

**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-015924**Date Inspected:** 30-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:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar 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:

OBG Trial Assembly Yard:

This QA Inspector observed the following work in progress:

OBG Seg 9EE:

Repair welding on weld joint no: SEG058C-049. Welding process was identified as Flux Cored Arc Welding (FCAW). The welder was identified as 220066 and was observed welding in the 2G position. ZPMC Quality Control (QC) was identified as Wang Liang. The welding variables recorded by QC appeared to comply with WPS: 345-FCAW-2G(2F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): WR 14138 Rev-2.

OBG Seg 9DE and Seg 9EE:

Repair welding on weld joint no: OBE9C-007. Welding process was identified as Shielded Metal Arc Welding (SMAW). The welder was identified as 054467 and was observed welding in the 4G position. ZPMC QC was

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identified as Wang Liang. The welding variables recorded by QC appeared to comply with WPS: 345-FCAW-4G(4F)-FCM-Repair-1. Repair welding was done as per Critical Welding Report (CWR): B-CWR-1736 Rev-0.

OBG Seg 9BW and Seg 9CW:

Repair welding on weld joint no: OBW9B-008. Welding process was identified as SMAW. The welders were identified as 047864 and 045246 and were observed welding in the 4G position. ZPMC QC was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: 345-FCAW-4G(4F)-FCM-Repair-1. Repair welding was done as per WRR: B-WR-14201 Rev-0.

The SMAW process on weld joint no's: SP730-001-043 to 048. The welder was identified as 045196 and was observed welding in the 3G position. ZPMC QC was identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS: B-P-2213-B-U2-FCM-1.

OBG Seg 9CW and Seg 9DW:

The SMAW process on weld joint no's: BP045-001-020, 022 and 024. The welder was identified as 041713 and was observed welding in the 3G position. ZPMC QC was identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS: B-P-2213-B-U2-FCM-1.

Cross Beam 11 (CB11):

The FCAW process on weld joint no: CB202A-011-016. The welder was identified as 045143 and was observed welding in the 2G position. ZPMC QC was identified as Xu Jin long. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-TC-U4c-F.

Cross Beam 12 (CB12):

The FCAW process on weld joint no: CB201A-012-013. The welder was identified as 053742 and was observed welding in the 4G position. ZPMC QC was identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS: B-T-2234-TC-U4b-F.

Bay 7 - Cross Beam 18 (CB18):

The FCAW process on weld joint no's: SP3089-001-011 and 012. The welder was identified as 062447 and was observed welding in the 2F position. ZPMC QC was identified as Guo Pan. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

The FCAW process on weld joint no's: FB4106-001-005 and 006. The welder was identified as 217185 and was observed welding in the 2F position. ZPMC QC was identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

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

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documents.

**Summary of Conversations:**

No significant conversations were reported on this date.

**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 for your project.

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<b>Inspected By:</b>	Wadkar,Sailesh	Quality Assurance Inspector
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<b>Reviewed By:</b>	Peterson,Art	QA Reviewer
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