

**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-008944**Date Inspected:** 26-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**CWI Name:** Li Jia**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

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 OBE 2 and OBG Z Plate. The weld designations reviewed are as follows:

2BE

1. SEG010A-007
2. SEG008C-023
3. SEG008B-023
4. SEG010C-019
5. SEG010B-005
6. SEG010A-008

Z Plate

1. SSD16-PP020-093, 094
2. SSD16-PP022-093, 094

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

1BE

SMAW welding (VT repair) of weld joints 001~008 located on BP314.

Welder is identified as Mr. Liu Houkuan (045133). ZPMC QC is identified as Li Jia.

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

5CE & 5BE

FCAW welding of weld joint 008 located on OBE5A.

Welder is identified as Mr. Xin Meng (053742). ZPMC QC is identified as Li Jia.

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

FCAW welding of weld joint 008 located on OBE5A.

Welder is identified as Mr. Li Shuqiang (053609). ZPMC QC is identified as Li Jia.

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

1BE

SMAW welding (repair) on bottom and side plate stiffeners on panel point 12.5 cross beam side.

Welder is identified as Mr. Hu Yanming (062092). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1.

1AAE

SMAW welding (VT repair) of weld joints 931~936 located on SEG2E.

Welder is identified as Mr. Liu Houkuan (045133). ZPMC QC is identified as Li Jia.

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

SMAW welding (VT repair) of weld joints 972~977 located on SEG2E.

Welder is identified as Mr. Liu Houkuan (045133). ZPMC QC is identified as Li Jia.

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

2BE

This QA Inspector observed a ZPMC work personnel performing the mechanically straightening diverter plate using a sledge hammer. Diverter plate is located between panel point 16 and 17 on the cross beam side of segment.

This QA Inspector issued an incident report on the above noted work.

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

## Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

## 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
---------------------	----------------	-------------