

**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-010859**Date Inspected:** 23-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/ Wu Zhi Cheng**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

6CE

SMAW welding on weld joint 28 located at SEG032B on bike path 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-2234-Tc-U4b-FCM.

5BE

SMAW repair welding on weld joints 006 and 024 located at SEG024B longitudinal diaphragm on bike path 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-2G (2F)-Repair-1.

SMAW repair welding on weld joint 031 located at SEG024C longitudinal diaphragm on bike path 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-345-SMAW-2G (2F)-Repair-1.

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6BE

SMAW repair welding on X37 member weld joints 027, 028, 029 and 030 located at SEG028H between panel point 27&26 on the bike path side of segment. Welder is identified as Mr. Wu Haijun (201087). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-345+485-SMAW-3G (3F)-Repair and WR8987.

FCAW welding on weld joint 002 located at CA028 on bike path 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-2234-Tc-U4b-FCM.

5CW

SMAW welding on weld joint 001 located at CA022\* on cross beam side of segment. Welder is identified as Mr. Lv Peng (048617). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2214-Tc-U4b-FCM-1.

NDT Observation

QA Inspector observed ZPMC's personnel performing Ultra Sonic (UT) inspection on repair areas. Locations and description of work are as followed:

5AW

1. Weld joints FB017-001-128, FB021-001-128 and FB025-001-128 between panel point 32&33.

Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions in the trial assembly yard. Locations and description of work are as followed:

6CE+6BE

1. Heat straightening in progress of edge plate stiffeners on EP55A-001-009~012, EP56A-001-007~010 and QBE6A-001-005 between panel points 43 and 44 per HSR1 (B)-6725.

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

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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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