

**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-011263**Date Inspected:** 07-Jan-2010**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

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as 5AE+5BE hold back welds on the bottom, edge, deck and side plate (cross beam side). The weld designations reviewed are as follows:

5AE

1. EP047-001-013, 014
2. DP629-001-13, 14
3. SP419-001-26, 27, 34, 35
4. SP521-001-51, 52, 63, 64
5. SP561-001-43, 44, 53, 54
6. SP601-001-43, 44, 53, 54
7. BP164-001-43, 44, 53, 54
8. BP110-001-43, 44, 53, 54
9. BP56-001-43, 44, 53, 54

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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## 10. SEG22B-30

### 5BE

1. SP522-001-15, 16, 27, 28
2. SP562-001-11, 12, 21, 22
3. SP602-001-1, 2, 11, 12
4. BP165-001-32, 34, 41, 42
5. BP111-001-31, 32, 41, 42
6. BP57-001-31, 32, 41, 42
7. SEG22C-30
8. SEG24C-30

### 6CE

Shield Metal Arc Welding (SMAW) welding was performed on weld joints 056 and 057 located at SP529-001 on cross beam side of segment. Welder is identified as Mr. Liu Shouhai (066456). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2112-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joints 034 and 033 located at SP428-001 on bike path side of segment. Welder is identified as Mr. Wu Zeqiang (066481). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2112-FCM-1.

### 7AE

Shield Metal Arc Welding (SMAW) welding was performed on weld joints 001 and 002 located at SP610-001 on cross beam side of segment. Welder is identified as Mr. Liu Shouhai (066456). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2112-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joints 021 and 022 located at SP530-001 on cross beam side of segment. Welder is identified as Mr. Liu Shouhai (066456). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2112-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joints 013, 014, 015 and 016 located at SP449-001 on bike path side of segment. Welder is identified as Mr. Wu Zeqiang (066481). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2112-FCM-1.

### 5CE

Shield Metal Arc Welding (SMAW) repair (VT rejects) welding was performed on side and bottom plate t stiffeners on the bike path side of segment. Welder is identified as Mr. Zhang Feng (049769). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F) Repair-1.

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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6BE

During random in-process visual inspection at Segments 6BE+6CE edge plate on bike path side of segment, temporary attachment removal areas, this QA Inspector observed base metal repairs without prior approval of the Engineer. This QA Inspector issued an incident report for 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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