

**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-015571**Date Inspected:** 12-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:** Mr. Huang min**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:

**BAY- 1**

This QA received ZPMC inspection notification sheet 06177 to perform dimensional inspection of traveler rail identified as 20TR1-027. Dimensional inspections performed on this traveler rail include, but is not limited to, overall length, beam sweep, beam camber, flange tilt and flange warpage. The results of the inspection were recorded on Caltrans (CT) QA form OBG DCP Hand Measurements survey: Traveler Rails and submitted to CT QA lead for review.

**BAY- 6**

This QA Inspector Randomly observed the following work in progress:

ZPMC personnel heat straightening OBG member identified as DP3097A. Distortion appeared to be caused by welding of the material. ZPMC Quality Control (QC) inspector identified as Mr. Xia Yong Zheng was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) HSR1 (B) 8761.

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ZPMC personnel heat straightening OBG member identified as BP3041A. Distortion appeared to be caused by welding of the material. ZPMC Quality Control (QC) inspector identified as Mr. Xia Yong Zheng was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) HSR1 (B) 8760.

ZPMC QC Certified Welding Inspector Mr. Huang min was performing Visual Testing for the welds located on Bottom Panel identified as BP3060-001. Refer attached photos for additional details.

BAY- 7

FCAW of weld joint EP3021-001-011,012. Welder is identified as 053609. ZPMC Quality Control (QC) is identified as Mr. Guopan. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

FCAW of weld joint SA7034-001-017,018. Welder is identified as 217185. ZPMC Quality Control (QC) is identified as Mr. Cui jun jie. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-TC-U5-F.

FCAW of weld joint SA7509-001-021,022. Welder is identified as 217185. ZPMC Quality Control (QC) is identified as Mr. Cui jun jie. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132.

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
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<b>Reviewed By:</b>	Hall,Steven	QA Reviewer
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