

**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-014233**Date Inspected:** 19-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:** Guo Yenfei**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:** Bay 9**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Christopher D'souza was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

Bay 9

Welding of Continuity plates on DP3073 – 001

This QA Inspector observed the following ZPMC welding personnel's performing Flux cored arc welding (FCAW) on Diaphragms to U-Rib weld

Welder Weld ID

Han Guodan (062259) DP3073-001- 132, 133

Jiang Tingguang (062265) DP3073-001- 252, 253

Xuan Zhenglin (040875) DP3073-001- 220, 221

Xu Guoyin (059443) DP3073-001- 189, 190

Zhang Liping (201840) DP3073-001- 091, 092

Zhong Qichao (040881) DP3073-001- 054, 055

ZPMC QC is identified as Zhu Zhong Jie. The welding variables recorded by QC appeared to comply with the

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# WELDING INSPECTION REPORT

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WPS – B – T – 2133 and WPS – B – T – 2233 – Tc – U4b – F (CJP)

## Tack Welding

This QA Inspector observed ZPMC welding personals identified as 059440 and 059366 performing Gas Metal Arc welding (GMAW) tack welding on DP3124 (PL3320A) deck plate to U-rib. ZPMC QC is identified as Zhu Zhong Jie. The welding variables recorded by QC appeared to comply with the WPS-345-B-T-2342 U5b (U-Rib).

## NDT Observations

Observed ABF Inspectors performing Magnetic Particle Testing (MT) of tack welds of Deck plate to U-rib on DP3117-001 and DP3125-001, cracked tacks were marked for repair by ABF Inspectors.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



## Summary of Conversations:

No relevant conversations.

## 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 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Dsouza, Christopher	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon, Albert	QA Reviewer

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