

**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-015520**Date Inspected:** 21-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:** ZPMC and ABF**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 13 section**Summary of Items Observed:**

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

**Bay#13**

Caltrans QA inspector observed a welder performed carbon arc back gouging process on CJP stiffener welds of 13A grillage mock up. Approximately four spots with 20mm~ 45mm depth x 100mm ~200mm length of sound wall thick along two weld length have been gouged out. The purpose of carbon arc back gouging is removed the indications that have been rejected by ZPMC UT test. The back gouging areas will be re-beveled to request design joint and the surface free of the scale, traces of oxide films and other contaminants prior welding. Base on Caltrans observation, no discrepancies were noted.

**Bay #14**

Caltrans QA Inspector observed two welders performed FCAW fillet weld process on stiffeners that connected to T-joint steel plate PL3243A of side plate #SP3063A with 22mm wall thick. The minimum preheat and maximum interpass temperature requirements for FCAW fillet weld are 110C degree and 230 C degree. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

**Bay #16**

Caltrans QA Inspector observed a welding operator in process of semi-automatic SAW on CJP butt joint weld. The CJP weld is attached to 100mm wall thick base plate of 13AE section of west line. The weld number and plate

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## WELDING INSPECTION REPORT

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number are BP3074-001-005/PL3361C and PL3361C (side B). The semi-automatic saw process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

### Bay#19

Caltrans QA Inspector observed two welders performed FCAW PJP weld process on stiffeners that connected to suspender bracket. The suspender bracket and weld ID are SB48W/SB008-048-026~032. The minimum preheat and maximum interpass temperature requirements for FCAW fillet weld are 110C degree and 230 C degree. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Caltrans QA Inspector observed two welders performed FCAW seal weld process on plates that connected to suspender bracket. The suspender brackets ID are SB70W and SB80W. The minimum preheat and maximum interpass temperature requirements for FCAW fillet weld are 110C degree and 230 C degree. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

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

### Summary of Conversations:

As notes within report above

### 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 James Devey 15000026784 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Pau,Wai	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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