

**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-008946**Date Inspected:** 29-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>	Li Jia			<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 2AE. The weld designations reviewed are as follows:

**2AE**

1. SEG008A-029, 030
2. CA100-005, 006

**1AE & 1AAE**

FCAW welding of weld joint 009 located on OBE1.

Welder is identified as Mr. Yu Chuanshan (050316). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G (1F)-FCM-Repair-1 and repair procedure B-WR7125.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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SMAW welding of weld joint 001 located on OBE1.

Welder is identified as Mr. Zang Yanbo (045196). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and repair procedure B-WR7170.

FCAW welding of weld joint 003 located on OBE1A.

Welder is identified as Mr. Bi Laishu (045280). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G (1F)-FCM-Repair-1 and repair procedure B-WR7127.

SMAW welding of weld joint 001 located on OBE1.

Welder is identified as Mr. Tian Zhaoquan (045246). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-4G (4F)-FCM-Repair-1 and repair procedure B-WR7170.

5BE & 5CE

FCAW welding of weld splice joint 009 located on OBE9A.

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.

FCAW welding of weld splice joint 009 located on OBE9A.

Welder is identified as Mr. Zhao Pan (220065). ZPMC QC is identified as Li Jia.

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

1BE

SMAW welding of weld splice joint 009 located on OBE9A.

Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114-FCM-1.

5BW

SMAW welding of weld joint 036 located on SEG023.

Welder is identified as Mr. Du Hengyou (037743). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114-Tc-U4b-FCM.

SMAW welding of weld joint 032 located on SEG023A.

Welder is identified as Mr. Bi Shijian (068764). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and repair procedure B-WR6871.

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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5BW

SMAW welding of weld joint 005 located on SEG025A.

Welder is identified as Mr. Bi Shijian (068764). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and repair procedure B-WR6871.

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.

### 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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