

**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-015950**Date Inspected:** 01-Aug-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:** welder qual**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Bay 10

This QA Inspector observed Welder Qualification using the Flux Cored Arc Welding (FCAW) and Shield Metal Arc Welding (SMAW) process for Complete Joint Penetration (CJP) Groove Tests for plate of unlimited thickness in the 3G (vertical) and 4G (overhead) position.

Position, Process, WPS and Test Plate ID# are as follows:

3G

FCAW

WPS-B-T-2233T

2-F-3G (VT Reject)

3-F-3G

4-F-3G (VT Reject)

5-F-3G

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7-F-3G (VT Reject)  
8-F-3G  
9-F-3G  
14-F-3G  
16-F-3G (VT Reject)  
22-F-3G  
24-F-3G (VT Reject)  
29-F-3G  
26-F-3G (VT Reject)  
27-F-3G (VT Reject)  
28-F-3G (VT Reject)

3G  
SMAW  
WPS-B-P-2213-B-U2a-1

3-S-3G  
27-S-3G

4G  
SMAW  
WPS-B-P-2214-B-U2a-1

29-S-4G  
30-S-4G (VT Reject)

ZPMC QC CWI Li Yang was present during Welder qualification. Test coupons will be sent to ZPMC weld lab for Radiographic Testing and Mechanical Bend Tests.

Visual for CJP test plates and Tack weld Visual and Fracture Testing results were accepted by ZPMC QC unless otherwise noted.

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

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

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**Inspected By:** Hernandez, Dan

Quality Assurance Inspector

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**Reviewed By:** Peterson, Art

QA Reviewer