

**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-011562**Date Inspected:** 23-Jan-2010**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**

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 5BE punch list item 228. The weld designations reviewed are as follows:

**5BE**

1. Suspender bracket (SB032E) Flange (X53B) to deck plate on bike path side of segment.

**6BW**

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA027 counter weight side of segment. Welder is identified as Mr. Zhou Bing (067764). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR 1057 repair procedure.

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Y Location of repairs areas by above noted welder (067764) is located at 4500mm.

6CW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA030 bike path side of segment. Welder is identified as Mr. Sun Lingling (067764). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR 1139 repair procedure.

Y Location of repairs areas by above noted welder (067764) is located between 4675mm~4770mm.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA030 bike path side of segment. Welder is identified as Mr. Yang Yunfeng (215553). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR 1139 repair procedure.

Y Location of repairs areas by above noted welder (215553) is located between 12725mm~12950mm.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA030 bike path side of segment. Welder is identified as Mr. Chen Renzhi (058087). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR 1139 repair procedure.

Y Location of repairs areas by above noted welder (058087) is located between 15310mm~15715mm.

Flux Core Arc Welding (FCAW) welding was performed on weld joints 051 and 050 located at SP150-001 cross beam side of segment. Welder is identified as Mr. Zhou Songsong (068091). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-3132.

7BW

Flux Core Arc Welding (FCAW) welding was performed on weld joints 045 and 046 located at BP117 001 cross beam side of segment. Welder is identified as Mr. Chen Zhenghua (220067). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2133.

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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