

**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-007203**Date Inspected:** 11-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Zhu Zhenghu and Shen Fu You	<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>	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 002 located on SEG-048.

Welder is identified as Mrs. Lu Shi Qin (044755). ZPMC QC is identified as Mr. Shen Fu You.

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

SMAW welding of weld joint 248 located on SSD12A-PP58.

Welder is identified as Mr. Wang Fupeng (205718). ZPMC QC is identified as Mr. Shen Fu You.

The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2.

SMAW welding of weld joint 004 located on SSD14-PP055.

Welder is identified as Mr. Wang Chaili (045203). ZPMC QC is identified as Mr. Shen Fu You.

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

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### Bay 13

FCAW welding of weld joint 036 located on LD003-038.

Welder is identified as Mr. Jin Zhenghu (037907). ZPMC QC is identified as Mr. Shen Fu You.

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

FCAW welding of weld joint 128 located on SSD16A-PP62.

Welder is identified as Mr. Ai Xiang Long (066480). ZPMC QC is identified as Mr. Shen Fu You.

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

FCAW welding of weld joint 131 located on SSD13A-PP65.

Welder is identified as Mr. Huang Hongpei (037705) ZPMC QC is identified as Mr. Shen Fu You.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2-F.

FCAW welding of weld joint 135 located on SSD13A-PP65.

Welder is identified as Mr. Pan Meng (066673) ZPMC QC is identified as Mr. Shen Fu You.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2-F.

FCAW welding of weld joints 042, 044 and 046 located on DP308-001.

Welder is identified as Mr. We Chao (069866) ZPMC QC is identified as Mr. Shen Fu You.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133 and WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joints 087, 088, 091 and 092 located on CSD4-PP64.

Welder is identified as Mr. Dan Deyin (044795) ZPMC QC is identified as Mr. Shen Fu You.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joints 011 and 012 located on SEG048E.

Welder is identified as Mr. Cao Tao (066163) ZPMC QC is identified as Mr. Shen Fu You.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

### Bay 19

SAW welding of weld joints 003 located on BP025-009.

Welder is identified as Mr. Wang Yu Long (062817). ZPMC QC is identified as Mr. Zhu Zhenghu.

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

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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# WELDING INSPECTION REPORT

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**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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