

**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-006778**Date Inspected:** 20-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

|                                    |                            |    |     |                                  |               |    |     |
|------------------------------------|----------------------------|----|-----|----------------------------------|---------------|----|-----|
| <b>CWI Name:</b>                   | Liu Yang and Wan Wen Zhong |    |     | <b>CWI Present:</b>              | Yes           | No |     |
| <b>Inspected CWI report:</b>       | Yes                        | No | N/A | <b>Rod Oven in Use:</b>          | Yes           | No | N/A |
| <b>Electrode to specification:</b> | Yes                        | No | N/A | <b>Weld Procedures Followed:</b> | Yes           | No | N/A |
| <b>Qualified Welders:</b>          | Yes                        | No | N/A | <b>Verified Joint Fit-up:</b>    | Yes           | No | N/A |
| <b>Approved Drawings:</b>          | Yes                        | No | N/A | <b>Approved WPS:</b>             | Yes           | No | N/A |
|                                    |                            |    |     | <b>Delayed / Cancelled:</b>      | Yes           | No | N/A |
| <b>Bridge No:</b>                  | 34-0006                    |    |     | <b>Component:</b>                | 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 10

FCAW welding of weld joint 45A located on NSD1-FDSA3-1B/C.

Welder is identified as Mr. Li Shoufu (066674). ZPMC QC is identified as Mr. Liu Yang.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G (1F)-Repair.

FCAW welding of weld joint 20A located on NSD1-FDSA3-1B/C.

Welder is identified as Mr. Chan Chuancang (053870). ZPMC QC is identified as Mr. Liu Yang.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G (1F)-Repair.

FCAW welding of weld joint 41A located on NSD1-FDSA3-1B/C.

Welder is identified as Mr. Jiang Zhou (040261). ZPMC QC is identified as Mr. Liu Yang.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G (1F)-Repair.

FCAW welding of weld joint 36 located on NSD1-FDSA3-1B/C.

Welder is identified as Mr. Nie Baofeng (068864). ZPMC QC is identified as Mr. Wan Wen Zhong.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

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FCAW welding of weld joint 37 located on NSD1-FDSA3-1B/C.

Welder is identified as Mr. Dong Changxi (070046). ZPMC QC is identified as Mr. Wan Wen Zhong.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

FCAW welding of weld joint 29 located on NSD1-FDSA3-1B/C.

Welder is identified as Mr. Wang Kui (203977). ZPMC QC is identified as Mr. Wan Wen Zhong.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

FCAW welding of weld joint 30 located on NSD1-FDSA3-1B/C.

Welder is identified as Mr. Yu Jun (201825). ZPMC QC is identified as Mr. Wan Wen Zhong.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

FCAW welding of weld joint 53 located on NSD1-A166H/J.

Welder is identified as Mrs. Wu Zhizhong (057180). ZPMC QC is identified as Mr. Li Ming.

The welding variables recorded by QC appeared to comply with WPS-B-T-4332-Tc-P4-F.

FCAW welding of weld joint 83 located on NSD1-A166G/J.

Welder is identified as Mr. Zhuang Hua (068206). ZPMC QC is identified as Mr. Li Ming.

The welding variables recorded by QC appeared to comply with WPS-B-T-4332-Tc-P4-F.

FCAW welding of weld joint 198 located on NSD1-A166C/J.

Welder is identified as Mr. Zhu Bensheng (068047). ZPMC QC is identified as Mr. Li Ming.

The welding variables recorded by QC appeared to comply with WPS-B-T-4332-Tc-P4-F.

Bay 11

SMAW welding of weld joint 31 and 32 located on ND1-A268-23M-1.

Welder is identified as Mr. Liu Qing Yong (066479). ZPMC QC is identified as Mr. Zhang Zhi Neng.

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

SMAW welding of weld joint 17 and 18 located on ND1-A476-53M-1.

Welder is identified as Mr. Li Xiuchun (040733). ZPMC QC is identified as Mr. Zhang Zhi Neng.

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

SMAW welding of weld joint 48 located on ND1-A476-53M-1.

Welder is identified as Mr. Liu Ji (070007). ZPMC QC is identified as Mr. Zhang Zhi Neng.

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

SMAW welding of weld joint 42 located on ND1-A476-53M-1.

Welder is identified as Mr. Wang Wei Jun (070006). ZPMC QC is identified as Mr. Zhang Zhi Neng.

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

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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 |
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| <b>Reviewed By:</b> | Carreon,Albert | QA Reviewer |
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