

**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-007352**Date Inspected:** 22-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>	Zhang Bao Len and Geng Wei	<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 19

FCAW welding of weld joints 002, 003, 051 and 052 located on SB014-058.

Welder is identified as Mr. Feng Hulong (062778) ZPMC QC is identified as Mr. Liu Fa Wen.

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

FCAW welding of weld joints 002, 003, 051 and 052 located on SB013-068.

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

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

## Bay 13

FCAW welding of weld joints 103 located on SSD11-PP63.

Welder is identified as Mr. Zhao Shanlun (066683). ZPMC QC is identified as Mr. Geng Wei.

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

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FCAW welding of weld joints 015 located on SEG047E.

Welder is identified as Mr. Jia Guang Fu (069089). ZPMC QC is identified as Mr. Geng Wei.

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

FCAW welding of weld joints 037 located on SEG044A.

Welder is identified as Mr. Jin Chengmao (058551). ZPMC QC is identified as Mr. Geng Wei.

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

FCAW welding of weld joints 037 located on SEG044A.

Welder is identified as Mr. Jin Chengmao (058551). ZPMC QC is identified as Mr. Geng Wei.

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

FCAW welding of weld joints 220 located on SSD16-PP68.

Welder is identified as Mr. Zhao Jibo (055564). ZPMC QC is identified as Mr. Geng Wei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U4c-F.

SMAW welding of weld joint 240 located on SSD16-PP68.

Welder is identified as Mr. Lu Xiao Jie (067904). ZPMC QC is identified as Mr. Geng Wei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2214-Tc-U4b-FCM-1.

Back of Bay 14

SMAW welding of weld joint 031 located on SEG027B.

Welder is identified as Mr. Zang Yanho (045196). ZPMC QC is identified as Mr. Zhang Bao Lei.

The welding variables recorded by QC appeared to comply with WPS-B-U2-FCM-1.

SMAW welding of weld joint 004 located on SEG029A.

Welder is identified as Mr. Zai Pawei (068097). ZPMC QC is identified as Mr. Zhang Bao Lei.

The welding variables recorded by QC appeared to comply with WPS-B-U2-FCM-1.

SMAW welding of weld joint 004 located on SEG029A.

Welder is identified as Mr. Zai Pawei (068097). ZPMC QC is identified as Mr. Zhang Bao Lei.

The welding variables recorded by QC appeared to comply with WPS-B-U2-FCM-1.

SMAW welding of weld joint 185 located on SSD11A-PP39.

Welder is identified as Mr. Li Bin (069896). ZPMC QC is identified as Mr. Li Yan Hua.

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

SMAW welding of weld joint 181 located on SSD11A-PP39.

Welder is identified as Mr. Yun Chuanshan (050316). ZPMC QC is identified as Mr. Li Yan Hua.

The welding variables recorded by QC appeared to comply with WPS-B-T-2213-Tc-U4b-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
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<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer
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