

**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-010871**Date Inspected:** 30-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

6BE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 005 located at CA028 on bike path side of segment. Welder is identified as Mr. Li Wenguo (066261). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

6CE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 005 located at CA030 on bike path side of segment. Welder is identified as Mr. Du Hang You (037743). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2214-Tc-U4b-FCM-1.

5CE+5BE

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Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 008 located at OBE5 on deck plate of segment. Welder is identified as Mr. Han Xiao Feng (054467). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-Repair-1 and repair procedure WR9313.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 009 located at OBE5 on deck plate of segment. Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-Repair-1 and repair procedure WR9320.

Y location of noted repair worked performed by noted welder (04659) is at 840mm.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at OBE5A on edge plate bike path of segment. Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-3G (3F)-Repair-1 and repair procedure WR9320.

5CE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 002 located at CA024 on bike path of segment. Welder is identified as Mr. Li Wenguo (066261). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

5BE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 005 located at SEG024A on deck plate of segment. Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-Repair-1.

BK001-024

Flux Core Arc Welding (FCAW) welding was performed on weld joint 009 located at BK001 on Cantilever member. Welder is identified as Mr. Zhou Pan (220063). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

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

6CW

1. Observed weld splice OBE6B-003 and OBE6B-005 being cut with mechanical guided track torch due to

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misalignment issue present. Work was performed per WR9159.

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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