

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-010860**Date Inspected:** 22-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/ 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:

OBG Assembly Yard

6AW

FCAW welding on weld joints 073, 005, 014 and 023 located at SEG028J. Welder is identified as Mr. Chen Zhenghua (220067). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

SMAW welding on weld joint 044 located at SEG027\* on cross beam side of segment. Welder is identified as Mr. Lv Peng (048617). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2214-Tc-U4b-FCM-1.

5CE

SMAW welding on weld joint 002 located at CA024 on bike path side of segment. Welder is identified as Mr. Zhang Feng (069769). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

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### 6AW+6BW

SMAW welding on weld joint 003 located at OBE6B on bottom plate side of segment. Welder is identified as Mr. Li Wenguo (066261). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

SMAW welding on weld joint 003 located at OBE6B on bottom plate side of segment. Welder is identified as Mr. Zhao Aifei (067942). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-B-U2-FCM-1.

### 5BE

SMAW welding on weld joints 001 and 031 located at SEG024 longitudinal diaphragm on bike path 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-1G (1F)-Repair-1.

### 6BE

SMAW repair welding on X37 member weld joint 034, 035, 030 and 031 located between panel point 38&39 on the bike path side of segment. Welder is identified as Mr. Wu Haijun (201087). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-345+485-SMAW-3G (3F)-Repair and WR8987.

### NDT Observation

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

### 5AW

1. Side plate to bottom plate weld at panel point 29 located on the counter weight and crossbeam side of segment.

### 6AW+6BW

During a random in-process visual inspection at Segments 6AW+6BW of Edge Elate (EP) temporary attachment removal areas, this Caltrans Quality Assurance (QA) Inspector observed base metal repairs on EP's without prior approval of the Engineer. This QA Inspector issued an incident for noted noncompliance.

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

### Summary of Conversations:

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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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