

**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-014370**Date Inspected:** 23-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**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

9AE+9BE

Flux Core Arc Welding (FCAW) welding was performed on weld joint 002 located at OBE9 deck plate weld splice cross beam side of segment. Welder is identified as Mr. Zhang Hanming (220066). ZPMC QC is identified as Liu Huajie. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-223(2)1T-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 021 located at SP622-001 cross beam side of segment. Welder is identified as Mr. Dou Dexiang (048800). ZPMC QC is identified as Liu Huajie. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-3213-B-U3b.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 001 located at OBE9 cross beam side of segment. Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Liu Huajie. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-3213-B-U3b.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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Flux Core Arc Welding (FCAW) welding was performed on weld joint 005 located at OBE9B bike path side of segment. Welder is identified as Mr. Zhuang Hua (068206). ZPMC QC is identified as Liu Huajie. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233T.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 005 located at OBE9B bike path side of segment. Welder is identified as Mr. Qi Huanhuan (067184). ZPMC QC is identified as Liu Huajie. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233T.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 006 located at OBE9B bike path side of segment. Welder is identified as Mr. Han Lin (062782). ZPMC QC is identified as Liu Huajie. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233T.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 005 located at OBE9B bike path side of segment. Welder is identified as Mr. Wang Hong lei (066687). ZPMC QC is identified as Liu Huajie. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233T.

9AE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 014 located at SEG050A bike path side of segment. Welder is identified as Mr. Dong Haitao (067183). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

### NDT Observation

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

7DW+7EW

1. Side plate weld splice OBE8C-005 UT reject excavation areas at Y Location 1860 and 2000mm on the bike path side of segment, per CWR 1525.

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

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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## 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.

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

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