

**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-018815**Date Inspected:** 15-Dec-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

<b>CWI Name:</b>	Li Jia			<b>CWI Present:</b>	Yes	No	
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006			<b>Component:</b>	OBG COMPONENT		

**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Subhasis Bera was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

In process Inspection

BAY#10

This QA Inspector observed the following work in progress:

SMAW in the 2F position for the OBG bike path, weld No.BK004-A3-025-073. The welder is identified as #056200. ZPMC QC is identified as Mr. Li Jun. The welding variables recorded by QC appear to comply with WPS-B-P-2112.

SMAW in the 2G position for the OBG bike path, UT repair weld No.BK004-A1-033-044. The welder is identified as #057258. ZPMC QC is identified as Mr. Yu Zhi Lai. The welding variables recorded by QC appear to comply with WPS-345-SMAW-2G(2F)-REPAIR. The weld repair report is identified as WR18691.

FCAW in the 2G position for the OBG bike path, UT repair weld No.BK007-A1-001-044. The welder is identified as #040533. ZPMC QC is identified as Mr. Yu Zhi Lai. The welding variables recorded by QC appear to comply with WPS-345-FCAW-2G(2F)-ESAB-REPAIR. The weld repair report is identified as WR19143.

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BAY#11

This QA Inspector observed the following work in progress:

SMAW in the 1G position for the OBG bike path, UT repair weld No.BK004-ASD1-022-003. The welder is identified as #044541. ZPMC QC is identified as Mr. Wang Chang Xin. The welding variables recorded by QC appear to comply with WPS-345-SMAW-1G(1F)-REPAIR. The weld repair report is identified as WR18893.

FCAW in the 2F position for the OBG Bike path , weld No.BK004-A1-056-005. The welder is identified as #042218. ZPMC QC is identified as Mr. Shao Hai Lang . The welding variables recorded by QC appear to comply with WPS-B-T-2132-ESAB.

SMAW in the 2G position for the OBG Bike path , weld No.BK008-A1-002-043. The welder is identified as #040655. ZPMC QC is identified as Mr. Yu Dong Ping . The welding variables recorded by QC appear to comply with WPS-B-P-2212-Tc-U4c.

BAY#8

This QA Inspector observed the following work in progress:

SMAW in the 1G position for the OBG bike path, UT No.BK004-ASD1-068-001. The welder is identified as #067904. ZPMC QC is identified as Mr. Feng Ya Jun . The welding variables recorded by QC appear to comply with WPS-B-P-2211-B-U2.

FCAW in the 2G position for the OBG bike path, weld No.BK004-A8-061-007. The welder is identified as #500405. ZPMC QC is identified as Mr. Feng Ya Jun. The welding variables recorded by QC appear to comply with WPS-B-T-2232-ESAB.

SMAW in the 2F position for the OBG Bike path , weld No.BK004-A2-061-019. The welder is identified as #066155. ZPMC QC is identified as Mr. Feng Ya Jun. The welding variables recorded by QC appear to comply with WPS-B-P-2112-PLUG.

Ultrasonic Testing (UT) at Bay#11

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as bike path weld joint.

The weld designation reviewed is as follows:

BK004-A5-023-002

Visual Inspection Before install bottom cover plate

Visual inspection of internal welds and surface cleaning carried out before install the bottom cover plate, the bike path is identified as BK004A-0023. Locations where need additional grinding and cleaning marked and repaired

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work carried out ZPMC personnel.

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



## Summary of Conversations:

No relevant conversations

## 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 150-0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Bera,Subhasis

Quality Assurance Inspector

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**Reviewed By:** Dsouza,Christopher

QA Reviewer