

**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-008276**Date Inspected:** 27-Jul-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>	Wu Zhi Cheng and Chen Xi	<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:

OBG Assembly Yard

1AAW Segment

SMAW welding of spacer blocks at various locations on deck & side plate (crossbeam side of segment).

Welder is identified as Mr. Bi Shijian (068764). ZPMC QC is identified as Mr. Chen Xi.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114.

4AW Segment

FCAW repair welding of weld joint 20, 21, 23~26 and 38 located on SEG017.

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

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

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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## 4AE Segment

SMAW repair welding of weld joint 004 located on SSD20-PP025.

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

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G (2F)-FCM-Repair-2 and CWR procedure B-CWR629.

## 3AW Segment

FCAW repair welding of side plate stiffeners located at panel point 22~22 (crossbeam side).

Welder is identified as Mr. Han Xiaofeng (054467). 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.

## Between 4BW & 5AE Segments

FCAW repair welding of weld joint 009 located on BK2-001.

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-345-FCAW-3G (3F)-FCM-Repair.

FCAW repair welding of weld joints 009 and 006 located on BK3-001.

Welder is identified as Mr. Cao Caijun (220064). ZPMC QC is identified as Mr. Wu Zhi Cheng.

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

## NDT Observation

QA Inspector observed ZPMC Magnetic Particle (MT) Technician performing MT (Wet method) on various locations in the trail assembly yard. Locations are as followed:

1. Deck plate U-ribs at panel point 29 on Segment 5AE.
2. Deck plate U-ribs and side plate stiffeners (cross beam side) at panel point 29 on Segment 5AW.

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

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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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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