

**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-013514**Date Inspected:** 30-Apr-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:** Chen Xi.**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) Shailesh Wadkar 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:

Bay 1: CB15:

This QA Inspector observed that no significant work was being performed on this CB at the time when this QA was present.

Bay 8: CB17:

This QA Inspector observed that no significant work was being performed on this CB at the time when this QA was present.

Outside Yard:

CB11, CB12, CB13 &amp; CB16:

This QA Inspector observed that no significant work was being performed on the above mentioned CB's at the time when this QA was present.

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CB10:

Notification No: 005639.

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG component – Cross Beam 10. The weld designations reviewed are as follows:

1) CB202A-010-011.

Notification No: 005583.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT reports for this date. The members are identified as OBG Component – Cross Beam 10. The weld designations reviewed are as follows:

1) CB202G-025-001/002, 003/004, 051/052, 057/058 & 059/060.

2) CB202G-026-001/002, 003/004, 047/048, 049/050 & 051/052.

3) CB202G-027-001/002, 003/004, 057/058, 059/060 & 051/052.

4) CB202G-028-001/002, 003/004, 057/058, 059/060 & 051/052.

Above mentioned joints are welded as CJP welds as the root gap was in excess of 5mm (Refer WRR: B-WR11454 Rev: 0).

CB14:

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) of weld joints CB202A-014-005 & 017. Welders are identified as 044824 & 050977. ZPMC Quality Control (QC) is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4b-F.

FCAW of weld joint CB202A-014-003. Welder is identified as 050977. ZPMC Quality Control (QC) is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-B-U2-F.

Trial Assembly:

CB 7:

This QA Inspector observed the following work in progress:

FCAW of weld joints CB201A-007-006 & 018. Welder is identified as 066746. ZPMC Quality Control (QC) is identified as Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4b-F.

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FCAW of weld joints FB202-007-007 to 012 & 013 to 018. Welders are identified as 022063 & 022069. ZPMC Quality Control (QC) is identified as Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2132 & WPS-B-T-2134.

CB 8:

This QA Inspector observed the following work in progress:

FCAW of weld joints FB201-008-024, 026, 028, 030, 032 & 034. Welder is identified as 069895. ZPMC Quality Control (QC) is identified as Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2132.

CB 9:

This QA Inspector observed that no significant work was being performed on this CB at the time when this QA was present.

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

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<b>Inspected By:</b>	Wadkar,Sailesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Hall,Steven	QA Reviewer

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