

**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-017853**Date Inspected:** 08-Nov-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:** An Qing Xiang**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune 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:

This QA Inspector randomly observed the following work in progress:

OBG TRIAL ASSEMBLY YARD

**WELDING:****Segment 11BW ~ 11CW**

This QA Inspector observed ZPMC qualified welding personnel identified as 046709 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE11-007; located On Orthotropic Box Girder (OBG) Deck Plate to Deck Plate Transverse CJP Weld. The Critical Welding Repair Report (CWRR) was B-CWR2178. ZPMC QC is identified as Mr. Zhu Yuan Yuan. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with applicable WPS-345-SMAW 4G (4F) FCM-Repair-1. See attached photo for further details.

**Segment 11DW ~ 11EW**

This QA Inspector observed ZPMC qualified welding personnel identified as 044551 perform Shielded Metal Arc

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

Welding (SMAW), weld joint identified as OBW11A-010; located On Orthotropic Box Girder (OBG) Edge Plate to Edge Plate CJP Weld. ZPMC QC is identified as Mr. Zhu Yuan Yuan. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with applicable WPS-B-P-2214-TC-U4b-FCM-1.

### Segment # 11CE ~ 11DE

This QA Inspector observed ZPMC qualified welding personnel identified as 040484 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE11C-003; located On Orthotropic Box Girder (OBG) Bottom Plate to Bottom Transverse CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2214-B-U2-FCM-1. See attached photo for further details.

### Segment # 11CE ~ 11DE

This QA Inspector observed ZPMC qualified welding personnel identified as 067752 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE11A-002; located On Orthotropic Box Girder (OBG) Deck Plate to Deck Plate Transverse CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2214-B-U2-FCM-1.

### Segment # 11EW

This QA Inspector observed ZPMC qualified welding personnel identified as 053486 perform Flux Core Arc Welding (FCAW), weld joint identified as SP508-001-002; located On Orthotropic Box Girder (OBG) Side Plate T-Rib Hold Back Weld; ZPMC Quality Control (QC) is identified as Mr. Zhou Peng. The welding variables recorded by QC appeared to comply with applicable WPS-B-T-2132.

### Segment # 11DW

This QA Inspector observed ZPMC qualified welding personnel identified as 049220 perform Flux Core Arc Welding (FCAW), weld joint identified as SP745-001-049; located On Orthotropic Box Girder (OBG) Side Plate T-Rib Hold Back Weld; ZPMC Quality Control (QC) is identified as Mr. Zhou Peng. The welding variables recorded by QC appeared to comply with applicable WPS-B-T-2132.

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

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---



## Summary of Conversations:

No significant conversation 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.

---

**Inspected By:** Prabhune,Manoj

Quality Assurance Inspector

**Reviewed By:** Peterson,Art

QA Reviewer