

**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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016527**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**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

OBG SEGMENT 9DW-9EW

ABF Request No: 08302010-2

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 deck panel splice weld between OBG segment 9DW and 9EW. The weld designations were as follows:

OBW9A-008, 007 (OBG 9DW-9EW, DP)

TRIAL ASSEMBLY YARD

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This QA Inspector randomly observed the following work in progress.

## OBG SEGMENT 10BW-10CW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040759 performing the Flux Cored Arc Welding process on weld 003 located at PCMK OBW10A. ZPMC QC Mr. Zhong Peng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-223 (2) 1T-2.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 046706 performing the Flux Cored Arc Welding process on weld 003 located at PCMK OBW10C. ZPMC QC Mr. Zhong Peng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-223 (2) 1T-2.

## OBG SEGMENT 10AE-10BE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040367 performing the Flux Cored Arc Welding process on weld 030 located at PCMK BP183-001. ZPMC QC Mr. Wang Li Yang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233T.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044515 performing the Shielded Metal Arc Welding process on weld 014 located at PCMK EP167-001. ZPMC QC Mr. Wang Li Yang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-u4-fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040504 performing the Shielded Metal Arc Welding process on weld 044 located at PCMK SP350-001. ZPMC QC Mr. Wang Li Yang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-u2-fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044473 performing the Flux Cored Arc Welding process on weld 005 located at PCMK SP324-001. ZPMC QC Mr. Wang Li Yang was monitoring this welding operation. 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 documents.



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**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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<b>Inspected By:</b>	Utekar,Shrikant	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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