

**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-008279**Date Inspected:** 30-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**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

3BW

SMAW repair welding of weld joints 004 and 005 located on SSD13-PP023.

Welder is identified as Mr. Qie Jianzhou (067571). ZPMC QC is identified as Mr. Xu Yu Ming.

The welding variables recorded by QC appeared to comply with WPS-SMAW-345-2G (2F)-Repair and CWR procedure B-CWR617.

3AW

SMAW repair welding of weld joints 003 and 004 located on SSD19-PP019.

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

The welding variables recorded by QC appeared to comply with WPS-SMAW-345-2G (2F)-Repair and CWR procedure B-CWR617.

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### 3AW & 3BW

SMAW repair welding of base metal located at weld joint SEG015B-46, 47 and 003~006.  
Welder is identified as Mr. Qie Jianzhou (067571). 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.

### 1AAW & 1AW

SMAW repair welding of weld joint 050 located on SEG003B.  
Welder is identified as Mr. Lv Peng (048617). ZPMC QC is identified as Wu Zhi Cheng.  
The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

SMAW repair welding of weld joint 050 located on SEG003C.  
Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Wu Zhi Cheng.  
The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

### 1AAW

SMAW welding of spacer blocks at various locations on side plate (crossbeam side of segment).  
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-2114.

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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