

**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-022043**Date Inspected:** 19-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:** Liu Hua Jie.**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:

Trial Assembly:

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: Seg3013A-002 [Side Panel (SP) 3100A to Bottom Panel (BP) SA3013B, complete joint penetration (CJP) weld at panel point (PP) 119.65]. The welder is identified as 067572 and was observed welding in 4G 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-2214-B-U2-FCM-1.

The SMAW process on weld joint no: Seg3013A-004 (SP3099A to SA3110A, CJP weld at PP119-1500). The welder is identified as 067764 and was 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: Seg3013R-209 [I-Rib stiffener (RS3459A) on BP (SA3168A) to Floor Beam (FB) 3172A, CJP weld at PP117.5]. The welder is identified as 067588 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-Tc-U4b-FCM-1.

The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3013S-168 (RS3459A on SA3168A to FB3175A, CJP weld at PP117.5). The welder is identified as 215676 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-T-2233-ESAB.

OBG Seg 13AE:

The SMAW process on weld joint no: Seg3007AC-009 (SP to BP, CJP weld at PP118.35). The welder is identified as 037743 and was 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.

OBG Seg 13AW and Seg 13AE:

ZPMC personnel performing base metal repair welding on Bottom Panel after removal of temporary attachments. Welding process was identified as SMAW. Welders were identified as 069683 and 200113 and were observed welding in 4G position. Repair welding was done as per Critical Welding Repair Report (CWR): 2841 Rev-0. Magnetic Particle Testing was observed to be done (by ABF) before performing base metal repair welding. See attached photo for further information.

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

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

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