

**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-007091**Date Inspected:** 09-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**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:** Liu Wan Ning and Chen Ming**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 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 14

SAW welding of weld joint 003 located on SEG-043.

Welder is identified as Mrs. Lu Shi Qin (044755). ZPMC QC is identified as Mr. Liu Wan Ning.

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

SMAW welding of weld joints 169 and 172 located on SEG-036E.

Welder is identified as Mr. Chang Zhan Chi (200432). ZPMC QC is identified as Mr. Chen Ming.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM.

SMAW welding of weld joints 015 and 018 located on SEG-040E.

Welder is identified as Mr. Xu Shangtai (068088). ZPMC QC is identified as Mr. Chen Ming.

The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-U4b-FCM.

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SMAW welding of weld joints 132, 134, 136 and 128 located on SSD10A-PP56.  
Welder is identified as Mr. Wang Jun (067752). ZPMC QC is identified as Mr. Liu Wan Ning.  
The welding variables recorded by QC appeared to comply with WPS-B-P-2114.

SMAW welding of weld joint 002 located on SEG043.  
Welder is identified as Mr. Li Jiao (049861). ZPMC QC is identified as Mr. Liu Wan Ning.  
The welding variables recorded by QC appeared to comply with WPS-B-P-2211-B-U2.

FCAW welding of weld joint 171 and 172 located on SEG-040-SSD18-PP50.  
Welder is identified as Mr. Xu Liguang (200114). ZPMC QC is identified as Mr. Liu Wan Ning.  
The welding variables recorded by QC appeared to comply with WPS-B-P-2112-FCM and WPS-B-P-2114-FCM.

Bay 13

SMAW welding of weld joints 039 located on SP621-001.  
Welder is identified as Mr. Jin Zhu (044837). ZPMC QC is identified as Mr. Chen Ming.  
The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2.

FCAW welding of weld joint 035 and 036 located on SEG-44B.  
Welder is identified as Mr. Pan Ming (066673). ZPMC QC is identified as Mr. Chen Ming.  
The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joint 017 located on SEG-44C.  
Welder is identified as Mr. Huang Hongpei (037705). ZPMC QC is identified as Mr. Chen Ming.  
The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joint 026 located on SEG-48B.  
Welder is identified as Mr. Wu Wan Yong (050242). ZPMC QC is identified as Mr. Chen Ming.  
The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 004 located on CA054.  
Welder is identified as Mr. Chen Fenglian (206623). ZPMC QC is identified as Mr. Chen Ming.  
The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 003 located on CA053.  
Welder is identified as Mr. Wu Cunxiang (070101). ZPMC QC is identified as Mr. Chen Ming.  
The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U4b-F.

Bay 19

FCAW welding of weld joints 003 located on BP025-009.  
Welder is identified as Mr. Yu Bing (062737). ZPMC QC is identified as Mr. Lu Li Qing.  
The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-U2-F.

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

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