

**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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022553**Date Inspected:** 05-Apr-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) Chanxing Island**Location:** Shanghai, China

**CWI Name:** Mr. LI YANG  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** Yes No N/A  
**Approved WPS:** Yes No N/A  
**Delayed / Cancelled:** Yes No N/A

**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Santhosh Ramakrishna Pillai was present during the times noted above for observations relative to fabrication work of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China.

This QA inspector randomly observed the following work:

## 1. INPROCESS:

Orthotropic Box Girder (OBG) at Trial Assembly Area:

ZPMC welding personnel performing Shielded Metal Arc Welding of Repair weld for the deck panel diaphragm to deck panel diaphragm weld joint located on 13AE at Panel Point (PP-118). The weld is designated as SEG3007Q-005. The welder is identified as 066422. ZPMC QC Mr. LIU HUA JIE was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1. The weld repair report number is named as WR20507.

ZPMC welding personnel performing Shielded Metal Arc Welding of Repair weld for the floor beam to side plate weld joint located on 13AE at Panel Point (PP-119-1500). The weld is designated as SEG3007AD-026. The welder is identified as 037743. ZPMC QC Mr. LIU HUA JIE was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-4G

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(4F)-FCM-Repair-1. The weld repair report number is named as WR20494.

ZPMC welding personnel performing Shielded Metal Arc Welding of Repair weld for the floor beam to side plate weld joint located on 13AE. The weld is designated as SEG3007AD-045. The welder is identified as 067183. ZPMC QC Mr. LIU HUA JIE was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. The weld repair report number is named as WR20494.

ZPMC welding personnel performing Shielded Metal Arc Welding of Repair weld for the bottom plate to side plate weld joint located on CB-17 at Panel Point (PP-112). The weld is designated as CB3001A-017-005. The welder is identified as 066459. ZPMC QC Mr. LI YANG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1. The weld repair report number is named as CWR-2890.

ZPMC welding personnel performing Shielded Metal Arc Welding of Repair weld for the bottom plate to side plate weld joint located on CB-17 at Panel Point (PP-110). The weld is designated as CB3001A-017-017. The welder is identified as 066459. ZPMC QC Mr. LI YANG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1. The weld repair report number is named as CWR-2891. Further weld detail mention in attached picture.

ZPMC welding personnel performing Shielded Metal Arc Welding of Repair weld for the deck plate to side plate weld joint located on CB-17 at Panel Point (PP-110). The weld is designated as CB3001A-017-014. The welder is identified as 066459. ZPMC QC Mr. LI YANG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1. The weld repair report number is named as CWR-2892. Further weld detail mention in attached picture.

ABF Quality Assurance (QA) personnel performing Magnetic particle Testing (MT) for the drainage plate weld joint located on 12BW+12CW at counter weight side. The weld is designated as CA 3012-224 ~ 227.

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

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## Summary of Conversations:

No relevant 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 150-0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Pillai,Santosh

Quality Assurance Inspector

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**Reviewed By:** Miller,Mark

QA Reviewer