

**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-012081**Date Inspected:** 15-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:** 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: 6BW-6CW**

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint OBW6A-005. Welder is identified as 037743. ZPMC Quality Control (QC) is identified as Mr. Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-3G (3F)-FCM-Repair-1 and Critical Welding Repair Report (CWR) No: B-CWR1209.

**SEGMENT: 6CW**

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG031D-039. Welder is identified as 066261. ZPMC Quality Control (QC) is identified as Mr. Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2214-TC-U4b-FCM-1.

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# WELDING INSPECTION REPORT

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**SEGMENT: 7BW-7CW**

Flux Cored Arc Welding (FCAW) welding of weld joint SP757-001-03. Welder is identified as 066673. ZPMC Quality Control (QC) is identified as Mr. He Yanbing. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2233T.

Flux Cored Arc Welding (FCAW) welding of weld joint SP520-001-46. Welder is identified as 066746. ZPMC Quality Control (QC) is identified as Mr. He Yanbing. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2233T.

**SEGMENT: 5AW**

This QA Inspector observed ZPMC personnel performing Heat Straightening on weld joint no: SEG021A. The weld is connecting to Side plate (SP91A) and Side plate (SP409A) plate thickness is 18 mm. Against Caltrans Engineer approved document No: HSR (B)-348.Rev 0. ZPMC Quality Control (QC) is identified as Mr. Wang Xu.

**SEGMENT: 6BE**

This QA Inspector observed ZPMC personnel at Segment 6BE Panel Point #43.5 Corner Assembly Cross back to back angle truss bolts Tightening is in progress.

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

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