

**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-006436**Date Inspected:** 27-Apr-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:** Chen Xi / Li Yang**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:** crossbeams**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 cross beam CB1**

This QA observed ZPMC qualified welding personnel identified as 067993 perform SMAW repair welding on various welds in this crossbeam. ZPMC QC identified as Mr. Jian Lei 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 and WPS-B-P-2112-FCM.

**OBG cross beam CB2**

This QA noted that this crossbeam is still in the paint bay. No significant work was observed on this cross beam during the time QA was present.

**OBG cross beam CB3**

This QA observed ZPMC personnel perform clean up and grinding. This QA observed ZPMC qualified welding personnel identified as 062811 perform SMAW repair welding on various welds in this crossbeam.

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

ZPMC QC identified as Mr. Zhong Cheng 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-2G (2F)-repair.

### OBG cross beam CB4

This QA observed ZPMC personnel perform clean up and grinding. No other significant work was observed on this cross beam during the time QA was present.

### OBG cross beam CB5

This QA observed ZPMC qualified welding personnel identified as 037705 perform FCAW welding on weld joint identified as CB202A-001-014. ZPMC QC CWI identified as Mr. Zhang Yang 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-2232-TC-U4b-F.

This QA observed ZPMC qualified welding personnel identified as 067520 perform FCAW welding on weld joint identified as CB202A-001-002. ZPMC QC CWI identified as Mr. Zhang Yang 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-2232-TC-U4b-F.

This QA observed ZPMC qualified welding personnel identified as 066480 perform SMAW welding on weld joint identified as CB202G-008-145 and 163. ZPMC QC CWI identified as Mr. Zhang Yang 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-2113.

This QA observed ZPMC qualified welding personnel identified as 066456 perform SMAW welding on weld joint identified as CB202G-008-143 and 161. ZPMC QC CWI identified as Mr. Zhang Yang 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-2113.

### OBG cross beam CB6

This QA observed ZPMC personnel are in the process of fitting and tack welding the west side and intermediate panels to the deck panel. No other significant work was being performed on this crossbeam 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.

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---



## 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.

---

<b>Inspected By:</b>	Hall,Steven	Quality Assurance Inspector
<b>Reviewed By:</b>	Prue,Erik	QA Reviewer

---