

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-005488**Date Inspected:** 19-Feb-2009**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:** Luan Zhao Gang**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 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 outside assembly (OBG segment 3BE)

This QA observed ZPMC qualified welding personnel identified as Mr. Hong Liang (200113) perform SMAW welding on weld joints identified as CSDA-PP023-055, 052 and 051. ZPMC QC identified as Mr. Wang Wei Ming 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-4113-2.

This QA observed ZPMC qualified welding personnel identified as Mr. Fang Xinyou (037748) perform SMAW welding on weld joint identified as CSD6-PP23-079. ZPMC QC identified as Mr. Wang Wei Ming 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-4113-2.

This QA observed ZPMC qualified welding personnel identified as Mr. Sun Lingling (048047) perform SMAW welding on weld joint identified as CA04-045. ZPMC QC identified as Mr. Wang Wei Ming 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-4113-2.

This QA observed ZPMC qualified welding personnel identified as Mr. Hu Yacheng (049339) perform SMAW base metal weld repairs in various areas of this segment. ZPMC QC identified as Mr. Wang Wei Ming was present

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# WELDING INSPECTION REPORT

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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-1G (1F)-repair and WPS-345-SMAW-3G (3F)-repair.

OBG outside assembly (OBG segment 4AE)

This QA observed several ZPMC personnel fitting the lifting lugs one of the floor beams in this segment. No other significant work was observed in this segment while QA was present.

OBG outside assembly (OBG segment 3AE)

This QA observed ZPMC personnel carbon arc gouging areas previously rejected by ZPMC QC UT technicians in weld identified as SEG014A-016.

This QA observed ZPMC qualified welding personnel identified as Mr. Li Yongshui (067656) perform SMAW 3 Critical Weld Repairs (CWR) on weld joint identified as SEG014A-016. ZPMC QC identified as Mr. Geng Wei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with CWR report no. B-CWR350 and WPS-345-SMAW-4G (4F)-repair.

This QA observed ZPMC qualified welding personnel identified as Mr. Bai Jinhui (067756) perform SMAW welding on weld joints identified as CSD5-PP027-087, 088, 091 and 092. ZPMC QC identified as Mr. Wang Wei Ming 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-P-2112.

This QA observed ZPMC QC Ultrasonic Testing (UT) technician testing welds that have been repaired by ZPMC welding personnel.

OBG outside assembly (OBG segment 4BW)

No significant work was observed in this segment while 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 Patrick Lowry (858)-344-2712, 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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