

**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-020056**Date Inspected:** 19-Mar-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

<b>CWI Name:</b>	Liu Hua Jie, Lu Li Qing, Geng Wei			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Component:</b>	Orthotropic Box Girder (OBG)		

**Summary of Items Observed:**

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

This QA Inspector observed the following work in progress:

Assembly, Bay 14, 12BW, SEG3005K, Longitudnal Diaphragm to Bottom Plate.

FCAW welding of weld joint SEG3005K-018; located on assembly, Bay 14, 12BW. Welder is identified as 045240; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2232-TC-U4B-FCM-1.

Assembly, Bay 14, 12CW, Deck plate (DP3062A) to Deck plate (DP3063A).

SAW welding of weld joint SEG3006\*-008; located on assembly, Bay 14, 12CW. Welder is identified as 045265; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2221-B-L2C-S-2.

Assembly, Bay 14, 12CE, Bottom plate to Side plate.

SMAW welding of weld joint SEG3003A-001; located on assembly, Bay 14, 12CE. Welder is identified as 044774, 058551; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-B-U2-F.

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Assembly, Outside Yard, 9DW.

During the Quality Assurance (QA) random in-process visual inspection, this QA inspector ZPMC Personnel performing fit up of X37-Stiffener between PP81 & PP82. The attached photographs provide additional detail.

Assembly, Bay 14, 11EE, SEG074.

SMAW welding of weld joint SSD19-PP109-131 & SSD19-PP108-127; located on assembly, Bay 14, 11EE. Welder is identified as 067904, 066201; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2214-TC-U4B-FCM-1.

Assembly, Bay 14, 12AE, Bottom plate to Side plate.

SMAW Repair welding of weld joint SEG3001A-005 (WRR # TEMPORARY); located on assembly, Bay 14, 12AE. Welder is identified as 049339; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-SMAW-4F(4G)-REPAIR-1.

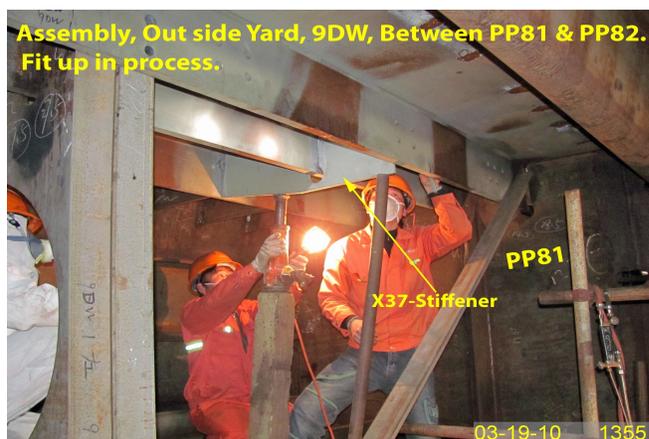
Assembly, Bay 14, 12AE, Bottom plate to Side plate.

SMAW Repair welding of weld joint SEG3001A-007 (WRR # TEMPORARY); located on assembly, Bay 14, 12AE. Welder is identified as 200113; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-SMAW-4F(4G)-REPAIR-1.

Training for Phased Array Ultrasonic Testing.

This QA inspector attended Training for Phased Array Ultrasonic Testing (PAUT) from 1600Hrs. to 1900Hrs.

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



## Summary of Conversations:

No relevant conversations.

## Comments

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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, 1500.042.2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Juvekar,Amit	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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