SB012-054-025,037,049,061,018,001,004,005,007,008,019  
SB015-060-019

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



## 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.

---

**Inspected By:** Bera, Subhasis

Quality Assurance Inspector

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

**Reviewed By:** Patterson,Rodney

QA Reviewer