

**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-010230**Date Inspected:** 16-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li 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:** 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:

OBG Assembly Yard

Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions in the trial assembly yard. Locations and description of work are as followed:

1AE

1. Repair work (dressing weld profile with hand held grinder) at weld joint SEG004A-004 located between 600~1780mm on the side plate to bottom plate weld seam. (Bike path side of segment)

2. Repair work (dressing weld profile with hand held grinder) at weld joint SEG004A-007. Y locations are as followed: 450, 460 and 1140mm on cross beam side of segment.

3. Repair work (dressing weld profile with hand held grinder) at weld joint OBE1A-008. Y locations approximately at 2000 and 4500mm off bike path side of segment.

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6AW

SMAW tack welding in progress of diaphragm member located at panel point 38 of segment. Welder is identified as Mr. Zhao Quanlin (046813). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-FCM-1 and WPS-B-P-2212-FCM-1.

SMAW tack welding in progress of diaphragm member located at panel point 39 of segment. Welder is identified as Mr. Xiao Lin (049485). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-FCM-1 and WPS-B-P-2212-FCM-1.

## NDT Observation

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

1AW+1BW

1. Side plate weld joint repair located at y location 6270 (accepted) and 6325mm (accepted) on the cross beam side of segment.
2. Edge to deck plate weld joint repair located at y location 2100 (rejected), 23280 (accepted), 21730 (accepted), 21370 (accepted) 21350 (accepted) and 21300mm (rejected) on the cross beam side of segment.

This QA Inspector observed ZPMC Magnetic Particle (MT) Technician performing MT on various locations in the trial assembly yard. Locations are as followed:

1AAW+1AW

1. Lateral bracing on I ribs on deck plate stiffeners located on bike path side of segment.

## Note:

Due to inclement weather, work was limited in the OBG Trail Assembly Yard on today's work shift.

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

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## WELDING INSPECTION REPORT

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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>	Miller,Mark	QA Reviewer
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