

**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-007204**Date Inspected:** 13-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Zhong Hai and Liu Fa Wen	<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 009 located on SEG-057A.

Welder is identified as Mr. Xu Peipei (050323). 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.

FCAW welding of rain diverter located on OBG Segment 6BW.

Welder is identified as Mr. He Hanbi (202122). ZPMC QC is identified as Mr. Shen Fu You.

The welding variables recorded by QC appeared to comply with WPS-B-P-2113.

FCAW welding of weld joint 010~112 located on DP281A-001.

Welder is identified as Mr. Gao Min (050988). ZPMC QC is identified as Mr. Shen Fu You.

The welding variables recorded by QC appeared to comply with WPS-B-P-2233-Tc-U4b.

FCAW welding of weld joint 004 located on SD14-PP55.

Welder is identified as Mr. Cheng Haixian (045209). ZPMC QC is identified as Mr. Shen Fu You.

The welding variables recorded by QC appeared to comply with WPS-B-P-2232-Tc-U4b-F.

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FCAW welding of weld joint 013~116 located on DP254A-001.

Welder is identified as Mr. Jia Guang Fu (069089). ZPMC QC is identified as Mr. Shen Fu You.

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

Bay 13

SMAW welding of weld joints 010 located on SEG044A.

Welder is identified as Mr. Zhao Aifei (067942). ZPMC QC is identified as Mr. Geng Wei.

The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM.

SMAW welding of weld joints 016 located on SEG044A.

Welder is identified as Mr. Cao Xinglong (069683). ZPMC QC is identified as Mr. Geng Wei.

The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM.

SMAW welding of weld joints 015 located on SEG044A.

Welder is identified as Mr. Li Zai Jun (037996). ZPMC QC is identified as Mr. Geng Wei.

The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM.

SMAW welding of weld joints 021 located on SEG047B.

Welder is identified as Mr. Bai Jinhua (067756). ZPMC QC is identified as Mr. Zhong Hai.

The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM.

SMAW welding of weld joints 020 located on SEG047B.

Welder is identified as Mr. Wang Li (044772). ZPMC QC is identified as Mr. Zhong Hai.

The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM.

Bay 19

FCAW welding of weld joints 008 located on SB601-010.

Welder is identified as Mr. Zhang Shanbao (062763). ZPMC QC is identified as Mr. Liu Fa Wen.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U5-F.

FCAW welding of weld joints 043 located on SB004-010.

Welder is identified as Mr. Yuan Yan Song (062797). ZPMC QC is identified as Mr. Liu Fa Wen.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U5-F.

Outside Bay 13 Segment 6CE

SMAW welding of weld joints 165 located on FB28-001.

Welder is identified as Mr. Chen Renzhi (058087). ZPMC QC is identified as Mr. Li Yan Hua.

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

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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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