

**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-020271**Date Inspected:** 05-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** 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:** 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:

OBG Seg 13AW:

Repair welding of weld joint no: SEG3013AA-053 [Floor Beam (FB) 3193A to Edge Plate (EP) 3020D, complete joint penetration (CJP) weld at Panel Point (PP) 119+1500]. The welder is identified as 066261 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 Zhang Ling. The welding variables recorded by this 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 20128 Rev-0.

Repair welding of weld joint no: SEG3013AA-078 (FB3202A to EP3020F, CJP weld at PP120). The welder is identified as 066261 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhang Ling. The welding variables recorded by this QC appeared to comply with

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WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per WRR: B-WR 20128 Rev-0.

OBG Seg 13CW:

The SMAW process on weld joint no: DP3135-023 [X4079N to X4127C of Deck Panel (DP) 3135A, CJP weld at PP121]. The welder is identified as 066674 and was observed welding in the 3G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-P-2213-TC-U4b-FCM-1.

The SMAW process on weld joint no: DP3148-246 (X4079L to X4127C of DP3135A, CJP weld at PP121.5). The welder is identified as 037840 and was observed welding in the 3G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-P-2213-TC-U4b-FCM-1.

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3015C-010 [Deck Panel Diaphragm (of DP3144A) to FB3235, CJP weld at PP124.5]. The welder is identified as 201583 and was observed welding in the 2G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

OBG Seg 14W:

The SMAW process on weld joint no: SEG3020E-058 [Longitudinal Diaphragm (LD) 3048A to I-stiffener on FB3344A, CJP weld at PP128.3]. The welder is identified as 067765 and was observed welding in the 4G position. ABF QA was identified as Wang Jiang Hua. The welding variables recorded by QA appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

This QA Inspector observed ZPMC personnel performing fit-up of X4881C with DP3174. ABF QA was identified as Shen Jian. See attached photo 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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<b>Inspected By:</b>	Wadkar,Sailesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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