

**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-016911**Date Inspected:** 02-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), Changxing Island **Location:** Shanghai, China**CWI Name:** Gong Wai**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

Bay #14

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 13CE, weld No. SEG3011A-006. The welder is identified as #044780. ZPMC QC is identified as Mr. Zhang Ling. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

FCAW in the 1G position for the OBG Segment 13CW, weld No. SEG3015A-003. The welder is identified as #201215. ZPMC QC is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2231-B-U2-F.

SAW in the 1G position for the OBG Segment 13BE, weld No. SEG3009A-005. The welder is identified as #044771. ZPMC QC is identified as Mr. Zhang Ling. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

SMAW in the 4G position for the OBG Segment 12CW, UT repair weld No. SEG3006N-242. The welder is

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identified as #066179. ZPMC QC is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-REPAIR.

SMAW in the 4G position for the OBG Segment 12BW, UT repair weld No. SEG3005\*-006. The welder is identified as #205718. ZPMC QC is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-REPAIR.

During random visual inspection at bay 14 the QA Inspector observed ZPMC personnel damaged the bearing pad holes (75mm diameter) during use automatic Flame gas cutting device on bottom plate BP3032A for segment 13AW. The hole number is identified as 922. The bottom plate thickness is 100mm.

### Bay #16

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG Segment 13CW Longitudinal Diaphragm to stiffener, weld No. LD3036-001-094/095. The welder is identified as #040344. ZPMC QC is identified as Mr. Xin Chun Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

FCAW in the 2F position for the OBG Segment 13CW Longitudinal Diaphragm to stiffener, weld No. LD3036-001-313/314. The welder is identified as #201583. ZPMC QC is identified as Mr. Xin Chun Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

### Bay #19

This QA Inspector observed the following work in progress:

FCAW in the 1G position for the OBG suspender Bracket SB84E, weld No. SB020-084-001. The welder is identified as #062783. ZPMC QC is identified as Mr. Li Ming Yang . The welding variables recorded by QC appear to comply with WPS-B-T-22231-Tc-U4B-F.

### Ultrasonic Testing (UT)

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 Longitudinal Diaphragm splice joint for segment 13AW .

The welds designation reviewed are as follows:

LD3034-001-001~007

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

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## 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.

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<b>Inspected By:</b>	Bera,Subhasis	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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