

**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-005565**Date Inspected:** 27-Jan-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:** Shazhi, C. M. Chen**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 Segment**Summary of Items Observed:**

CALTRANS OSM Quality Assurance (QA) Inspector, Erik Prue 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) facility at Changxing Island in Shanghai, China. QA Inspector and/or found the following:

Outside Bay 13 lift 5AW: QA Inspector randomly observed ZPMC qualified welder Feng Hua Jun ID#0662583 welding various base metal repairs to outside surface of lift. Welder was observed welding in the 4G (overhead) position utilizing Shielded Metal Arc Welding (SMAW) process with a 4 mm diameter electrode THJ506Fe-1 (E7018-1). QA Inspector observed the ZPMC QC Inspector Zhang Xiao Ming verifying welding parameters and pre-heat were in accordance with the Welding Procedure Specification (WPS). QA Inspector with QC Inspector observed parameters as follows: preheat temperature to be at 40°C and measured the welding parameters to be 172 amps, 22 volts, a travel speed of 100 mm/min. Welding parameters verified by QA Inspector appear to be in general compliance with the approved WPS-B-P-2214-Tc-U4b\_FCM.

Bay 14 lift 1BEW: QA Inspector randomly observed ZPMC qualified welder ID#200432 tack welding floor beam FB056-002 to bottom plate at panel point 10.5. Welder was observed welding in the 2F (horizontal) position utilizing Shielded Metal Arc Welding (SMAW) process with a 4 mm diameter electrode THJ506Fe-1 (E7018-1). QA Inspector observed the ZPMC QC Inspector Li Mingyang verifying welding parameters and pre-heat were in accordance with the Welding Procedure Specification (WPS). Welding parameters verified by QA Inspector appear to be in general compliance with the approved WPS-B-P-2213.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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# WELDING INSPECTION REPORT

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**Summary of Conversations:**

No significant conversations this day.

**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>	Prue,Erik	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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