

**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-009945**Date Inspected:** 02-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1000**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin and Wu Zhi Cheng**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:** 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:

Trail Assembly Yard

This QA inspector performed MT of approximately 15% of the repaired area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as East and West Drip plates. The weld designations reviewed are as follows:

1. OBW1B-076
2. OBE1B-059, 080

1AE+1BE

SMAW repair welding on weld joint 007 located on OBE1A.

Welder is identified as Mr. Yun Chuansheng (045221). ZPMC QC is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and repair procedure CWR #874.

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## WELDING INSPECTION REPORT

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SMAW repair welding on weld joint 007 located on OBE1A.

Welder is identified as Mr. Yun Chengxian (045138). ZPMC QC is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and repair procedure CWR #874.

SMAW repair welding on weld joint 004 located on OBE1 edge plate at crossbeam side of segment.

Welder is identified as Mr. Tian Zhaoquan (045246). ZPMC QC is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and repair procedure CWR #874.

### NDT Observation

QA Inspector observed ABF's personnel performing Ultra Sonic (UT) inspection on repair areas. Locations and description of work are as followed:

1. Edge plate to deck plate weld joint located on the bike path side of segment 1AE.

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.

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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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