

**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-017589**Date Inspected:** 24-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:** Mr. Qiu Wen.**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:** Tower and Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad 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. QA observed and/or found the following:

NDT

BAY 11

This QA Inspector performed randomly Visual Inspection of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as OBG Bike path. The weld designations reviewed are as follows.

BK004A-018

NDT Notification No-07085

This QA Inspector observed the following work in progress:

BAY 11:

SMAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 041271, 040690 Perform Shielded Metal Arc Welding (SMAW) on Lift 5 Bracket stiffener. Joint identified as ND1-BRSA5-2-6B. ZPMC QC Identified as Zhao Mao Mao. The welding parameters as measured using QC's calibrated instrument appeared to

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

be in general compliance with WPS-B-T-3212-Tc-U5b. For more information see below attached picture number 1.

This QA Inspector observed ZPMC qualified welding personnel identified as 040611 Perform Shielded Metal Arc Welding (SMAW) on Angle Connection plate. Joint identified as ND1-SA4-68-143M-3-1A. ZPMC QC Identified as Zhao Mao Mao. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3211-Tc-U5b-1. For more information see below attached picture number 2.

Repair welding SMAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 202100, Perform Shielded Metal Arc Welding (SMAW) on Splice (connect) Plate. Plate identified as SA5-5 (ZP06-787-J1071) quantity of plate 7 nos. ZPMC QC Identified as Zhao Mao Mao with welding repair report WRR-T-WR3552. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-485-SMAW-2G (2F) Repair.

OBG Bike path plate FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040704, 054460, Perform Flux Core Arc Welding (FCAW) on OBG bike path plate. Joint identified as BK4ASD1-019-005, 021. ZPMC QC Identified as Shao Hai Lang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2213-B-U2, WPS-B-P-2212-B-U2.

This QA Inspector observed ZPMC qualified welding personnel identified as 042218, Perform Flux Core Arc Welding (FCAW) on OBG bike path plate. Joint identified as BK005A8-003-015, 016, 019, 020. ZPMC QC Identified as Shao Hai Lang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2133.

This QA Inspector observed ZPMC qualified welding personnel identified as 040704, Perform Flux Core Arc Welding (FCAW) on OBG bike path plate. Joint identified as BK005A6-003-015, 016, 019, 020. ZPMC QC Identified as Shao Hai Lang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2133.

This QA Inspector observed ZPMC qualified welding personnel identified as 040759, Perform Flux Core Arc Welding (FCAW) on OBG bike path plate. Joint identified as BK008A1-001-009. ZPMC QC Identified as Mao Bin Bin. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231-B-U2-F.

BAY 10

OBG Bike path plate Repair welding FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 053869, Perform Flux Core Arc Welding (FCAW) on OBG bike path plate. Joint identified as BK004A3-025-002. ZPMC QC Identified as Yu Zhi Lai with temporary welding repair report. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-1G (1F) Repair.

This QA Inspector observed ZPMC qualified welding personnel identified as 057180, 053869, Perform Flux Core

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

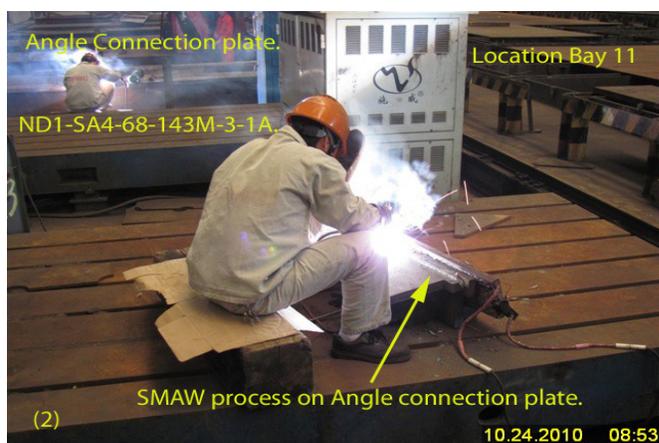
---

---

Arc Welding (FCAW) on OBG bike path plate. Joint identified as BK004A3-025-019, 020, 032, 033, 043, 044, 058, 059. ZPMC QC Identified as Yu Zhi Lai. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2133.

This QA Inspector observed ZPMC qualified welding personnel identified as 053869, Perform Flux Core Arc Welding (FCAW) on OBG bike path plate. Joint identified as BK004A6-025-067, 114. ZPMC QC Identified as Yu Zhi Lai. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2233-Tc-U4c-F.

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 Thomas Ho phone : 150002048250, who represents the Office of Structural Materials for your project.

---

**Inspected By:** Gaikwad,Shailesh

Quality Assurance Inspector

---

**Reviewed By:** Clifford,William

QA Reviewer