

**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-015258**Date Inspected:** 01-Jul-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:** Wu Zhi Zhang**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

ULTRASONIC INSPECTION

OBG SEGMENT 11BE

ABF Report No: UT-11E-013

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between edge panel and deck panel (Cross beam side) of OBG segment 11BE. The weld designations are as follows.

SEG068\*-047 (OBG 11BE, E.P to D.P – Cross beam side)

ULTRASONIC INSPECTION

OBG SEGMENT 11DE

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

ABF Report No: UT-11E-013

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between edge panel and deck panel (Cross beam side) of OBG segment 11DE. The weld designations are as follows.

SEG072\*-047 (OBG 11DE, E.P to D.P – Cross beam side)

### TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

#### OBG SEGMENT 9AW-9BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068097 performing Shielded Metal Arc Welding process for weld 006 located on PCMK CA055. 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-fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067588 performing Shielded Metal Arc Welding process for weld 019 located on PCMK DP671-001. ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-b-u3b.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045143 performing Flux Cored Arc Welding process for weld 018 located on PCMK SEG049B. ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045221 performing Shielded Metal Arc Welding process for weld 001 located on PCMK OBW9. ZPMC QC Mr. Zhang Hai Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-b-u2-fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC QA Inspector performing Ultrasonic Inspection for the side panel splice weld between OBG segment 9AW and 9BW (Cross beam side).

#### OBG SEGMENT 9BE-9CE

This Quality Assurance (QA) Inspector observed ZPMC QA Inspector performing Magnetic Particle Inspection for the side panel splice weld between OBG segment 9CE and 9BE (Bike path side).

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

---

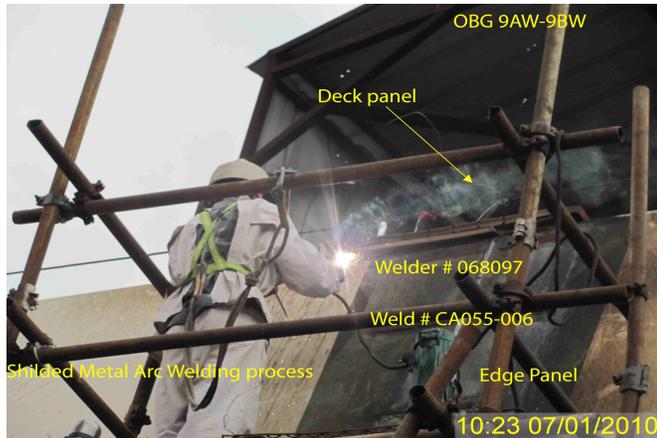
---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---



## Summary of Conversations:

Only general conversation was held between QA and QC

## 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.

---

<b>Inspected By:</b>	Utekar,Shrikant	Quality Assurance Inspector
----------------------	-----------------	-----------------------------

---

<b>Reviewed By:</b>	Peterson,Art	QA Reviewer
---------------------	--------------	-------------