

**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-022141**Date Inspected:** 26-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:** Sun Tian Liang**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**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 14, OBG 13BW (NWIT # 08631)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

SEG3014D-178, 213

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 14

OBG Seg 14W:

Repair welding of weld joint no: DP3168-001-003. The welder is identified as 045196 and was observed welding in the 2G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was

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identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR 20205 Rev-0.

Repair welding of weld joint no: DP3168-001-071, 062. The welder is identified as 067588 and was observed welding in the 3G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR 20205 Rev-0.

The FCAW process on weld joint no: SEG3020B-053 [Floor Beam (FB) 3350A/FB3347A to Floor Beam (FB) 3346A, CJP weld at PP128.7]. The welder is identified as 066239 and was observed welding in 3G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

The FCAW process on weld joint no: SEG3020C-053 [Floor Beam (FB) 3348A to Floor Beam (FB) 3350A/FB3347A, CJP weld at PP128.7]. The welder is identified as 045175 and was observed welding in 3G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020AQ-025 [Top anchorage plate PL3519A to Side Plate (SP) 3144B, CJP weld in between panel point PP125 to PP127]. The welders are identified as 051348, 045246 and 069841 and were observed welding in 4G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-Tc-U5b-FCM-1.

OBG Seg 13BW

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3014M-001 [Corner Assembly (CA) 3015A to Side Plate (SP) 3094A, CJP weld]. The welder is identified as 066621 and was observed welding in 4G position. ZPMC QC was identified as Mr. Zhang Lin. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-Tc-U4b-FCM-1.

OBG Seg 13CW

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3015A-014 [Corner Assembly (CA) 3016A to Side Plate (SP) 3097A, CJP weld]. The welder is identified as 066621 and was observed welding in 4G position. ZPMC QC was identified as Mr. Zhang Lin. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-Tc-U4b-FCM-1.

OBG Seg 13BW+13CW

The Shielded Metal Arc Welding (SMAW) process on weld joint no: OBW13C-006 [Side Panel (SP) 3094A to Side Plate (SP) 3097A, CJP weld]. The welder is identified as 067179 and was observed welding in 4G position. ZPMC QC was identified as Mr. Zhang Lin. The welding variables recorded by this QC appeared to comply with

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WPS: B-P-2214-B-U2-FCM-1.

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

**Summary of Conversations:**

Only general conversation was held between QA and QC concerning this project.

**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 : 15000422372, who represents the Office of Structural Materials for your project.

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