

**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-008973**Date Inspected:** 25-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 MT of approximately 15% of items on Punch list. This QA Inspector generated an MT report for this date. The item (s) is/are identified as OBG 2AE, CB1, 4BW and 3BE. The weld designations reviewed are as follows:

**2AE**

1. Side plate bevel end at panel point 13. (4 locations) Punch List Item #1530

**CB1**

1. Deck panel bevel stiffener end at panel point 13. (3 locations) Punch List Item #1532

**4BW**

1. FL3 25A to bottom plate. (2 locations) Punch List Item #1480

**3BE**

1. Diaphragm to Floor beam at panel point 23. (Various locations)

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## 1AAE & 1AE

FCAW welding (UT repair) of weld joint 001 located on OBE1.

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-345-SMAW-1G (1F)-FCM-Repair and repair procedure WR7170.

## 1AE & 1BE

SMAW welding (UT repair) of weld joint 005 located on OBE1A.

Welder is identified as Mr. Yun Chengxian (045138). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-Repair-1 and repair procedure B-WR7171.

## 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.

## 1AAE & 1AE

This QA Inspector performed Magnetic Particle Testing (MT) and observed 1 transverse linear indication on CJP weld OBE1-001 (UT reject excavation area) accepted by ZPMC. Location is approximately 3150mm off bike path side. 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.

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# WELDING INSPECTION REPORT

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