

**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-016053**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:** Chen Xi.**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:

Bay 1:

This QA Inspector observed the following work in progress:

Repair welding on weld joint no: 20TR2-023-009. Welding process was identified as Flux Cored Arc Welding (FCAW). The welder was identified as 215397 and was observed welding in the 2G position. ZPMC Quality Control (QC) was identified as Ai Wei. The welding variables recorded by QC appeared to comply with WPS: 345-FCAW-2G(2F)-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR-14324 Rev-0. See attached photo for further details.

Repair welding on weld joint no: 20TR2-028-011. Welding process was identified as FCAW. The welder was identified as 216872 and was observed welding in the 2G position. ZPMC QC was identified as Ai Wei. The welding variables recorded by QC appeared to comply with WPS: 345-FCAW-2G(2F)-Repair-1. Repair welding was done as per WRR: B-WR-14227 Rev-0.

Bay 2:

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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This QA Inspector observed the following work in progress:

The Submerged Arc Welding (SAW) process on weld joint no: FB3329-001-006. The welder is identified as 045265 and was observed welding in the 1G position. ZPMC QC was identified as Zhong Yang Gang. The welding variables recorded by QC appeared to comply with WPS: B-T-2221-L2c-S-2. See attached photo for further details.

The FCAW process on weld joint no's: SA3181B-001-047 and 048. The welder is identified as 045203 and was observed welding in the 2F position. ZPMC QC was identified as Zhong Yang Gang. The welding variables recorded by QC appeared to comply with WPS: B-T-2132-3.

Notification No: 006331.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC QC personnel. This QA Inspector generated a UT report on this date. The members are identified as OBG components. The weld designations reviewed are as follows:

- 1) FB3202-001-138 and 139.
- 2) FB3217-001-020.
- 3) FB3231-001-018.

Bay 3:

This QA Inspector observed the following work in progress:

The Submerged Arc Welding (SAW) process on weld joint no: FB3280-001-001 and 002. The welder is identified as 062406 and was observed welding in the 1G position. ZPMC QC was identified as Wang Liang. The welding variables recorded by QC appeared to comply with WPS: B-T-2221-L2c-S-2.

Bay 6:

Notification No: 006331.

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC QC personnel. This QA Inspector generated a UT report on this date. The members are identified as OBG components. The weld designations reviewed are as follows:

- 1) DP3126B-001-230, 225 and 218.
- 2) DP3095A-001-117, 122 and 127.
- 3) DP3127A-001-046.
- 4) DP3096A-001-046.

Bay 7:

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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Notification No: 006331.

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC QC personnel. This QA Inspector generated a UT report on this date. The members are identified as OBG components. The weld designations reviewed are as follows:

- 1) SP3122A-001-001.
- 2) SP3144A-001-127.
- 3) SP3145A-001-014.
- 4) SP3121A-001-001.

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; phone: 15000422372., who represents the Office of Structural Materials for your project.

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**Inspected By:** Wadkar,Sailesh

Quality Assurance Inspector

**Reviewed By:** Peterson,Art

QA Reviewer