

**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-010594**Date Inspected:** 16-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xian Ping**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 Sub-Assembly**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Stefan Holmes was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #010 located on Traveler Rail 10TR3-023. Welder is identified as 215078. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply

with the WPS – B – T – 2232 – Tc – U5 – F.

Flux Cored Arc Welding (FCAW) process welding of weld joint #010 located on Traveler Rail 11TR1-022.

Welder is identified

as 215185. ZPMC Quality Control(QC) is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply

with the WPS – B – T – 2232 – Tc – U5 – F.

FCAW process welding of weld joint #005 located on Traveler Rail 10TR3-011. Welder is identified

as 215250. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply

with the WPS – B – T – 2232 – Tc – U5 – F.

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

SMAW process welding of weld joint #002A located on Tower Strut WD1-A305-53M-1. Welder is identified as 048659. ZPMC QC is identified as Zhang Bao Bo. The welding variables recorded by QC appeared to comply with the WPS – 485 - SMAW - 2G(2F) - FCM - Repair - 1.

Shielded Metal Arc Welding (SMAW) process welding of weld joint #002B located on Tower Strut WD1-A305-53M-1. Welder is identified as 048617. ZPMC QC is identified as Zhang Bao Bo. The welding variables recorded by QC appeared to comply with the WPS – 485 - SMAW - 2G(2F) - FCM - Repair - 1.

### Ultrasonic Testing (UT)

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

#### Traveller Rail

1. 10TR1-006-001
2. 10TR1-017-001
3. 10TR1-018-001
4. 10TR1-019-001
5. 10TR1-023-001
6. 10TR1-024-001
7. 10TR1-025-001
8. 10TR1-026-002
9. 10TR1-027-002
10. 10TR1-028-001
11. 10TR1-029-001
12. 11TR7-002-001
13. 11TR3-016-002
14. 11TR3-019-002
15. 11TR3-020-002
16. 11TR3-021-002
17. 11TR3-022-002
18. 11TR3-023-002
19. 11TR3-025-002
20. 11TR3-005-002
21. 11TR3-014-001
22. 11TR3-015-002
23. 11TR3-017-001
24. 11TR1-001-003

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

### Summary of Conversations:

No relevant conversations.

---

---

# WELDING INSPECTION REPORT

( *Continued Page 3 of 3* )

---

---

## 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 , who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Holmes,Stefan	Quality Assurance Inspector
<b>Reviewed By:</b>	Hall,Steven	QA Reviewer

---