

**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-009944**Date Inspected:** 31-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin and Wu Zhi Cheng**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:

Trail Assembly Yard

5BE

SMAW welding on weld joint 005 located at CA020 edge plate to side plate located on bike path side.

Welder is identified as Mr. Qie Jianzhou (067571). ZPMC QC is identified as Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

5BC

SMAW welding on weld joint 005 located at CA024 edge plate to side plate located on bike path side.

Welder is identified as Mr. Qie Jianzhou (067571). ZPMC QC is identified as Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

NDT Observation

QA Inspector observed ABF's personnel performing MT inspection on repair areas. Locations and description of

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# WELDING INSPECTION REPORT

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work are as followed:

1AW+1BW

Excavation (5 areas) areas at OBW1A-009 side plate (external) weld joint on segment 1W.

Y locations of MT Indications observed are as followed:

1. Y Location 5730mm, ABF observed a 60mm transverse crack on 1AW side of weld splice.
2. Y Location 5930mm, ABF observed a 5~6mm transverse crack on 1AW side of weld splice.

This QA Inspector performed MT at same areas ABF inspected, accepted and observed one (1) MT l transverse indication at Y Location 6570 (approximately 5~6mm in length).

Miscellaneous Work In Progress

1AW+1BW

1. Excavation areas at OBW1A-004 side plate (external) weld joint on segment 1E. Y locations of excavations and numbers of MT Indications observed are as followed:

Y locations 8185mm and length of excavation is approximately 120mm.

This QA Inspector performed MT in excavation area and observed one (1) MT longitudinal indication observed (approximately 12mm in length).

2. Observed ABF representatives Peter Ferguson, Steven Lawton and Kevin Chen measuring sample to be removed o weld joint OBW1A-008. Y location is between 3665~3965mm. Length of cut sample is 300mm by 25mm and will be sent for the required testing.

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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