

**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-009762**Date Inspected:** 12-Oct-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:** Xu Yumin and 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

5BW + 5AW

SMAW repair welding of weld joint 002 located on OBW5A.

Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and repair procedure WR8043. Y location (taken from bottom plate) for noted repairs are as followed:

2940~3050mm (2 indications) 3180~3290mm (2 indications)

SMAW repair welding of weld joint 002 located on OBW5A.

Welder is identified as Mr. Zhang Feng (049769). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and repair procedure WR8043. Y location (taken from bottom plate) for noted repairs are as followed:

5320~5420mm (2 indications) 5630~5750mm (2 indications)

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5CE

SMAW repair welding of weld joint 011 located on at panel point 32 (cross beam side of segment). Welder is identified as Mr. Chen Zhenghua (220067). ZPMC QC is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G (2F)-Repair and repair procedure WR8063.

5BE

SMAW welding of weld joint 011 located on LD15E at panel point 32 (cross beam side of segment). Welder is identified as Mr. Li Guimin (220069). ZPMC QC is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4c-F and repair procedure WR8106.

5BE + 5AE

SMAW welding of weld joint 003 located on OBE5. Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair and repair procedure WR8035. Y location (taken from cross beam side) for noted repairs are as followed: 6860mm (1 indication), 8160mm (1 indication), 12570mm (1 indication), 14200mm (1 indication) and 25050 (1 indication)

NDT Observation

This QA Inspector observed ZPMC Magnetic Particle (MT) Technician performing MT on various locations in the trial assembly yard. Locations are as followed:

1. Horizontal deck plate stiffeners on the bike path side of segment 1E (in progress). Welds numbers are as followed:  
OBE1-023~034, 071~082, 083~106

Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions in the trial assembly yard. Locations and description of work are as followed:

1. Grit blasting of various internal areas in segment 2W and 2E.  
2. Removed segment 1W from trail assembly line up to behind tower shop 11.  
Segment was move with excavation on weld joint OBW1A-007 (exterior) not filled with weldment.

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

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**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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