

**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-010485**Date Inspected:** 06-Dec-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

5CW

SMAW repair welding on weld joint 007 located at OBW5G on counter weight side of segment.

Welder is identified as Mr. Du Hengyou (037749). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and WR repair procedure #8590.

Y Locations of excavations by above noted welder (037749) are at 920mm, 6800mm, 7080mm, 7570mm and 8110mm.

6AW

SMAW repair welding on weld joint 004 located at OBW6 on deck plate of segment.

Welder is identified as Mr. Li Shoufu (066674). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-223(2)1T-2.

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6BE+6CE

SMAW tack welding on weld joints 034, 035 and 036 located at SP427-001 edge to deck cross beam side of segment. Welder is identified as Mr. Li Guimin (220069). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2-F.

SMAW tack welding on weld joint 005 located at OBE6A on cross beam side of segment. Welder is identified as Mr. Li Guimin (220069). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233T.

5BE+5CE

SMAW repair welding on weld joint 009 located at OBE5A side plate on cross beam side of segment. Welder is identified as Mr. Qie Jianzhou (067571). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and WR repair procedure #8617.

Y Locations of excavations by above noted welder (067571) are at 2035mm and 1195mm.

SMAW repair welding on weld joint 009 located at OBE5A side plate on cross beam side of segment. Welder is identified as Mr. Feng Huajun (066258). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and WR repair procedure #8617.

Y Locations of excavations by above noted welder (067571) are at 30mm and 665mm.

5CE

SMAW repair welding on weld joint 001 located at CA023 on bike path side of segment. Welder is identified as Mr. Han Xiao Feng (054467). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and WR repair procedure #8823.

Y Locations of excavations by above noted welder (054467) are at 100mm and 400mm.

5BE

SMAW repair welding on weld joint 005 located at CA020 on bike path side of segment. Welder is identified as Mr. Han Xiao Feng (054467). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and WR repair procedure #8826.

Y Locations of excavation by above noted welder (054467) are at 200mm.

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## NDT Observation

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

5BE+5AE

1. Segment splice hold back welds on side plate (cross beam side) t stiffeners.

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
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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