

**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-009594**Date Inspected:** 14-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**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 sub assemblies**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall 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 BAY 5**

This QA observed ZPMC qualified welding personnel identified as 204342 perform FCAW welding on bike path cantilever bracket weld joint identified as BK001-041-008. ZPMC QC identified as Mr. Wang Liang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-Tc-U4c-F.

This QA observed ZPMC qualified welding personnel identified as 205390 perform FCAW welding on bike path cantilever bracket weld joint identified as BK001-040-008. ZPMC QC identified as Mr. Wang Liang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-Tc-U4c-F.

This QA observed ZPMC qualified welding personnel identified as 068858 perform FCAW welding on traveler rail weld joint identified as 10TR3-012-013. ZPMC QC identified as Mr. Zhong Chong Biao was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U5-F.

This QA observed ZPMC qualified welding personnel identified as 204342 perform FCAW welding the root of crossbeam CB16 weld joint identified as CB202B-016-002. ZPMC QC identified as Mr. Zheng Zhi Wei was

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present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-U2-F.

## OBG BAY 6

This QA observed ZPMC qualified welding personnel identified as 053609 perform FCAW welding temporary lifting lug on the bottom corner of crossbeam CB9. ZPMC QC identified as Mr. Zhuo Jie was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA received ZPMC Non Destructive Testing (NDT) notification No. 004397 and performed Magnetic particle Testing (MT) of approximately 15% of the welds previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated a MT report for this date. The weld designations are as follows: SP3003-001-054~065, EP3005-001-001~004, EP3011-001-001~004, BP3011-001-001~008, 017~052, 059~062, 065~068, 072 and 073, BP3028-001-001~008 and 017~055.

This QA reviewed and signed ABF green tags for the above mentioned welds. The green tag numbers are as follows: 010629, 010630, 010631, 010632 and 010633.

## OBG BAY 7

No significant work was observed in this bay during the time QA was present.

## OBG BAY 8

No significant work was observed in this bay during the time QA was present.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



### Summary of Conversations:

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

### Comments

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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 (15000422372), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hall, Steven	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson, Rodney	QA Reviewer

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