

**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-021836**Date Inspected:** 17-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:** Zhou Zhong Hai**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 COMPONENT**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Subhasis Bera was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

In process Inspection

Trial Assembly

This QA Inspector observed the following work in progress:

SMAW in the 1G position for the OBG Segment 12AE, weld No. OBE12C-030. The welder is identified as #044504. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS-B-P-2211-Tc-U4b-FCM-1. The welding variables were recorded at, Amperage 145, volts 24.5. The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 1G position for the OBG Segment 12CE, weld No. OBE12C-026. The welder is identified as #067752. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS-B-P-2211-Tc-U4b-FCM-1. The welding variables were recorded at, Amperage 153, volts 24. The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 1G position for the OBG Segment 12BE, weld No. OBE12C-014. The welder is identified as #044504. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply

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with WPS-B-P-2211-Tc-U4b-FCM-1. The welding variables were recorded at, Amperage 150, volts 24.6 .The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 4G position for the OBG Segment 12AE, UT repair weld No. CA6501-002. The welder is identified as #067752. ZPMC QC is identified as Mr. Zhou Zhong Hai. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-FCM-REPAIR-1. The weld repair report is identified as CWR2860R0. The welding variables were recorded at, Amperage 157, volts 24.3.The In-process SMAW appears to be progressing in compliance with approved contract documents.

Magnetic Particle Testing (MPT) for Hold back Joints at 12AE

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for OBG Segment 12AE holdback welds at trial assembly Area . This QA inspector generated a (MT) report for this date .This area was previously tested and accepted by ABF QC MT technicians.

The Weld Designations are as follows

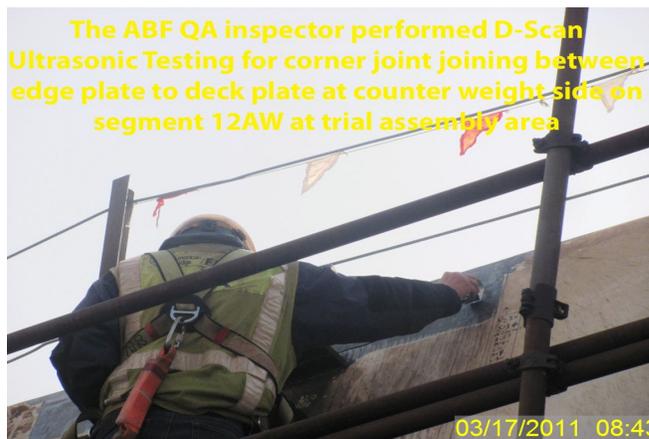
BP3018-001-034,035,042,043

SEG3001Z-129,130,139,140

FB3031-001-003,004,013,014,015,016

FB3039-001-003,004,013,014,015,016

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



## Summary of Conversations:

No relevant conversations

## 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 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Bera,Subhasis	Quality Assurance Inspector
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<b>Reviewed By:</b>	Dsouza,Christopher	QA Reviewer
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