

**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-019699**Date Inspected:** 24-Jan-2011**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. Xu Le Feng.**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:

This QA Inspector observed the following work in progress:

**BAY 10:****Repair welding, SMAW Process:**

This QA Inspector observed ZPMC qualified welding personnel identified as 040581, 040582, 057220 Perform Shielded Metal Arc Welding (SMAW) on OBG Bike path BK17 suspending bracket edge plate. Plate identified as BKX51A weld build up 50mm. ZPMC QC Identified as Jiang Xiang Bo with critical welding repair report CWR-B-CWR1868. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F) Repair.

**Magnetic Particle Testing:**

This QA Inspector observed AB/F Magnetic Particle Testing Inspector, performed MT on OBG Bike path Stringer plate. Joint identified as BK009A3-001-005, 006, 485, 405, 580. For more information see attached picture number 1.

**Repair welding, FCAW Process:**

# WELDING INSPECTION REPORT

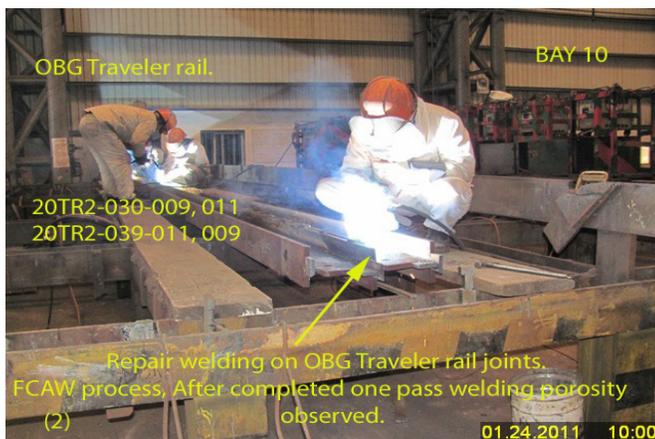
( Continued Page 2 of 3 )

This QA Inspector observed ZPMC qualified welding personnel identified as 052763, 040458 Perform Flux Core Arc Welding (FCAW) on OBG Traveler Rail. Joint identified as 20TR2-030-009, 011. ZPMC CWI Identified as Guo Yan Fei with Temporary welding repair report WRR-B-WR14292 and WR-14293 after completed one pass of welding porosity observed on weld. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-1G (1F) ESAB-Repair.

## Repair welding, FCAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040367, 047353 Perform Flux Core Arc Welding (FCAW) on OBG Traveler Rail. Joint identified as 20TR2-039-009, 011. ZPMC CWI Identified as Guo Yan Fei with Temporary welding repair report WRR-B-WR14320, and WR-14316 after completed one pass of welding porosity observed on weld. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-1G (1F) ESAB-Repair. For more information see attached picture number 2 and 3.

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.

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

## 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: 150002048250, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Gaikwad,Shailesh	Quality Assurance Inspector
----------------------	------------------	-----------------------------

---

<b>Reviewed By:</b>	Clifford,William	QA Reviewer
---------------------	------------------	-------------