

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-017260**Date Inspected:** 30-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Gang Wei**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 Subassemblies and bike path**Summary of Items Observed:**

On this day CALTRANS Office of Structural Materials (OSM) Quality Assurance Inspector (QA) Steve Hall 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 ASSEMBLY BAY 16**

This QA observed ZPMC qualified welding personnel identified as 045143 perform Flux Cored Arc Welding (FCAW) on OBG Segment 13BW. The weld joint is identified as LD3032-001-058. ABF QA identified as Mr. Li Zhi You was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-TC-U5-F.

This QA observed ZPMC qualified welding personnel identified as 206358 perform Flux Cored Arc Welding (FCAW) on OBG Segment 13 AW. The weld joint is identified as LD3034-001-186. ABF QA is identified as Mr. Li Zhi You was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-B-U5-F.

This QA observed ZPMC qualified welding personnel identified as 048250 perform FCAW on OBG Longitudinal diaphragm. The weld joint is identified as LD3033-001-024. ZPMC QC identified as Mr. Li Zhi You was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-Tc-u5-f.

**OBG ASSEMBLY BAY 14**

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# WELDING INSPECTION REPORT

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This QA observed ZPMC qualified welding personnel identified as 047866 perform Flux Cored Arc Welding (FCAW) on OBG anchorage plate. The weld joint is identified as AP3013-001-31. ABF QA Mr. Shao Jian Yuan was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

## OBG ASSEMBLY OUTSIDE YARD

This QA observed ZPMC qualified welding personnel identified as 043661 perform Shielded Metal Arc Welding (SMAW) on OBG Segment 12CE. The weld joint is identified as SEG3003M-021. ZPMC QC is identified as Mr. Li ping was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### 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 (15000422372), who represents the Office of Structural Materials for your project.

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

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