

**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 #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020348**Date Inspected:** 05-Feb-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. Shao Jian Yuan.**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 Trial Assembly & bay14**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy 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 # 14

Flux Cored Arc (FCAW) welding of Weld Joint DP3174-001-173(14W deck panel diaphragm), And Welder is identified as 067888; ZPMC Quality Control (QC) is identified as Mr. Shao Jian Yuan. The welding variables appeared to comply with the Applicable WPS-B-T-2132-ESAB.

FCAW welding of Weld Joint DP3172-001-296(14 West), And Welder is identified as 048433; ZPMC Quality Control (QC) is identified as Mr. Shao Jian Yuan. The welding variables appeared to comply with the Applicable WPS-B-T-2132-ESAB.

FCAW welding of Weld Joint DP3172-001-341(14 West), And Welder is identified as 203871; ZPMC Quality Control (QC) is identified as Mr. Shao Jian Yuan. The welding variables appeared to comply with the Applicable WPS-B-T-2132-ESAB.

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

SMAW welding of Weld Joint DP3175-001-144/148(14W deck panel diaphragm ), And Welder is identified as 037779/068493; ZPMC Quality Control (QC) is identified as Mr. Shan Jian. The welding variables appeared to comply with the Applicable WPS-B-P-2212-TC-U4b-FCM.

SMAW welding of Weld Joint DP3175-001-043(14W deck panel diaphragm ), And Welder is identified as 067904; ZPMC Quality Control (QC) is identified as Mr. Shan Jian. The welding variables appeared to comply with the Applicable WPS-B-P-2212-TC-U4b-FCM.

SMAW welding of Weld Joint SEG3013AA-001-078(13AW, CB Side ), And Welding Repair Report(WR)B-WR20128, Welder is identified as 066002; ZPMC Quality Control (QC) is identified as Mr. Qiu Wen. The welding variables appeared to comply with the Applicable WPS-345-SMAW-2G(2F)-FCM-Repair-1.

SMAW welding of Weld Joint SEG3013AA-001-053(13AW, CB Side ), And Welding Repair Report(WR)B-WR20128, Welder is identified as 066261; ZPMC Quality Control (QC) is identified as Mr. Qiu Wen. The welding variables appeared to comply with the Applicable WPS-345-SMAW-2G(2F)-FCM-Repair-1.

SMAW welding of Weld Joint SEG3020D-052(14W), And Critical Welding Repair Report(CWR)B-CWR2734, Welder is identified as 066038; ZPMC Quality Control (QC) is identified as Mr. Wang Jiang Hua. The welding variables appeared to comply with the Applicable WPS-345-SMAW-2G(2F)-FCM-Repair-1.

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.

### **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 (15000422372), who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Tharikoppada,Reddy	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

---