

**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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015902**Date Inspected:** 25-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) Chanxing Island**Location:** Shanghai, China

**CWI Name:** Mr. Geng Wei  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** Yes No N/A  
**Approved WPS:** Yes No N/A  
**Delayed / Cancelled:** Yes No N/A

**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

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

Magnetic Particle Testing (MT) - Document No's: 006277

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Segment Side Plate. The weld designations reviewed are as follows:

1. SP3076-001-007, 008, 009, 010, 014, 017, 018, 030
2. SP3102-001-037, 038, 045, 046

OBG Segment 11DW

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SP745-001-300 and 303 located on the Web Buckled Plate of OBG Segment 11DW. The welder is identified as 045263. ZPMC Quality Control (QC) is identified as Mr. Tang Ya Jun. The welding variables recorded by QC appeared to comply with WPS-B-P-2112-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SP507-001-302 located on the Web Buckled Plate of OBG Segment 11DW. The welder is identified as 045263.

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## WELDING INSPECTION REPORT

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ZPMC Quality Control (QC) is identified as Mr. Tang Ya Jun. The welding variables recorded by QC appeared to comply with WPS-B-P-2112-FCM-1.

### OBG Segment 13AW

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SP3010-001-003 & 004 located on the Side Plate of OBG Segment 13AW. The welder is identified as 044795. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

### OBG Segment 13BE

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SP3073-001-011 & 012 located on the Side Plate of OBG Segment 13BE. The welder is identified as 044790. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

### Visual Inspection after Blast

#### Segment 10BE

This QA Inspector performed a preliminary random visual inspection after the grit blast of the interior components of the deck panel, floor beams and corner assemblies of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

#### **Summary of Conversations:**

Only general conversation was held between QA and QC concerning this project.

#### **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 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Vibin	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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