

**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-020760**Date Inspected:** 18-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:** 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:

West Grillage:

Repair welding of weld joint nos: SA712C-265 and 259, complete joint penetration (CJP) weld. The welder is identified as 047864 and was observed welding in the 1G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC Quality Control (QC) was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS):

345-SMAW-1G(1F)-FCM-Repair. Repair welding was done as per Critical Welding Repair Report (CWR): CWR 2629 Rev-3.

OBG Seg 13AW:

The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3013-009 [Deck Panel (DP) 3119A to

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

DP3120A, CJP weld]. The welder is identified as 066734 and was observed welding in the 1G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by QC appeared to comply with WPS: B-T-223(2)1T-ESAB-1. Magnetic Particle Testing (MT) was also observed to be done (by ABF MT personnel); after completion of root-pass of the weld. See attached photo for further information.

The FCAW process on weld joint no: Seg3013-006 (DP3122A to DP3123A, CJP weld). The welder is identified as 066734 and was observed welding in the 1G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by QC appeared to comply with WPS: B-T-223(2)1T-ESAB-1.

Repair welding of weld joint no: Seg3013AA-044 [I-rib on Edge Panel (EP) 3020 to Floor Beam at PP119+1500, CJP weld]. The welder is identified as 066261 and was observed welding in the 4G position. Welding process was identified as SMAW. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per CWR: 2796 Rev-0.

Seg 13BW:

Repair welding of weld joint no: Seg301S-058 [K-Plate to Side Panel, CJP weld]. The welder is identified as 066443 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per WRR: B-WR 20254 Rev-0.

OBG Seg 14W:

Repair welding of weld joint no: SEG3020BB-019 [Sub Assembly Vertical Shear Plate (VSP) to Bottom Panel (BP), CJP weld]. The welder is identified as 066398 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per CWR: 2752 Rev-1.

The SMAW process on weld joint no: DP3172-019 (Deck Panel to diaphragm, CJP weld). The welder is identified as 067520 and was observed welding in 2G position. ABF QA was identified as Shen Jian. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-TC-U4b-FCM-1.

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

### 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.

---

---

# WELDING INSPECTION REPORT

*( Continued Page 3 of 3 )*

---

---

---

<b>Inspected By:</b>	Wadkar,Sailesh	Quality Assurance Inspector
----------------------	----------------	-----------------------------

---

<b>Reviewed By:</b>	Peterson,Art	QA Reviewer
---------------------	--------------	-------------

---