

**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-015912**Date Inspected:** 25-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**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 lift 13 subassemblies**Summary of Items Observed:**

On this day CALTRANS Office of Structural Materials (OSM) Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

**OBG BAY 1**

This QA observed ZPMC qualified welding personnel identified as 059450 perform Flux Cored Arc Weld (FCAW) buttering on one end of traveler rail 20TR1-031. ZPMC Quality Control personnel (QC) identified as Mr. Xiang Feng was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-1G (1F)-Repair-1 and Critical Weld Repair (CWR) B-CWR1568.

**OBG BAY 2**

This QA observed ZPMC qualified welding personnel identified as 067275 perform Flux Cored Arc Weld (FCAW) on lift 13W floor beam weld joint identified as FB3216-001-059. ZPMC QC identified as Mr. Zhu Jun was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-TC-U4b-F.

This QA observed ZPMC qualified welding personnel identified as 067947 perform Flux Cored Arc Weld

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

(FCAW) on lift 13W floor beam weld joint identified as FB3189-001-058. ZPMC QC identified as Mr. Zhu Jun was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

OBG BAY 3

This QA observed ZPMC qualified welding personnel identified as 214945 perform Flux Cored Arc Weld (FCAW) on lift 13E floor beam weld joint identified as FB3155-001-019. ZPMC QC identified as Mr. Zhang Yaxu was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

This QA observed ZPMC qualified welding personnel identified as 217805 perform Flux Cored Arc Weld (FCAW) on lift 13E floor beam weld joint identified as FB3123-001-012. ZPMC QC identified as Mr. Zhang Yaxu was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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 (15000422372), who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Hall,Steven	Quality Assurance Inspector
----------------------	-------------	-----------------------------

---

<b>Reviewed By:</b>	Peterson,Art	QA Reviewer
---------------------	--------------	-------------