

**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-006162**Date Inspected:** 11-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Hong Fei & Wu Zhi Cheng**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:** Tower and OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz 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:

Bay 11

This QA inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The member(s) is/are identified as Lift 1 East Tower. The weld designations reviewed are as follows:

1. Welds on Skin B and C between 18m~28m diaphragms.
2. Fit lugs on Skin C (partial) on diaphragms 18m, 23m and 28m.
3. Fit lugs on Skin B on 18m and 23m diaphragms.

Bay 11

This QA Inspector observed the following work in progress:

SAW welding of weld joint 24A located on PCMK WSD1-FASA3-2E/E.

Welder is identified as Mr. Deg Jun Feng (202756). ZPMC QC is identified as Mr. Li Hong Fei.

The welding variables recorded by QC appeared to comply with WPS-B-P-2221-B-P3-S-2.

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SAW welding of weld joint 8A located on PCMK WD1-A25A/E.

Welder is identified as Mrs. Cao Xiaohua (056975). ZPMC QC is identified as Mr. Peng Guo.

The welding variables recorded by QC appeared to comply with WPS-345-SAW-1G-Repair.

FCAW welding of weld joint 2 located on PCMK ESD1-A167-AH.

Welder is identified as Mr. Zhang Lliang (067036). ZPMC QC is identified as Mr. Peng Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2a-F.

Bay 10

This QA Inspector observed the following work in progress:

SAW welding of weld joint 7B located on PCMK NSD-FESA3-1A/D.

Welder is identified as Mrs. Zhang Lingling (207746). ZPMC QC is identified as Mr. Liu Liang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

SAW welding of weld joint 37B located on PCMK NSD1-FESA3-1A/D.

Welder is identified as Mrs. Liu Xianoyan (207745). ZPMC QC is identified as Mr. Liu Liang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

Bay 13

FCAW welding of weld joint 025 located on PCMK SEG2A.

Welder is identified as Mr. Han Kun (066751). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G (2F)-Repair.

FCAW welding of weld joint 004 located on PCMK CA026.

Welder is identified as Mr. Yang Hongjun (070254). ZPMC QC is identified as Mr. Liu Fa Wen.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U4b-F.

SAW welding of weld joint 005 located on PCMK SEG036\*.

Welder is identified as Mrs. Sun Guzuo (058100). ZPMC QC is identified as Mr. Liu Liang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

Bay 7

SMAW welding of weld joint 007 and 008 located on PCMK SP661-001.

Welder is identified as Mr. Zhao Shuming (046819). ZPMC QC is identified as Mr. Wu Zhi Feng.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112-FCM.

Bay 2

FCAW welding of weld joint 007 and 008 located on PCMK FB015-038.

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Welder is identified as Mr. Wang Shilin (205091). ZPMC QC is identified as Xu Xia Ping.  
The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

FCAW welding of weld joint 013 and 014 located on PCMK FB010-030.

Welder is identified as Mr. Wang Chaili (045203). ZPMC QC is identified as Mr. Zhi Jiang.  
The welding variables recorded by QC appeared to comply with WPS-B-T-2133 and WPS-B-T-2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with 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 (134-8257-0045), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Alaniz,Joe	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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