

**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-005428**Date Inspected:** 09-Feb-2009**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>	Zhang Bo Lei	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG segments	

**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG outside assembly (OBG segment 4BW)

This QA observed ZPMC qualified welding personnel identified as Mr. Zang Yanbo Li (045196) perform SMAW welding on weld joint identified as SEG019A-025. ZPMC QC identified as Mr. Li Ming Yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM.

This QA observed ZPMC qualified welding personnel identified as Mr. Wang Chang Ming (047864) perform SMAW welding on weld joint identified as SEG019A-025. ZPMC QC identified as Mr. Li Ming Yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM.

This QA observed ZPMC qualified welding personnel identified as Mr. Zang Yanbo Li (045196) perform SMAW repair welding on weld joint identified as SEG019A-038. ZPMC QC identified as Mr. Li Ming Yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-repair.

This QA observed ZPMC qualified welding personnel identified as Mr. Li Zhai Jun (037996) perform SMAW repair welding on weld joint identified as SEG019A-037. ZPMC QC identified as Mr. Li Ming Yang was present

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to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-485-SMAW-3G (3F)-FCM-repair.

This QA observed ZPMC qualified welding personnel identified as Mr. Yang Chang Ming (058242) perform SMAW base metal repair welding on floor beam web plate identified as FB021-01 @ PP027 near weld 001. ZPMC QC identified as Mr. Li Ming Yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-485-SMAW-3G (3F)-FCM-repair.

This QA noted that weld identified by ZPMC QC as SEG019\*-037 has been excavated for repair for approximately 70% to 75% of its length. This weld is identified as a Fracture Critical Weld (FCW) on the shop drawings. ZPMC QC lead CWI identified as Mr. Zhang Bo Lei assured this QA that the repair welding would not commence until an approved Critical Weld Repair (CWR) procedure has been issued to ZPMC QC department.

OBG outside assembly (OBG segment 5AW, 5BW and 5CW)

No significant work was being performed on these segments while QA was present.

OBG assembly bay 19

This QA observed ZPMC qualified welding personnel identified as Mr. Zhang Jingfu (062747) perform SMAW tack welding on weld joint identified as CB205B-001-014. ZPMC QC identified as Mr. Zhou Cheng was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2211-B-U2.

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

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## Summary of Conversations:

As mentioned 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 Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hall,Steven	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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