

**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-003125**Date Inspected:** 25-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Wen Pang**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:**

Caltrans Quality Assurance (QA) Inspector, Ken Jobes, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, to randomly monitor welding and Quality Control (QC) functions. While on site, the QA Inspector observed and/or discovered the following:

OBG – 7

The Caltrans QA Inspector randomly observed the semi-automatic flux cored arc welding (FCAW) of Weld No. 045 on Floor Beam FB011-009. The welder was Zhang Qing quan (I. D. 044774). The Caltrans QA Inspector also randomly observed the machine FCAW of Weld Nos. 013 and 014 on Floor Beam FB009-007. The welding operator for Weld No. 013 was Liu Long xian (I. D. 044786) and the welding operator for Weld No. 014 was Chen Chaun zong (I. D. 044824). Certified Welding Inspector (CWI), Wang Wen Pang (CWI No. 02080501) was present during all of the above welding. The Welding Procedure Specification (WPS) being used was WPS-B-T-2132-3. The Caltrans QA Inspector verified the qualifications of the welding operators and welder, and that the electrode classification, diameter of electrode, amperage, voltage, travel speed, and preheat/interpass temperatures were within the specified ranges on the applicable WPS.

The Caltrans QA Inspector also randomly observed the grinding of plate stiffeners.

All above observations appeared to meet the requirements of the job specifications.

**Summary of Conversations:**

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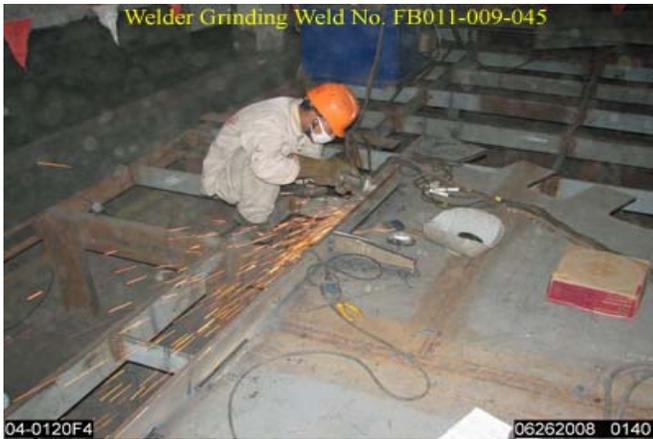
# WELDING INSPECTION REPORT

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As identified within the contents of this report.



## 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 Patrick Lowery (858)344-2712, who represents the Office of Structural Materials for your project.

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**Inspected By:** Jobses, Kenneth

Quality Assurance Inspector

**Reviewed By:** Carreon, Albert

QA Reviewer

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