

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-008282**Date Inspected:** 03-Aug-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>	N/A	<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

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as OBG 2AW and 2BW T stiffeners. The weld designations reviewed are as follows:

1. BP193A-001-020
2. SP174A-001-023
3. SP172A-001-052

4BW

SMAW plug welding of horizontal stiffeners on panel point 27 and 28.

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-FCAW-4G (4F)-Repair misdrilled hole.

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

4AW

SMAW repair welding of weld joint 004 located on SSD13-PP024.

Welder is identified as Mr. Lv Peng (048617). ZPMC QC is identified as Mr. Xu Yu Ming.

The welding variables recorded by QC appeared to comply with WPS-SMAW-345-1G (1F)-Repair and CWR procedure B-CWR634.

FCAW repair welding of weld joints 023 and 024 located on SEG017B.

Welder is identified as Mr. Lv Peng (048617). ZPMC QC is identified as Mr. Xu Yu Ming.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G (2F)-Repair.

1AAW & 1AW

SMAW tack welding of side plate stiffener to stiffener on both segments located on the crossbeam side.

Welder is identified as Mr. Wang Zhonghua (053753). ZPMC QC is identified as Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-B-P-2213-B-U2-FCM.

SMAW tack welding of side plate stiffener to stiffener on both segments located on the counter weight side.

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

The welding variables recorded by QC appeared to comply with WPS-B-P-2233-B-U2-F.

FCAW welding of root pass at weld joint 001 located on OBW1A.

Welder is identified as Mr. Zhou Pan (220063). ZPMC QC is identified as Mr. Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-U2a-F-3.

FCAW welding of root pass at weld joint 001 located on OBW1A.

Welder is identified as Mr. Li Guimin (220069). ZPMC QC is identified as Mr. Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-U2a-F-3.

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

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

**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.

---

<b>Inspected By:</b>	Alaniz,Joe	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

---