

**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-010653**Date Inspected:** 12-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**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

5CW+5BW

SMAW repair welding on weld joint 008 located at OB5W on deck plate.

Welder is identified as Mr. Feng Changdou (067572). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F) and WR # 8818.

6BW+6AW

FCAW welding on weld joints 28, 30 and 32 located at OBW6 cross beam 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-2233-B-U2-F.

FCAW welding on weld joints 21, 23 and 25 located at SP094-001 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-2233-B-U2-F.

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6AW+6BW

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

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.

6CE

FCAW welding on weld joints 037 and 038 located at SP309-001 on 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-2131.

NDT Observation

This QA Inspector observed ABF/ZPMC Ultra Sonic Testing (UT) Technician performing UT on various locations in the trial assembly yard.

4AE

1. BP to SP weld joint SEG017A-007 on bike path side of segment. (ABF)

2AE

1. Deck plate missdrilled hole repair area on DP582A at cross beam side of segment. (ZPMC)

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

2AE

1. Deck plate missdrilled hole repair area on DP582A at cross beam side of segment. (ZPMC)

2AE

During a random visual inspection of an Mislocated Drilled Hole Repair (MDHR) located on the Deck Panel of segment 2AE Cross Beam side PP14.5, the Caltrans Quality Assurance (QA) inspector observed that ZPMC did not follow the approved welding procedure specification (WPS) # WPS-345-SMAW-1G (1F)-Repair-Misdrilled hole resulting to Ultrasonic Testing reject. This QA inspector issued an incident report for this day.

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.

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## 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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