

**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-008950**Date Inspected:** 02-Sep-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 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 1AAE and 1AE. The weld designations reviewed are as follows:

## 1AAE

1. SEG2F-001-015
2. SEG2E-920, 960, 922, 925, 930, 971
3. SEG-001-931, 972, 935, 976, 980, 939, 983

## 1AE

4. EP181-01-009
5. SP406-046, 047, 050, 051
6. SP407-041, 042, 050, 051
8. SP408-042
9. SEG004B-005

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

- 10. BP312-001-006
- 11. BP310-001-010, 009
- 12. BP314-001-001, 002, 005, 006

1AE

FCAW welding of weld joint 003 located on SSD34-PP8.5.

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

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-FCM and repair procedure CWR700.

FCAW welding of weld joint 003 located on SSD34-PP8.5.

Welder is identified as Mr. Ji Hongwei (058245). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-FCM and repair procedure CWR700.

1AE

During random verification Magnetic Particle Testing (MT) for inspection Notification Sheet No. 004127 dated 9-02-2009. This QA Inspector observed one transverse indication, measuring approximately 10mm in length respectively. Weld number is noted to be SEG002A-007 (bottom plate to side plate weld joint) located at 1AAE+1AE weld splice on the bike path side of segment. This QA Inspector issued an incident report on the above noted MT rejection.

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.

---

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

---