

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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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-019036**Date Inspected:** 20-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:** Li Yan Hua.**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 Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

Corner Assembly for OBG Seg 13CW:

Repair welding of weld joint no: CA3016-100 [Edge panel (EP) to Deck Panel (DP); complete joint penetration weld (CJP) weld]. The welder is identified as 045246 and was observed welding in the 2G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC Quality Control (QC) was identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with Welding Procedure Specification (WPS): 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR 17264 Rev-0.

OBG Seg 13BW:

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3014J-118 [I-rib stiffener splice weld at

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Panel Point (PP) 120.5, CB side]. The welder is identified as 045280 and was observed welding in the 3G position. ZPMC QC was identified as Qiu Wen. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-B-U2-F.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3014J-106 [I-rib stiffener to Floor Beam (FB) CJP weld at PP 120.5, on Side Panel (SP) CB side]. The welder is identified as 045196 and was observed welding in the 3G position. ZPMC QC was identified as Qiu Wen. The welding variables recorded by QC appeared to comply with WPS: B-T-2213-TC-U4b-F.

OBG Seg 13AW:

The FCAW process on weld joint no: SEG3013P-258 (FB to RS stiffener, CJP weld at PP118). The welder is identified as 069089 and was observed welding in the 2G position. ZPMC QC was identified as Qiu Wen. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-TC-U4b-F.

OBG Seg 14W:

The SMAW process on weld joint no: SEG3020AZ-013 (SP to SP, CJP weld). The welder is identified as 067829 and was observed welding in the 4G position. ABF QA was identified as Shao Jian Yuan. The welding variables appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

Repair welding of weld joint nos: SEG3020AB-108 and 109 [Longitudinal Diaphragm (LD) to Bottom Panel (BP); CJP weld]. The welder is identified as 202122 and was observed welding in the 2G position. Welding process was identified as FCAW. ZPMC QC was identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with WPS: 345-FCAW-2G(2F)-ESAB-Repair. Repair welding was done as per WRR: B-WR 17424 and B-WR 17425 Rev-0, for the respective welds.

OBG Seg 13AW:

ZPMC NDE personnel performing UT of weld jt no: SEG3013P-104 and SEG3013Q-040 (LD to FB at PP118). 11 locations on weld no: SEG3013P-104 and 7 locations on weld no: SEG3013Q-040 were marked for repair welding.

OBG Seg 13BW and Seg 13CW:

This QA Inspector observed that the R25 cope hole is not provided on the floor beams; from PP120.5 to 124.5. Welding and NDT (UT) of FB to LD CJP weld from PP120.5 to 124.5 is completed. This is informed this to ZPMC CWI Li Ming Yang and CT Lead QA. See attached photos for further details.

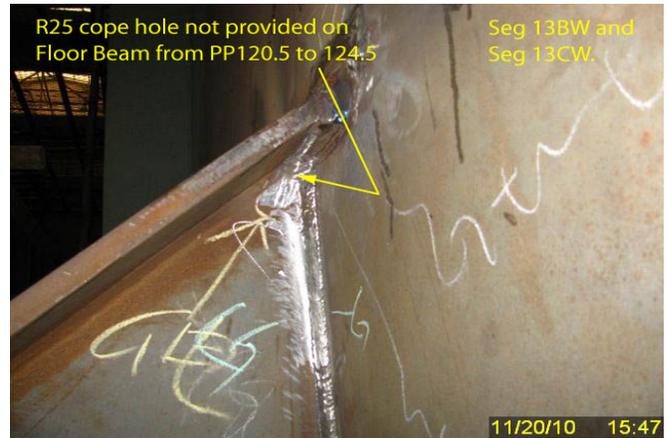
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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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:** Patterson,Rodney

QA Reviewer