

**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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006006**Date Inspected:** 05-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Fa Wen & Chen Xi**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:** Tower and OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz 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:

This QA Inspector performed Ultrasonic Testing (UT) on approximately 15% of CJP on the Bike Path welds previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QA Inspector observed no rejectable indications at the time of testing. The QA Inspector generated a TL-6027 UT report on this date. Welds UT verified were identified as listed below

Bay 19

BK004A1-008-009

BK004A1-009-009

BK004A1-010-009

BK004A1-011-009

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 25% of the area previously tested by ZPMC MT personnel. This QA Inspector generated a TL-6028 MT report on this date. The weld designation numbers is as follows:

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

### Bay 6

BP134-001-007~018

BP202-001-001~006

This QA Inspector observed the following work in progress:

### Bay 10

ZPMC's qualified welding personnel's are identified as Mr. Dong Yuqin (053116), Mr. Wang Gongzhi (0050041) and Mrs. Dong Yumei (054069) perform FCAW welding on weld joints identified as SSD1-FASA3-A164A/J-3 and 4. ZPMC QC identified Mr. Wan Wen Zhong 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-T-2331-Tc-P4-F-2 and WPS-B-T-2232-Tc-P4-F-2.

### Bay 19

ZPMC's qualified welding personnel's Mr. Wang Yong (062807) and Mr. Chen Zhoushan (062750) perform FCAW welding on weld joint identified as BK004A1-010-041 and BK004A1-010-076. ZPMC QC identified Mr. Liu Fa Wen 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-T-2B2-3.

### Bay 14

ZPMC's qualified welding personnel are identified as Mr. Chang Zhanchi (200432) performing groove welding of weld joint SEG032\*-001. The personnel were observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process. ZPMC QC identified Mr. Shen Fu You 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-T-2221-B-L2C-S-2.

### Bay 7

ZPMC's qualified welding personnel's are identified as Mr. Sun Daocan (250833), Mr. Wang Hongbo (203206) and Liu Yonggui (2050489) perform SMAW welding on weld joints identified as SP595-001-040, SP785-001-014, 013 and SP785-001-018, 017. ZPMC QC identified Mr. Wan Wen Zhong 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-2112-FCM.

### Bay 5

ZPMC's qualified welding personnel's Mr. Fan Xiao Liang (250534) and Mr. Han Hongwen (215082) perform FCAW welding on weld joint identified as BK2-001-063 and BK2-001-043. ZPMC QC identified Mr. Chen Xi was present to monitor the welding process. The welding parameters as measured using QC's calibrated

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

instruments appeared to be in general compliance with WPS-B-T-2132-3.

## Bay 3

ZPMC's qualified welding personnel's Mrs. Yang Ttianbing (066439) and Mr. Chen Chuanzong (044824) perform FCAW welding on weld joint identified as FB020-007-127 and SSD14-PP19-132. ZPMC QC identified Mr. Chen Xi 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-T-2232-Tc-U4b-F and WPS-B-T-2233-Tc-U4b-F.

## Bay 2

ZPMC's qualified welding personnel's Mrs. Cheng Haixian (045209) and Mr. Wang Shi (295091) perform FCAW welding on weld joint identified as FB011-032-005 and FB011-032-028. ZPMC QC identified Mr. Shi Lei 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-T-2133.

Unless otherwise noted, all work observed on this date appeared to generally comply with 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 Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

---

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

---