

**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-006161**Date Inspected:** 13-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Likun & Liu Yang**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:

Bay 10

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:

1. SD1-A20B/B-43, 44
2. SD1-A20A/B-2, 13
3. ND1-A26B/B-25~28, 71~74
4. SSD1-FDSA3-1B/C-50, 24~26A/B

This QA Inspector observed the following work in progress:

FCAW welding of weld joint 17B located on PCMK SSD1-FESA3-1B/D.

Welder is identified as Mr. Yu Yonglai (048378). ZPMC QC is identified as Mr. Chen Likun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

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FCAW welding of weld joint 17A located on PCMK SSD1-FESA3-1B/D.

Welder is identified as Mr. Wang Qingbo (068501). ZPMC QC is identified as Mr. Chen Likun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

FCAW welding of weld joint 31 located on PCMK SSD1-FESA3-1B/D.

Welder is identified as Mr. Pan Meng (066673). ZPMC QC is identified as Mr. Chen Likun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

FCAW welding of weld joint 30 located on PCMK SSD1-FESA3-1B/D.

Welder is identified as Mr. Jin Xiaogang (053474). ZPMC QC is identified as Mr. Chen Likun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

SAW welding of weld joint 3A located on PCMK NSD1-FBAS3-A/C.

Welder is identified as Mr. Xu Kaozhen (051413). ZPMC QC is identified as Mr. Liu Yang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

SMAW welding of weld joint 3A located on PCMK NSD1-TL8B/L.

Welder is identified as Mr. Huang Zhao (056200). ZPMC QC is identified as Mr. Chen Yingxin.

The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b.

SMAW welding of weld joint 2A located on PCMK NSD1-TL8B/L.

Welder is identified as Mr. Ye Xulan (040581). ZPMC QC is identified as Mr. Chen Yingxin.

The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b.

SMAW welding of weld joint 3A located on PCMK NSD1-TL8B/L.

Welder is identified as Mr. Zhang Jinlong (057220). ZPMC QC is identified as Mr. Chen Yingxin.

The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b.

This Quality Assurance Inspector Joe Alaniz observed material (NDS Stiffener A) has been over heated during straightening on night shift. Discrepancy was not caught until day shift on this day. This QA Inspector issued an incident report on the above noted discrepancy.

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

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# WELDING INSPECTION REPORT

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**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.

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