

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-012299**Date Inspected:** 23-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan**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:** Trial Assembly**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Christopher D'souza was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

Trial Assembly

QA Inspector observed ABF Inspectors performing Ultrasonic Testing (UT) on CB 7 DP to SP welds; UT was being performed for detection of planar transverse indication. Weld numbers are listed below:-

CB202A-007-001, 002, 003

CB202A-007-013, 014, 015

7AW-7BW Transverse Splice

This QA Inspector observed ZPMC welding personnel's performing Shielded Metal Arc welding (SMAW) on OBW7B-004 (7AW+7BW Transverse Splice Side Plate CB side). Welder is identified as 037996, 067752. ZPMC QC is identified as Zhang Hai Tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1

This QA Inspector observed ZPMC welding personnel's performing Shielded Metal Arc welding (SMAW) on

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## WELDING INSPECTION REPORT

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OBW7B-002 (7AW+7BW Transverse Splice Side Plate CW side), Welder is identified as 068917. ZPMC QC is identified as Zhang Hai Tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1

### 7AE-7BE Transverse Splice

This QA Inspector observed ZPMC welding personnel's performing Shielded Metal Arc welding (SMAW) on OBE7B-003 (7AE+7BE Transverse Splice Bottom Plate), Welder is identified as 067183. ZPMC QC is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1

### 5AW Side Plate to Corner Assembly Weld

This QA Inspector observed ZPMC welding personnel's performing Shielded Metal Arc welding (SMAW) on SEG021A-001 (Y- location 1900mm), Welder is identified as 069683. ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G(4F)-Ug-Repair 1.

### 5CE Side Plate to Corner Assembly Weld

This QA Inspector observed ZPMC welding personnel's performing Shielded Metal Arc welding (SMAW) on SEG026A-009 (Y- location 5570mm), Welder is identified as 044779. ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair 1.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### 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 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Dsouza,Christopher	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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