

**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-006780**Date Inspected:** 22-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Hong Fei and 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:

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as South Tower Lift 4 Skin B. The weld designations reviewed are as follows:

Bay 10

1. SSD1-FBSA4-1A/C-15, 30, 34, 46A (B)

Bay 10

SAW welding of weld joint 22 located on NSD1-FCSA4-1A/C.

Welder is identified as Mrs. Hua Guimei (050295). ZPMC QC is identified as Mr. Liu Yang.

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

SMAW welding of weld joints 56A and 72 located on SSD1-FCAS4-1A/C.

Welder is identified as Mr. Yuan Leilei (040324). ZPMC QC is identified as Mr. Liu Yang.

The welding variables recorded by QC appeared to comply with WPS-B-P-2312-Tc-P5.

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### Bay 11

SMAW welding of weld joints 4B located on WSD1-FCAS4-2A/B.

Welder is identified as Mr. Xie Zhongcheng (041220). ZPMC QC is identified as Mr. Li Hong Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-4211-B-U3b-2.

SMAW welding of weld joints 4B located on WSD1-FCAS4-2A/B.

Welder is identified as Mr. Yang Zaihua (040669). ZPMC QC is identified as Mr. Li Hong Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-4211-B-U3b-2.

FCAW welding of weld joint 54 located on ESTL3-4G/K.

Welder is identified as Mr. Liao Yanfei (066398). ZPMC QC is identified as Mr. Xu Le Feng.

The welding variables recorded by QC appeared to comply with WPS-B-T-4332-Tc-P5-F.

FCAW welding of weld joint 55 located on ESTL3-4G/K.

Welder is identified as Mr. Dong Changxi (070046). ZPMC QC is identified as Mr. Xu Le Feng.

The welding variables recorded by QC appeared to comply with WPS-B-T-4332-Tc-P5-F.

### Bay 7

SMAW welding of weld joints 001~004 located on SP202-015.

Welder is identified as Mr. Jia Anquan (201725). ZPMC QC is identified as Mr. Wu Zhi Feng.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112-FCM.

SMAW welding of weld joints 005~008 located on SP202-016.

Welder is identified as Mr. Lv Xiujun (215259). ZPMC QC is identified as Mr. Wu Zhi Feng.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112.

### Bay 6

SMAW welding of weld joints 145 and 146 located on CB202G-009.

Welder is identified as Mr. Lei Hanjie (215672). ZPMC QC is identified as Mr. Wu Zhi Feng.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112.

### OBG Assembly Yard “Segment 4GE”

FCAW welding of weld joint 25~36 located on SP32A.

Welder is identified as Mr. Lu Yangyuan (202841). ZPMC QC is identified as Mr. Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-F.

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
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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