

**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-010636**Date Inspected:** 10-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

6AE+6BE

SMAW welding on weld joint 23 located at DP635 on cross beam side of segment. 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-B-T-3213-B-U3b.

6CE+6BE

SMAW welding on weld joint 34 located at SP427-001 on the 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-2233-B-U2F.

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## 6AW+6BW

FCAW welding on weld joint 004 located at OBW6B on counter weight side of segment. Welder is identified as Mr. Zhou Pan (220063). 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 001 and 002 located at OBW6B on counter weight 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.

## 5CW+5BW

FCAW repair welding on weld joint 013 located at OBW5A. 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-345-SMAW-1G (1F)-FCM-Repair-1 and WR8834 procedure.

Y Location of excavation by above noted welder (054467) are located at 10mm, 3950mm, 4800mm, 5000mm, 5500mm, 5590mm and 8455mm.

## 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. LD15A buttered end (build up of edge) at panel point 44 on cross beam side of segment.

## 5CW+6AW

This QA Inspector observed ZPMC personnel deviating from approved heat straightening HSR (B)-388 and applying heat on wet surface. Locating of heat straightening performed is at panel point 37 counter weight side of segment 5CW+6AW. This QA Inspector issued an incident report on the above noted issue.

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
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<b>Reviewed By:</b>	Miller, Mark	QA Reviewer
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