

**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-015440**Date Inspected:** 02-Jul-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

<b>CWI Name:</b>	Chen Shi Gang, Yang Bai Qiang			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	OBG		

**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad 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:

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 9

**DECK PANEL 13CE-DP3104-001**

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3104-001 in process on gantry # 2. ZPMC Quality Control (QC) is identified as Mr. Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used. The weld number and welder for respected weld are as follows.

Weld Joint # 001, 011, 021; Welder # 059378

Weld Joint # 002, 012, 022; Welder # 203805

Weld Joint # 003, 013, 023, 005, 015, 025; Welder # 201788

Weld Joint # 004, 014, 024, 006, 016, 026; Welder # 059416

Weld Joint # 007, 017, 027; Welder # 059421

Weld Joint # 008, 018, 028; Welder # 059418

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## WELDING INSPECTION REPORT

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### DECK PANEL 13CE-DP3102-001

Gas Metal Arc Welding (GMAW) of DP3102-001 in process on gantry # 2. ZPMC Quality Control (QC) is identified as Mr. Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used. The weld number and welder for respected weld are as follows.

Weld Joint # 001, 011, 021, 003, 013, 023; Welder # 059418

Weld Joint # 002, 012, 022, 004, 014, 024; Welder # 059421

Weld Joint # 005, 015, 025, 007, 017, 027; Welder # 059416

Weld Joint # 006, 016, 026, 008, 018, 028; Welder # 201788

### 13CE-DP3099-001

Gas Metal Arc Welding (GMAW) tack welding of U-rib to deck plate of DP3099-001 were in process. The welder is identified as 059472. ZPMC Quality Control (QC) is identified as Mr. Chen Shi Gang. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U5(U-rib). Welding appears to conform to the requirements of the WPS used.

### 13CE-DP3106-001

Gas Metal Arc Welding (GMAW) tack welding of U-rib to deck plate of DP3106-001 were in process. The welder is identified as 062305. ZPMC Quality Control (QC) is identified as Mr. Chen Shi Gang. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U5(U-rib). Welding appears to conform to the requirements of the WPS used.

### BAY 04

### 13AW-DP3119-001

During random in process inspection this QA inspector observed that ZPMC personnel were performing repair welding on the Partial Joint Penetration (PJP) weld joints of deck panel 13AW-DP3119-001. Welders are identified as 062750 & 068916. ZPMC CWI is identified as Mr. Yang Bai Qiang. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-FCM-Repair. The repair area details are as follows.

Weld: 008; Y location: 12150

Weld: 006; Y location: 10550, 11050, 11650, 12150

Weld: 004; Y location: 11050, 10550

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

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# WELDING INSPECTION REPORT

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

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**Inspected By:** Gaikwad,Umesh

Quality Assurance Inspector

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**Reviewed By:** Carreon,Albert

QA Reviewer