

**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-015802**Date Inspected:** 13-Jul-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.

Caltrans QA inspector observed ABF survey group performed survey on the bolt hole lines of 100mm welded bottom plate. The bottom plates ID are PL3366C, PL3365C, PL3364C, PL3363C, PL3362C and PL3361C. All the survey check has been completed today and waits for Caltrans survey group verify. The holes drilling process will be start and finish after the survey accepted by Caltrans. Base on Caltrans QAI observation, no discrepancies were noted.

Caltrans QAI observed a ZPMC heat straightening operator performed heat straightening with ZPMC Heat Straightening Report (HSR) #8792 on side plates. The side plate ID is SP3102A with 25mm wall thick. The heating temperature is maximum 650 C (1200 F) and cool in still air. All the plates for heat straightening have been inspected and recorded by ZPMC QC. Based on Caltrans QAI observation, no discrepancies were noted.

Caltrans QA inspector observed three ZPMC welders performed FCAW fillet weld process on OBG side plate (SP). The weld is designed T-joint stiffeners to plate with size 8mm fillet weld. The side plate and weld ID are SP3103 / SP3103-001-011~034. The region of the weld joint has been pre-heating to specific desired temperature prior FCAW welding. The FCAW process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

Caltrans QA Inspector observed two ZPMC welding operator performed SAW CJP process on a longitudinal

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diaphragm. The longitudinal diaphragm ID and weld number are LD-3032/LD3032-001-003 and LD3031/LD3031-001-002. The FCAW process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector 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 (BP) of 13AW section of west line. This section is a SPM member. The weld number and plate number are BP3074-001-001/PL3363C and PL3362C (side B). The minimum preheat for SPM member CJP weld is 160C degree. The semi-automatic SAW process 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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