

**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-010585**Date Inspected:** 09-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

This QA Inspector performed MT of area previously tested and accepted by Quality Control on OBG 5AW. MT was performed on Diaphragms on Panel Points (PP) 32~34 (Floor Beam flange to Floor Beam web repaired areas). The QA Inspector generated a TL-6028 MT report on this date. Weld MT verified was identified as listed below

5AW

1. FB003-042-005
2. FB039-001-093
3. FB003-030,
4. FB011-008-003, 004
5. FB027-002-092, 093

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### 3AW

SMAW repair welding on weld joint 031 located at SEG013A counter weight side of segment. 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-4G (4F) and CWR # 903.

Y Location of excavation by above noted welder (048659) is located at 690mm.

### 3BW

SMAW repair welding on weld joint 007 located at SEG015A counter weight side of segment. Welder is identified as Mr. Han Xiao Feng (054467). ZPMC QC is identified as Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F) and CWR # 903.

Y Location of excavation by above noted welder (048659) is located at 80mm.

### 4AW

SMAW repair welding on weld joint 007 located at SEG017A counter weight side of segment. Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233T.

Y Location of excavation by above noted welder (054467) is located approximately between 850~920mm.

### 6BE+6CE

FCAW repair welding on weld joints 052, 050 and 048 located at SP363-001 side plate stiffeners on cross beam side. Welder is identified as Mr. Chang Hanming (220066). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T\_2233-B-U2-F.

### 6AE+6BE

FCAW welding on weld joint 016 located at EP54 edge plate stiffener on bike path side of segment. Welder is identified as Mr. Li Guimin (220069). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2234-B-U2-F.

### NDT Observation

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

### 6AW+6BW

1. Excavation area on weld joint SEG017A-007 located on counter weight of segment 4AW counter weight side.

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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>  | Miller,Mark | QA Reviewer                 |

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