

**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-011754**Date Inspected:** 29-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

7BE+7CE

Submerged Arc Welding (SAW) welding on weld joint 008 located at OBE7 deck plate weld seam.

Welder is identified as Mrs. Mu Jingfen (054458). ZPMC QC is identified as Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with WPS-B-T-223(2)1T-2.

Submerged Arc Welding (SAW) welding on weld joint 008 located at OBE7 deck plate weld seam.

Welder is identified as Mrs. Cai Hong (053748). ZPMC QC is identified as Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with WPS-B-T-223(2)1T-2.

7AW

Flux Core Arc Welding (FCAW) repair welding was performed on weld joint 007 located at SEG033A on cross beam side of segment. Welder is identified as Mr. Zheng Yi (067949). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G

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(1F)-FCM-Repair-1 and WR 10059 repair procedure.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 005 located at CA032 on cross beam side of segment. Welder is identified as Mr. Li Guangzu (069493). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G

(1F)-FCM-Repair-1 and WR 10059 repair procedure.

5CE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 008 located at SEG026A on bike path side of segment. Welder is identified as Mr. Li Wenguo (066261). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G

(1F)-Repair-1 and WR 10609 repair procedure.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 008 located at SEG026A on bike path side of segment. Welder is identified as Mr. Li Yongshui (067656). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G

(1F)-Repair-1 and WR 10609 repair procedure.

5BW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 074 located at SEG023E on cross beam side of segment. Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G

(1F)-Repair-1 and WR 9494 repair procedure.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 168 located at SSD22-PP32.5 on cross beam side of segment. Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G

(1F)-Repair-1 and WR 9494 repair procedure.

5BE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 035 located at SEG024\* on cross beam side of segment. Welder is identified as Mr. Dai Lu (048659). 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 and CWR 1088 repair procedure.

Y Location of repair by above noted welder (048659) is located at 14785mm.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

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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 (150-0042-2372), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Alaniz,Joe	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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