

**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-007354**Date Inspected:** 23-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**CWI Name:** Wu Zhi Cheng**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:

OBG Assembly Yard

1AE Segment

SMAW welding of weld joint 005 located on OB14.

Welder is identified as Mr. Ni Leijiang (037723). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1.

SMAW welding of weld joint 004 located on OB14.

Welder is identified as Mr. Yun Chengxian (045138). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair-1.

SMAW welding of weld joints 31, 32, 33 and 34 located on SEG003D.

Welder is identified as Mr. Zhou Bing (067764). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2114-FCM-1.

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FCAW welding of weld joints 15, 16 and 17 located on SEG003E.

Welder is identified as Mr. Gang Huaigang (037840). ZPMC QC is identified as Mr. Wu Zhi Cheng.

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

### 1AW Segment

FCAW welding of weld joints 029~042 located on SP385A-001.

Welder is identified as Mr. Li Shuqing (053609). ZPMC QC is identified as Mr. Wu Zhi Cheng.

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

FCAW welding of weld joints 029~036 located on SP287A-001.

Welder is identified as Mr. Chen Zhenghua (220067). ZPMC QC is identified as Mr. Wu Zhi Cheng.

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

### 1BW Segment

SMAW welding of weld joint 001 located on EA102.

Welder is identified as Mr. Bi Shijian (068764). ZPMC QC is identified as Mr. Wu Zhi Cheng.

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

### 4BW Segment

SMAW welding of weld joint 004 located on SEG19A.

Welder is identified as Mr. Li Wenguo (066261). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-B-P-2214-U2b-FCM-1.

SMAW welding of weld joint 007 located on SEG021A.

Welder is identified as Mr. Jiang Zhen (068917). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-B-P-2214-U2b-FCM-1.

### 3BW Segment

FCAW welding of weld joint 031 located on SEG013A.

Welder is identified as Mr. Li Guimin (220069). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-B-U2-F.

FCAW welding of weld joint 008 located on SEG015A.

Welder is identified as Mr. Lu Yong Yuan (202841). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-B-U2-F.

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

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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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