

**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-010543**Date Inspected:** 08-Dec-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:** Li Yang**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

6BE+6CE

FCAW welding on weld joint 005 located at OBE6C bike path side of segment.

Welder is identified as Mr. Zhou Bin (067947). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233T.

FCAW welding on weld joint 005 and 006 located at OBE6C bike path side of segment.

Welder is identified as Mr. Zhang Hanming (220066). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233T.

6AW+6BW

SAW repair welding on weld joint 003 located at OBW6 deck plate weld splice.

Welder is identified as Mr. Wu (049804). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-223(2)1T-2.

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FCAW welding on weld joint 002 located at OBW6B side plate stiffeners on counter weight side of segment. Welder is identified as Mr. Li Shoufu (066674). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233T.

FCAW welding on weld joints 004 and 005 located at OBW6B on cross beam side of segment. Welder is identified as Mr. Chen Zhenghua (220067). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233T.

5BE+5CE

SMAW repair welding on weld joint 010 located at OBE5A side plate on bike path side of segment. Welder is identified as Mr. Han Xiao Feng (054467). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and WR repair procedure #8818.

Y Locations of excavations by above noted welder (054467) are located at 100mm, 500mm, 1700mm and 2300mm.

BK001-018

SMAW repair welding on weld joint 005 located at BK001-018 cantilever member. Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-Repair-1.

Y Location of excavation by above noted welder (048659) is located at 400mm.

SMAW repair welding on weld joint 006 located at BK001-018 cantilever member. Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-Repair-1.

Y Locations of excavations by above noted welder (048659) are located at 100mm and 30mm.

NDT Observation

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

6AW+6BW

1. Segment splice weld OBW6-003 on deck plate. 4 longitudinal linear indications were observed at the time of observation.

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

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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>  | Miller,Mark | QA Reviewer                 |

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