

**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-014019**Date Inspected:** 16-May-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 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:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar 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:

**TRIAL ASSEMBLY YARD**

This QA Inspector randomly observed the following work in progress.

**OBG SEGMENT 8AW**

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045175 performing Flux Cored Arc Welding process for weld CA047-005 located on PCMK. Weld between side panel and edge panel (counter weight side). ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U4B-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037748 performing Shielded Metal Arc Welding process for weld DP643-001-015 located on PCMK. Weld between deck panel and deck panel "I" rib (counter weight side). ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-4114-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066261 performing Shielded Metal Arc

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Welding process for weld DP651-001-016 located on PCMK. Weld between deck panel and deck panel "T" rib (cross beam side). ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-4114-1.

This Quality Assurance (QA) Inspector observed ZPMC QA Inspector performing ultrasonic inspection for the weld between longitudinal diaphragm and floor beam at PP61 (cross beam side).

### OBG SEGMENT 7EW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066413 performing Shielded Metal Arc Welding process for weld CA044-006 located on PCMK. Corner assembly. ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4B-FCM-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066174 performing Shielded Metal Arc Welding process for weld EP071-001-011 located on PCMK. Corner assembly. ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-FCM-1.

### OBG SEGMENT 7AW-7BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 069683 performing Shielded Metal Arc Welding process for weld OBW7N-003 located on PCMK. Counter weight connection plate. ZPMC QC Mr. Zhang Hai Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4B-F-1.

### OBG SEGMENT 8CW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066038 performing Shielded Metal Arc Welding process for weld OBW8A-023 located on PCMK. Counter weight connection plate. ZPMC QC Mr. Zhang Hai Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

### OBG SEGMENT 7CW-7SW

This Quality Assurance (QA) Inspector observed ABF QA Inspector performing ultrasonic inspection for the weld between edge panel and deck panel (cross beam side) of OBG segment 7CE.

This Quality Assurance (QA) Inspector observed ZPMC QA Inspector performing ultrasonic inspection for the weld between "T" stiffener at splice weld between OBG segment 7CW and 7DE.

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

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## 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, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Utekar,Shrikant

Quality Assurance Inspector

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**Reviewed By:** Dawson,Paul

QA Reviewer