

**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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016485**Date Inspected:** 24-Aug-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**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 Segments**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: 006471

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 Lift 13 SP. The weld designations reviewed are as follows:

1. SP3117C-001-040, 041
2. SP3140B-001-027, 043
3. SP3118C-001-034, 035
4. SP3126-001-018, 034
5. SP3117-001-007, 008
6. SP3116-001-090, 100
7. SP3140-001-001, 002
8. SP3129-001-036, 037
9. SB3116C-001-038, 022

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This QA inspector performed Visual Inspection for Green Tagging which were previously tested and accepted by ZPMC Quality Control personnel and ABF QA personnel. The members are identified as lift 13 LD.

13AW	LD3031	14607
13BW	LD3032	14608
13CW	LD3033	14609
13AW	LD3034	14610
13BW	LD3035	14611
13CW	LD3036	14612

### OBG Segment 12AE

This QA inspector observed ZPMC qualified welding personnel identified as 215553 perform SMAW welding on OBG Segment 12AE, weld joint identified SEG3001J-057 and 059. ZPMC QC is identified as Mr. Wu Shi Gao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2113-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 201087 perform SMAW welding on OBG Segment 12AE, weld joint identified SEG3001L-061 and 063. ZPMC QC is identified as Mr. Wu Shi Gao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2113-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 050232 perform SMAW welding on OBG Segment 12AE, weld joint identified SEG3001M-060 and 062. ZPMC QC is identified as Mr. Wu Shi Gao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2113-FCM-1.

### Visual Inspection after Blast

#### Segment 11AE

This QA Inspector performed a preliminary random visual inspection after the grit blast of the exterior 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
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<b>Reviewed By:</b>	McClendon, Timothy	QA Reviewer
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