

**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-001802**Date Inspected:** 24-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Chen Xi, Huang Wen Pang & Xu Xian Ping			<b>CWI Present:</b>	Yes	No	
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006			<b>Component:</b>	Deck Plate		

**Summary of Items Observed:**

On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the observations related the following;

Bay-1 Deck Plate DP-061-001, welds 1 through 10. Zhenhua Port Machinery Company, ZPMC, Welders Han Changhou #059464, Gao Xin Dong #059361 and Yang Fengohuan #059355 were performing welding on the Rib to Plate areas. The ZPMC CWI present during this period was Chen Xi.

Bay-1 Deck Plate DP-019-001. Grinding of the Rib to Plate tack welds was being performed.

Bay-1 Rib Plate drilled holes were being de-burred.

Bay-1 Deck Plate DP-017-001. tack welding was being performed on the Rib to Plate 12A by ZPMC welders ShengQizhen #059401 and Shi Yunli #059409. The welding procedure being utilized was WPS-B-T-2342-U2 (U-Rib) and the ZPMC QC for the area was Duan Ya Bing.

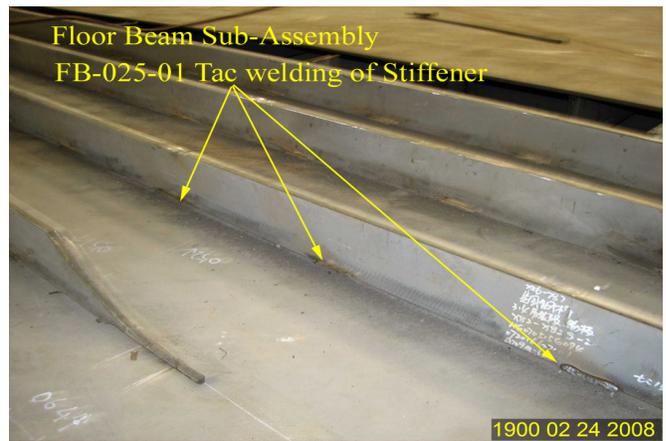
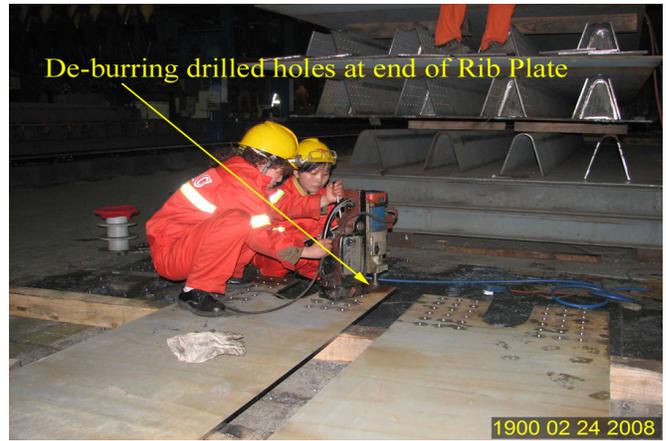
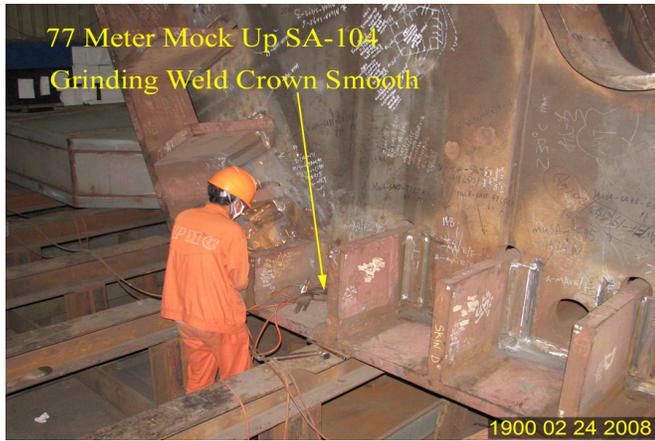
Bay-2 77 Meter Mock Up SA-104. Grinding of the weld crown on the horizontal welding was being performed.

Bay-3 Bottom Plate BP-18-01-013 thru 024. Welding of the Stiffeners to Plate 47A was being performed by ZPMC welders Li Xuehua #058174, Liu Zihong #062447 and Sun Tiyu #054459. The QC present was Guo Yang Wei and the CWI was Xu Xian Ping. The WPS posted was WPS-B-T-2132-3.

Bay-7 Floor Beam Sub-Assembly, Plate FB-025-01-117. Tack welding was being performed on the Stiffeners to Plate FB-025 by ZPMC welder Wang Lian Sheng #051127 in accordance with the WPS-B-T-2132-3. The CWI for this area was Huang Wen Pang and the QC was Xiang Feng Fong.

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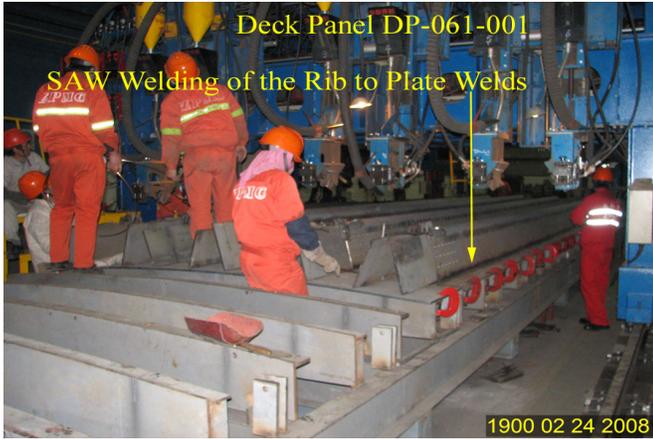


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## Summary of Conversations:

There were no pertinent conversations pertaining to the project during this shift.

## 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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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**Inspected By:** Smith,David

Quality Assurance Inspector

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**Reviewed By:** Cochran,Jim

QA Reviewer