

**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-022040**Date Inspected:** 14-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 Shielded Metal Arc Welding (SMAW) process on weld joint nos: Seg3013G-028, 030, 034 and 036 [I-rib of Deck panel (DP) 3116A to Floor Beam (FB) 3192A, complete joint penetration (CJP) weld at panel point (PP) 119+1500]. The welder is identified as 066443 and was observed welding in 3G position. 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): B-P-2213-TC-U4b-FCM-1.

The SMAW process on weld joint no: Seg3013-009 (DP3120A to DP3119A, CJP splice weld). The welders are identified as 067609 and 069683 and were observed welding in 4G position. ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

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The SMAW process on weld joint no: Seg3013-234 [DP diaphragm of Sub Assembly (SA) 7510A to FB3194A, CJP weld, at PP119.65]. The welder is identified as 066361 and was observed welding in 3G position. ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with WPS: B-P-2213-B-U2-FCM-1.

The SMAW process on weld joint no: Seg3013-254 (DP diaphragm of SA7510A to FB3200A, CJP weld, at PP120]. The welder is identified as 037996 and was observed welding in 3G position. ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with WPS: B-P-2213-B-U2-FCM-1.

OBG Seg 14W:

Repair welding of weld joint nos: Seg3020U-587 [Anchor Plate (AP) 3032A to Longitudinal Diaphragm (LD) 3049A, CJP weld, at PP126]. The welder is identified as 067588 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per Critical Welding Repair Report (CWR): 2854 Rev-0.

The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3020H-085 [I-rib stiffener (RS3533) on Bottom Panel (BP) 3091A to FB3331A, CJP weld at PP127.5]. The welder is identified as 204730 and was observed welding in 3G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

The FCAW process on weld joint no: Seg3020K-306 [I-rib stiffener (RS3533) on BP3091A to SA3409A, CJP weld at PP127.3]. The welder is identified as 204730 and was observed welding in 3G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

This QA inspector performed a visual & dimensional inspection of cope holes on Bearing Stiffener plates (on AP3032A). During the visual inspection, on some of the cope holes, weld spatter was observed at several locations. All the locations were marked up and were recorded on the data sheet and submitted to the Task Leader for review and disposition. The locations of the weld spatter were reported to the ZPMC QC/ CWI, identified as Mr. An Qing Xiang and ABF QA, identified as Mr. Xiao Jun Peng. The dimensional / visual inspection of these cope holes were still in process on this date.

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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