

**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-022128**Date Inspected:** 23-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 4G position for OBG segment 12BW, welding of weld No. OBW12C-021. The Welder is identified as 041713. ZPMC Quality Control is identified as Mr. Zhou Peng. The welding variables recorded by QC personnel appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1. The welding variables were recorded at, Amperage 155, volts 23.2. The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 4G position for OBG segment 12AW, welding of weld No. OBW12C-033. The Welder is identified as 046709. ZPMC Quality Control is identified as Mr. Zhou Peng. The welding variables recorded by QC personnel appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1. The welding variables were recorded at, Amperage 143, volts 24. The In-process SMAW appears to be progressing in compliance with approved contract documents.

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SMAW in the 4G position for OBG segment 12CE, welding of weld No. OBE12C-029. The Welder is identified as 067752. ZPMC Quality Control is identified as Mr. Wang Li Yang. The welding variables recorded by QC personnel appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1. The welding variables were recorded at, Amperage 152, volts 25.2. The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 4G position for OBG segment 12BE, welding of weld No. OBE12C-021. The Welder is identified as 044504. ZPMC Quality Control is identified as Mr. Wang Li Yang. The welding variables recorded by QC personnel appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1. The welding variables were recorded at, Amperage 145, volts 25. The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 4G position for OBG segment 13AW, welding of weld No. SEG3013A-009. The Welder is identified as 069683. ZPMC Quality Control is identified as Mr. Shen Jian Bao. The welding variables recorded by QC personnel appeared to comply with WPS-B-P-2214-B-U2-FCM-1. The welding variables were recorded at, Amperage 156, volts 24.6. The In-process SMAW appears to be progressing in compliance with approved contract documents.

During Quality Assurance random in-process observations of the fabrication of segment 13AW, this Quality Assurance Inspector (QA) discovered the following issue that the ZPMC personnel have performed Free Hand Flame Cutting more than 300mm in length of deck plate at cross beam side area. OBG Segment 13AW is currently located at trial assembly area. This QA inspector informed to ABF QA Mr. Wen Jian Bao and ZPMC QC Mr. Shen Jian Bao regarding this matter. For further information, please see the attached pictures below. This QA did not generate any incident report on this date.

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



## Summary of Conversations:

No relevant conversations

## Comments

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## WELDING INSPECTION REPORT

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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 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
<b>Reviewed By:</b>	Dsouza,Christopher	QA Reviewer

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