

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-009940**Date Inspected:** 23-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:

**1AAW & 1AW**

This QA Inspector performed Ultra Sonic (UT) inspection (partial) of weld joint OBW1A-004 (side plate) on cross beam side of segment 1W, utilizing scanning pattern D to detect transverse indication reflectors. Noted UT inspection was performed in conjunction with ABF UT Department. This QA Inspector did not complete the full length of the above noted weld due to weld repair area performed weld repair work in progress and rough surface condition. Y Locations are as followed for description of rework per weld joint.

OBW1A-004: Y location 980~2770 (weld repair in progress).

See Caltrans's Ultrasonic Transverse Indication Evaluation report sheet dated 10-23-09 for future information on inspection performed on this work day.

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# WELDING INSPECTION REPORT

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2AE & 2BE

SMAW repair welding on excavation on weld joint 004 located on OBE2A.

Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1 and CWR repair procedure #859.

Y Location of excavation by above noted welder (054467) is located at approximately 7182mm and is 170mm in length. Y Location was measured off the side and bottom plate weld joint on bike path side of segment.

SMAW repair welding on excavation on weld joint 004 located on OBE2A.

Welder is identified as Mr. Zhang Feng (049769). ZPMC QC is identified as Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1 and CWR repair procedure #859.

SMAW repair welding on excavation on weld joint 004 located on OBE2A.

Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1 and CWR repair procedure #859.

Y Location of excavation by above noted welders (048659 & 049769) is located at approximately 3460mm and is 3500mm in length. Y Location was measured off the side and bottom plate weld joint on bike path side of segment.

1AW

SMAW welding performed on drip plate weld joints 068, 069, 089 and 090 located on OBW1B.

Welder is identified as Mr. Li Bo (050433). ZPMC QC is identified as Xu Yumin.

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

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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