

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-011717**Date Inspected:** 26-Jan-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:** Mr. 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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

**OBG TRIAL ASSEMBLY**

This QA Inspector observed the following work in progress:

**SEGMENT- 7BE-7CE**

Flux Cored Arc Welding (FCAW) welding of weld joint SP365-001-052. Welder is identified as 068596. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: B-T-2233-U2-F.

Flux Cored Arc Welding (FCAW) welding of weld joint SP612-001-011. Welder is identified as 053742. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: B-T-2233-U2-F.

**SEGMENT-CB4**

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint CB201A-004-004. Welder is

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## WELDING INSPECTION REPORT

( Continued Page 2 of 5 )

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Identified as 066179. ZPMC Quality Control (QC) is identified as Mr.Zhang Xiao Ming. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G (2F)-FCM-Repair-1 and Critical Welding Repair Report (CWR) is: B-CWR1090.

The following Non Destructive Testing (NDT) Inspection carried out on Crossbeam CB4.

Visual Inspection (VT)

This QA Inspector performed random VT of CB4 (south side)

During Quality Assurance VT review of welds located on Cross Beam CB4, this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) Transverse Linear indication on base material measuring approximately 08 mm in length.
- The nearest weld to the indication is identified as: DP203-004-o41.
- The weld is a fillet weld joining deck plate to stiffener plate.
  
- One (1) Rounded indication on weld measuring approximately 3.0 mm dia.
- The weld is identified as: SP201-004-027.
- The weld is a fillet weld joining deck plate to stiffener plate.
  
- One (1) Transverse Linear indication on base material measuring approximately 10 mm in length.
- The nearest weld to the indication is identified as: FB201-004-036.
- The weld is a fillet weld joining deck plate to stiffener plate.
  
- One (1) Transverse Linear indication on base material measuring approximately 15 mm in length.
- The nearest weld to the indication is identified as: FB201-004-040.
- The weld is a fillet weld joining deck plate to stiffener plate.
  
- One (1) Transverse Linear indication on base material measuring approximately 15 mm in length.
- The nearest weld to the indication is identified as: FB201-004-042.
- The weld is a fillet weld joining deck plate to stiffener plate.
  
- CB4 is located near the OBG TRIAL ASSEMBLY AREA

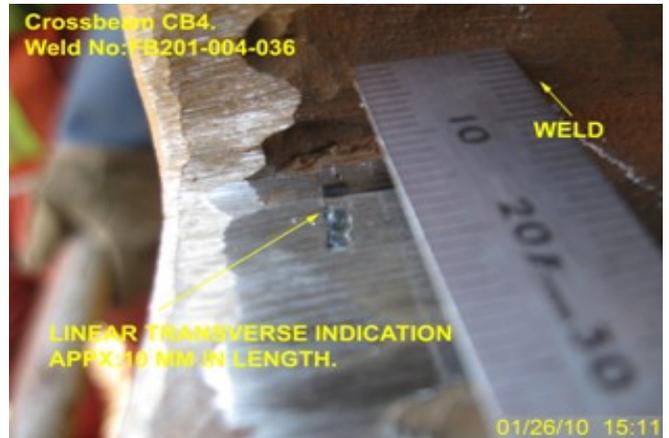
The attached photographs provide additional detail.

This QA notified ZPMC QC identified as Mr.Wang Li Yang and ABF inspector identified as Mr. Ding and Mr. Zhuhu of the above issue, and reported to the Team leader for further action.

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

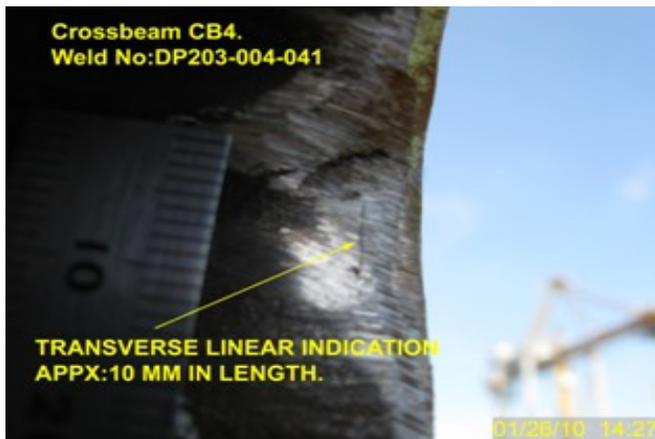
# WELDING INSPECTION REPORT

( Continued Page 3 of 5 )



# WELDING INSPECTION REPORT

( Continued Page 4 of 5 )



## Summary of Conversations:

Only general conversation was held between QA and Quality Control (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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# WELDING INSPECTION REPORT

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

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