

**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-005581**Date Inspected:** 15-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shi 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:** OBG**Summary of Items Observed:**

On this day 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) at Changxing Island in Shanghai, China. QA Inspector observed and/or found the following:

Bay 13: QA Inspector randomly observed ZPMC qualified welder ID#066028 tack welding Deck Panel DP731A to Edge Plate EP108A and DP728A to EP104. Welder was observed tack welding in the 3F (vertical) position utilizing Shielded Metal Arc Welding (SMAW) process. QA Inspector observed the ZPMC QC Inspector Huang Shuai 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 125°C and measured the welding parameters to be 160 amps, 21 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-2113-FCM.

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

**Summary of Conversations:**

QA Inspector noted 5 bottom plate segments had been laid in east jig bay 14 and asked QC CWI Mr. Shi Lei what lifts the bottom plate were. Mr. Shi Lei informed QA Inspector the bottom plates were for lifts 6AE, 6BE, 6CE, 7AE, and 7BE. QA Inspector asked QC Inspector to mark bottom plates with the appropriate lift number. QC Inspector concurred and marked the bottom plates.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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## 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>	Carreon,Albert	QA Reviewer

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