

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Vallejo, CA 94592-1133  
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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-017494**Date Inspected:** 21-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:** Geng 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 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 14:

Notification no: 007046.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control (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) SEG3015-003 (For OBG Seg 13CW).
- 2) SEG3013-007, 008 (For OBG Seg 13CW).

For the above mentioned welds, after completion of UT, this QA Inspector had also issued a Green Tag for the same. See attached photo for further details.

Notification no: 007049.

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## WELDING INSPECTION REPORT

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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) SEG3015-002 (For OBG Seg 13CW).

For the above mentioned weld, after completion of UT, this QA Inspector had also issued a Green Tag for the same. See attached photo for further details.

This QA Inspector observed the following work in progress:

OBG Seg 14E:

The Submerged Arc Welding (SAW) process on weld joint no: SEG3019AY-011. The welder is identified as 044771 and was observed welding in the 1G position. ZPMC QC was identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with WPS: B-T-2221-L2c-S-2.

OBG Seg 13CE:

The Flux Cored Arc Welding (FCAW) process on weld joint no: CA3014-103. The welder is identified as 044795 and was observed welding in the 2G position. ZPMC QC was identified as Lv Li Qing. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-TC-U4b-F.

The FCAW process on weld joint nos: VP3008-001-002 and VP3007-001-045. The welders are identified as 044801 and 067520 and were observed welding in the 2G position. ZPMC QC was identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-TC-U4b-F.

OBG Seg 14W:

The SAW process on weld joint no: SEG3020AQ-029. The welder is identified as 045265 and was observed welding in the 1G position. ZPMC QC was identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with WPS: B-T-2221-L2c-S-2.

OBG Seg 14E:

The SAW process on weld joint no: SEG3019AP-003. The welder is identified as 045265 and was observed welding in the 1G position. ZPMC QC was identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with WPS: B-T-2221-L2c-S-2.

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

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

Bay 14.

QA APPROVAL REQUEST FORM

COMPOSITE: SEG 3012 - 007/008 Date: 2010.10.21

In-Process tag No: \_\_\_\_\_  
(Attach to Process Tag)

Green tag No: 14999

Lift/OBG Segment: 塔吊裝段/OBG 橋段 13AW

Weld number: SEG 3012 - 007.008

ZPMC Team Representative: \_\_\_\_\_ Date: \_\_\_\_\_

ABF Team Representative: \_\_\_\_\_ Date: \_\_\_\_\_  
Shao Jian Yuan 2010.10.21

CT Team Representative: \_\_\_\_\_ Date: \_\_\_\_\_  
SHAILESH V WADKAR 10/21/10

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DOCUMENTATION REVIEW

NDE complete	<input type="checkbox"/>	Yes	<input type="checkbox"/>	No
Repairs complete	<input type="checkbox"/>		<input type="checkbox"/>	
NCR's closed	<input type="checkbox"/>		<input type="checkbox"/>	

ABF QA Manager: \_\_\_\_\_ Date: \_\_\_\_\_

10/21/10 13:30

Bay 14.

QA APPROVAL REQUEST FORM

COMPOSITE: SEG 3015 - 002/003 Date: 2010.10.21

In-Process tag No: \_\_\_\_\_  
(Attach to Process Tag)

Green tag No: 15000

Lift/OBG Segment: 塔吊裝段/OBG 橋段 13CW

Weld number: SEG 3015 - 002.003

ZPMC Team Representative: \_\_\_\_\_ Date: \_\_\_\_\_

ABF Team Representative: \_\_\_\_\_ Date: \_\_\_\_\_  
Shao Jian Yuan 2010.10.21

CT Team Representative: \_\_\_\_\_ Date: \_\_\_\_\_  
SHAILESH V WADKAR 10/21/10

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DOCUMENTATION REVIEW

NDE complete	<input type="checkbox"/>	Yes	<input type="checkbox"/>	No
Repairs complete	<input type="checkbox"/>		<input type="checkbox"/>	
NCR's closed	<input type="checkbox"/>		<input type="checkbox"/>	

ABF QA Manager: \_\_\_\_\_ Date: \_\_\_\_\_

10/21/10 13:30

**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.

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