

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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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-015911**Date Inspected:** 15-Jul-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:** Huang Min**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 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 6**

This QA observed ZPMC qualified welding personnel identified as 057795 perform Shielded Metal Arc Welding (SMAW) on west jacking frame weld joint identified as WJF-0-110. ZPMC Quality Control personnel (QC) identified as Mr. Zhao Jian Hang 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-3311-TC-P4.

This QA observed ZPMC qualified welding personnel identified as 057795 perform Flux Cored Arc Welding (FCAW) on lift bottom panel weld joints identified as BP3095-001-120 and 121. ZPMC Quality Control personnel (QC) identified as Mr. Xia Yong Zheng 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-4133.

**OBG BAY 7**

This QA observed ZPMC qualified welding personnel identified as 205386 perform Flux Cored Arc Weld (FCAW) on lift 13 edge panel weld joints identified as EP3022-001-075 and 076. ZPMC QC identified as Mr. Guo Pan was present to monitor the welding process. The welding parameters as measured using QC's calibrated

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instruments appeared to be in general compliance with WPS-B- T-2132-3.

This QA observed ZPMC qualified welding personnel identified as 204342 perform Flux Cored Arc Weld (FCAW) on lift 13 edge panel weld joints identified as EP3022-001-033 and 034. ZPMC QC identified as Mr. Guo Pan 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 8

This QA observed ZPMC qualified welding personnel identified as 054459 perform Flux Cored Arc Weld (FCAW) on bike path weld joints identified as BK004A8-056-041 and 042. ZPMC QC identified as Mr. Yong Qing 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-B- T-2132.

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.

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<b>Inspected By:</b>	Hall,Steven	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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