

**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-015439**Date Inspected:** 30-Jun-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 Shi Gang**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 (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-DP3103-001

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3103-001 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, 181, 291; Welder # 059421

Weld Joint # 002, 182, 292; Welder # 059418

Weld Joint # 003, 183, 293, 005, 185, 295; Welder # 059378

Weld Joint # 004, 184, 294, 006, 186, 296; Welder # 203805

Weld Joint # 007, 187, 297, 009, 189, 299; Welder # 201788

Weld Joint # 008, 188, 298, 010, 190, 300; Welder # 059416

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### DECK PANEL 13BE-DP3093-001

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3093-001 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, 145; Welder # 059421

Weld Joint # 002, 146; Welder # 059418

Weld Joint # 003, 147, 005, 149; Welder # 059378

Weld Joint # 004, 148, 006, 150; Welder # 203805

Weld Joint # 007, 151; Welder # 201788

Weld Joint # 008, 152; Welder # 059416

During production welding due to some malfunctioning the arc has been stopped at various locations for two weld joints. ZPMC and AB/F marked those locations & before start the production welding ZPMC NDT personnel Mr. Gu Yun Wu carried out Magnetic Particle Testing (MT) at the "Arc stop" locations of the weld to confirm the complete removal of crack from the "Arc stop" locations. The locations & respective weld identification are as follows

13CE-DP3103-001-183, 184; Y location: 3670mm.

### 13CE-DP3104-001

Gas Metal Arc Welding (GMAW) tack welding of U-rib to deck plate of DP3104-001 were in process. The welder is identified as 059366. 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.

### U-rib Internal Cover Plate

During random in process inspection this QA inspector witnessed Magnetic Particle Testing (MT) performed by ZPMC MT technician Mr. Gu Yun Wu on the welds of internal cover plate of U-rib of deck panels. The weld designation are identified as follows.

DP3107-001-124, 125, 169, 170, 117, 116, 167, 168

DP3106-001-132, 133, 171, 172, 117, 116, 167, 168, 124, 125, 169, 170

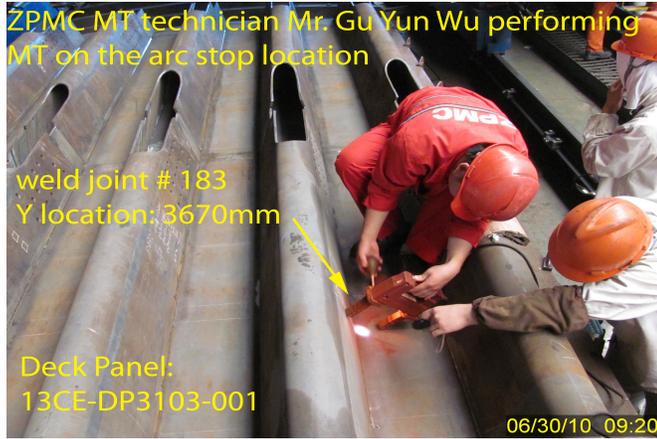
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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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