

**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-015881**Date Inspected:** 25-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:** 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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune 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 QA Inspector randomly observed the following work in progress:

**OBG # TRIAL ASSEMBLY YARD**

Segment # 9DW

Repair Welding

This QA inspector observed, ZPMC qualified welding personnel identified as 048659 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG054C-001; The Welding Repair Report (WRR) was B-WR14103. ZPMC QC is identified as Mr. An Qing Xiang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW 4G (4F) FCM-Repair-1. See the attached Photo.

Segment # 9AW ~ 9BW

Repair Welding

This QA inspector observed, ZPMC qualified welding personnel identified as 066326 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW9-005; The Welding Repair Report (WRR) was B-WR1709. ZPMC CWI is identified as Mr. Zhu Zhong Hai. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW 3G (3F) FCM-Repair-1.

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# WELDING INSPECTION REPORT

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## Segment # CB 11

### Repair Welding

This QA inspector observed, ZPMC qualified welding personnel identified as 201087 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CB202A-011-014; The Critical Welding Repair Report (CWRR) was B-CWR1696. ZPMC CWI is identified as Mr. Zhu Zhong Hai. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW 2G (2F) FCM-Repair-1. See the attached Photo.

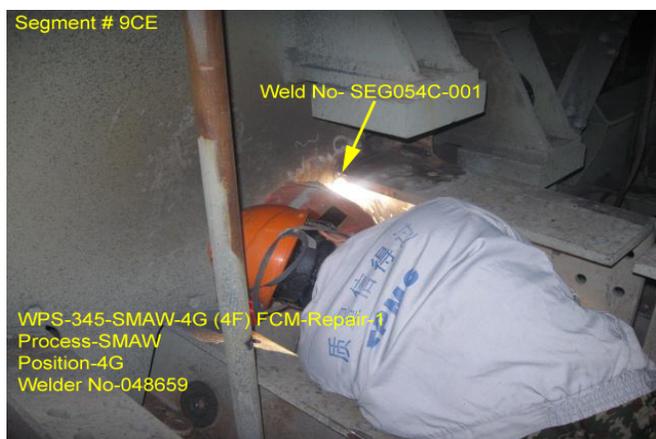
## Segment # 9CW ~ 9DW

This QA inspector observed, ZPMC qualified welding personnel identified as 067755 perform Flux Core Arc Welding (FCAW), weld joint identified as OBW9C-002; ZPMC QC is identified as Mr. Wang Zhu. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2233T.

## Segment # 9AE

This QA inspector observed, ZPMC qualified welding personnel identified as 044779 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SSD29-PP071.5-004; ZPMC QC is identified as Mr. Wang Xiang Ping. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2113.

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

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## WELDING INSPECTION REPORT

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for your project.

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<b>Inspected By:</b>	Prabhune,Manoj	Quality Assurance Inspector
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<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer
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