

**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-017250**Date Inspected:** 05-Oct-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:** Zhu Zhong Hai.**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 10BE and Seg 10CE:

Repair welding of weld joint nos: SP712-001-040 and SP712-001-036. Welding process was identified as Shielded Metal Arc Welding (SMAW). The welder was identified as 053871 and was observed welding in the 3G position. ZPMC Quality Control (QC) was identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-3G(3F)-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR-15523 Rev-0 and B-WR-15525 for the respective welds.

Repair welding of weld joint nos: DP702-001-039 and DP702-001-040. Welding process was identified as SMAW. The welder was identified as 044515 and was observed welding in the 3G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS: 485-SMAW-3G(3F)-Repair-1. Repair welding was done as per WRR: B-WR-15517 Rev-0 and B-WR-15518 for

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the respective welds.

The Flux Cored Arc Welding (FCAW) process on weld joint no: TR5B-PP91-003. The welder is identified as 040458 and was observed welding in the 1G and 3G positions. ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by QC appeared to comply with WPS: B-T-2231-TC-U4c-F and B-T-2233-TC-U4c-F. See attached photo for further details.

OBG Seg 10BE:

Repair welding of weld joint nos: CA076-001. Welding process was identified as SMAW. The welder was identified as 052493 and was observed welding in the 2G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-2G(2F)-Repair-1. Repair welding was done as per Critical Welding Report (CWR): CWR-1974 Rev-0.

OBG Seg 10CE:

Repair welding of weld joint no: CA078-005. Welding process was identified as SMAW. The welder was identified as 052493 and was observed welding in the 2G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-2G(2F)-Repair-1. Repair welding was done as per CWR: CWR-1974 Rev-0.

Repair welding of weld joint no: SEG064C. Welding process was identified as SMAW. The welder was identified as 044504 and was observed welding in the 3G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-3G(3F)-Repair-1. Repair welding was done as per WRR: BWR-15498 Rev-0.

OBG Seg 11AE:

The FCAW process on weld joint no: CA081-005. The welder is identified as 052763 and was observed welding in the 1G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS: B-T-2231-TC-U4b-F.

OBG Seg 11BE:

The FCAW process on weld joint no: SEG068A-028. The welder is identified as 052763 and was observed welding in the 1G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS: B-T-2231-TC-U4b-F.

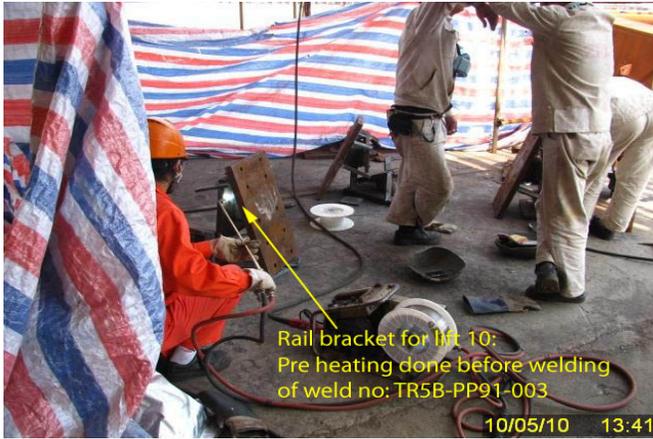
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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

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**Inspected By:** Wadkar,Sailesh

Quality Assurance Inspector

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**Reviewed By:** Peterson,Art

QA Reviewer