

**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-013929**Date Inspected:** 11-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**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

8CE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA054 bike path side of segment. Welder is identified as Mr. Sun Lingling (048047). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair-1 and CWR1409 R1 procedure.

Y Location of repairs areas by above noted welder (048047) is located at 6840mm.

8BE+8AE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 003 located at OBE8B bottom plate splice of segment. Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G (1F)-Repair-1 and CWR1450 R1 procedure.

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 4 )

---

---

Y Location of repairs areas by above noted welder (048659) is located at 5760mm.

8AW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA047 counter weight side of segment. Welder is identified as Mr. Feng Huajun (066258). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair-1 and CWR1222 R2 procedure.

Y Location of repairs areas by above noted welder (066258) is located at 3240mm.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA047 counter weight side of segment. Welder is identified as Mr. Chen Renzhi (058087). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair-1 and CWR1222 R2 procedure.

Y Location of repairs areas by above noted welder (058087) is located at 12235, 12520, 12660 and 12690mm.

7DW+7EW

Shield Metal Arc Welding (SMAW) repair welding (base metal) was performed on weld joint 009 and 010 located at OBW7C cross beam side of segment. Welder is identified as Mr. Ji Yi (045268). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-4G (4F)-FCM –Repair-1 and CWR1414 procedure.

8BW+8CW

Flux Core Arc Welding (FCAW) welding was performed on weld joint 005 located at OBW8C cross beam side of segment. Welder is identified as Mr. Liu Xiaolin (067079). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233T-1.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 004 located at OBW8C cross beam side of segment. Welder is identified as Mr. Fei Chengxiang (066239). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233T-1.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 002 located at OBW8C counter weight side of segment. Welder is identified as Mr. Jiang Junlin (067876). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233T-1.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 002 located at OBW8C counter weight side of segment. Welder is identified as Mr. Jin Rong (066471). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233T-1.

---

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 4 )

---

---

Flux Core Arc Welding (FCAW) welding was performed on weld joint 002 located at OBW8A deck plate splice of segment. Welder is identified as Mr. Bi Laishu (045280). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-223(2)1T-2.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 002 located at OBW8A deck plate splice of segment. Welder is identified as Mr. Wen Yanyan (066734). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-223(2)1T-2.

### Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions at Tail Assembly Yard. Locations and description of work are as followed:

#### 7DE

1. Heat straightening was performed on the deck plate to cross beam plate located between panel points 56 & 58 per HSR-364.

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 (150-0042-2372), who represents the Office of Structural Materials for your project.

---

**Inspected By:** Alaniz, Joe

Quality Assurance Inspector

---

---

---

# WELDING INSPECTION REPORT

( Continued Page 4 of 4 )

---

---

**Reviewed By:** Carreon,Albert

QA Reviewer