

**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-021496**Date Inspected:** 06-Mar-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:** An Qing Xiang.**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:

The Flux Cored Arc Welding (FCAW) process on weld joint nos: Seg3013H-154, 155, 164 and 165 [X4863 stiffener to Grillage, complete joint penetration welds (CJP) PP119-1500]. The welder is identified as 066912 and was observed welding in 1G position. ZPMC Quality Control (QC) was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): B-T-2231-ESAB.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: Seg3013AH-009 [X4863M stiffener to K-Plate (KP) 3009A, CJP weld at PP118.65]. The welder is identified as 066361 and was observed welding in 4G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

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The SMAW process on weld joint no: Seg3013AH-080 (X3864J stiffener to KP3015A, CJP weld at PP119+1500). The welder is identified as 067829 and was observed welding in 4G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

This QA Inspector observed ABF MT personnel performing Magnetic Particle Testing (MT) on weld joint no: Seg3013-012 [Deck Panel (DP) 3116A to DP3117A, CJP splice joint]. MT was observed to be done after completion of root / hot pass. ZPMC QC was identified as Liu Feng. See attached photo for further information.

OBG Seg 14W:

The FCAW process on weld joint no: Seg3020AW-089 [Side Panel (SP) 3131A to SP3144B, CJP weld]. The welder is identified as 066695 and was observed welding in 2G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

The FCAW process on weld joint no: Seg3020AE-067 (I-rib stiffener to SP3140E, fillet weld). The welder is identified as 047896 and was observed welding in 2F position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2132-ESAB.

The FCAW process on weld joint no: Seg3020N-118 (X4891B to B3089A, fillet weld). The welder is identified as 066673 and was observed welding in 2F position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2132-ESAB.

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.

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<b>Inspected By:</b>	Wadkar,Sailesh	Quality Assurance Inspector
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<b>Reviewed By:</b>	Peterson,Art	QA Reviewer
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