

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016526**Date Inspected:** 31-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 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 10BW and Seg 10CW:

The Flux Cored Arc Welding (FCAW) process on weld joint no's: OBW10A-002, 003 and 004. The welders are identified as 053316 and 040759 and were observed welding in the 1G position. ZPMC Quality Control (QC) was identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS:

B-T-223(2)1-T-2.

OBG Seg 9CW and Seg 9DW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: OBW9K-010. The welders are identified as 067904 and 067610 and were observed welding in the 4G position. ZPMC QC was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

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# WELDING INSPECTION REPORT

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OBG Seg 10AE and Seg 10BE:

The SMAW process on weld joint no's: EP167-001-013 and 014. The welder is identified as 044515 and was observed welding in the 4G position. ZPMC QC was identified as Wang Liang. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

The SMAW process on weld joint no's: SP350-001-044 and 046. The welder is identified as 040320 and was observed welding in the 4G position. ZPMC QC was identified as Wang Liang. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

OBG Seg 9BW:

Notification no: 006540.

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) SEG051E-PP75-049, 040, 013, 031 and 022.
- 2) SEG051D-PP75-065, 155 and 146.

Blasting inspection:

Cross Beam 11 (CB11).

This QA Inspector performed random visual inspection of CB11 after grit blasting. Inspection was done for the surfaces of Bottom panel, Side Panels, Deck panel and Floor Beams. Areas identified for any grinding and / or welding were marked and were informed to ZPMC personnel. Also the same were recorded on the drawings / weld maps and were submitted to the Task Leader for review.

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

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