

**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-016052**Date Inspected:** 04-Aug-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**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr. 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. The QA Inspector observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC TESTING

CROSS BEAM #16

ABF Report No: UT-CB16-001

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 separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the weld between side panel and bottom on the west side. The weld designations were as follows:

CB202A-016-017 (CB#16, S.P to B.P, West side)

This QA Inspector randomly observed the following work in progress.

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## OBG LIFT 9WEST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040609 performing Shielded Metal Arc Welding process for weld 024 located on PCMK BP154-001. ZPMC QC Mr. Shi Lei was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2233-B-u2-fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 046706 performing Flux Cored Arc Welding process for weld 028 located on PCMK SP731-001. ZPMC QC Mr. Zhou Peng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066413 performing Shielded Metal Arc Welding process for weld 008 located on PCMK OBW9B. ZPMC QC Mr. Zhou Peng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F) Repair-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067609 performing Shielded Metal Arc Welding process for weld 044 located on PCMK SP731-001. ZPMC QC Mr. Shi Lei was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-u2-fcm-1.

## OBG SEGMENT 9DE-9EE

This Quality Assurance (QA) Inspector observed ABF personnel performing ultrasonic testing on the repair areas of bottom panel splice weld between OBG segment 9DE and 9EE. Weld number identified as OBE 9C-008.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract 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, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

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# WELDING INSPECTION REPORT

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**Inspected By:** Utekar,Shrikant

Quality Assurance Inspector

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**Reviewed By:** Peterson,Art

QA Reviewer