

**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-005177**Date Inspected:** 15-Jan-2009**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:** Zhang Bao Lei**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:** cross braces and OBG segments**Summary of Items Observed:**

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

OBG assembly bay 19

This QA observed ZPMC personnel tack welding cross beam diaphragm sub assembly identified on the material as mark# FB209A.

OBG outside assembly (OBG segment 5AE)

This QA along with other Caltrans QA inspectors performed preliminary visual inspection of this segment prior to ZPMC sandblast and paint. This QA found numerous non-conforming weld defects and material surface and edge discontinuities. This QA noted that ZPMC and ABF QA/QC inspectors were present during this inspection.

OBG outside assembly (OBG segment 4BW)

This QA observed ZPMC qualified welding personnel identified as Mr. He Junrong (201215) perform FCAW welding on weld joints identified as SSD11-PP027-220 and 221. ZPMC QC identified Mr. Wang Tai was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared

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to be in general compliance with WPS-B-T-2232-TC-U4b-F-1.

OBG outside assembly (OBG segment 5BW)

This QA observed ZPMC qualified welding personnel identified as Mr. Zang Wei (0066413) performing SMAW repair welding on Complete Joint Penetration (PJP) welds identified on the material as SSD12-PP34.5-129, 130, 131 and 132. QC identified as Mr. Wushi Gai 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-SMAW-3G (3F)-repair. Weld repair report # B-WR1805.

OBG outside assembly (OBG segment 5AW)

No work observed on this segment during the time this QA was present.

OBG outside assembly (OBG segment 5CW)

No work observed on this segment during the time this QA was present.

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>	Carreon,Albert	QA Reviewer

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