

**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-008277**Date Inspected:** 28-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 Gu Rong Jan			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<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

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as OBG 2BE, 3AW and 3AE T&I ribs. The weld designations reviewed are as follows:

## 2BE

1. SP181-001-38, 39, 44, 45, 49, 50
2. SP182-001-39, 40, 45, 46
3. SP183-001-37, 38, 41, 42
4. BP196-001-37, 38, 43, 44
5. BP192-001-37, 38, 43, 44
6. BP196-001-37, 43, 44, 47, 48
8. SP175-001-38, 39, 42, 43, 46, 47
9. SP176-001-41, 42, 45, 46
10. SP177-001-37, 38, 41, 43, 44, 45

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11. CA103-005

3AE

1. SEG014-029

3AW

1. BP001-001-38, 39, 44, 45

2. BP002-001-40, 41, 46, 47

3. BP003-001-38, 39, 46, 47

1AAW Segment

SMAW welding of spacer blocks at various locations on deck 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.

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 006 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 and B-WR6198.

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FCAW repair welding of base plates for BK3-001 and BK2-001 members.

Welder is identified as Mr. Feng Changdou (067572). ZPMC QC is identified as Mr. Wu Zhi Cheng.

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

CB2

SMAW repair welding (butter end) of panel point 23 on 2BE side.

Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Mr. Gu Rong Jan.

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

3AE Segment

SMAW repair welding of weld joint 003 located on SSD16-PP020.

Welder is identified as Mr. Lv Peng (048617). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-2 and CWR procedure B-CWR596.

SMAW repair welding of weld joint 003 located on SEG14A-005.

Welder is identified as Mr. Lv Peng (048617). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-2 and CWR procedure B-CWR596.

SMAW repair welding of weld joints 020 and 021 located on SEG14B.

Welder is identified as Mr. Lv Peng (048617). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-Repair and WR procedure B-WR6492.

3BE Segment

SMAW repair welding of weld joints 004 and 005 located on SSD19-PP023.

Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Mr. Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair and CWR procedure B-CWR596.

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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