

**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-023720**Date Inspected:** 17-May-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 Yard:

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

This QA Inspector, along with Mr. Umesh Gaikwad; performed inprocess Visual Inspection of welds (of Seg 13AW) at Panel Points (PP) 117.5, PP118 and PP118.35. Visual Inspection was done for the welds between Longitudinal Diaphragm (LD) 3034A to Edge Panel (EP) 3023A (for the welds at the inside of the segment). Besides various locations on the EP to FB welds, where the cope holes needs to be profiled corrected, following welds were observed to have toe cracks. Details are as mentioned below.

- 1) Seg3013R-032 and 033 (fillet welds at PP117.5 – identified earlier on Dt: 05/12/11).
- 2) Seg3013P-018 and 027 (fillet welds at PP118).
- 3) Seg3013P- 028, 017, 020, 022, 026, 028 (PP118).
- 4) Seg 3013M-024, 028 (PP118.35).

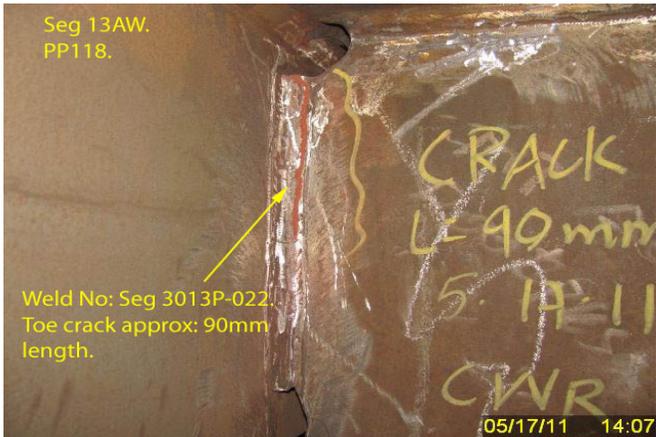
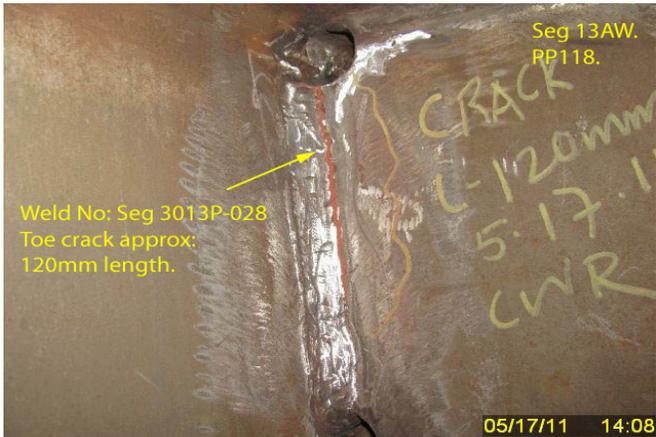
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5) Seg 3013Q-007 (PP118).

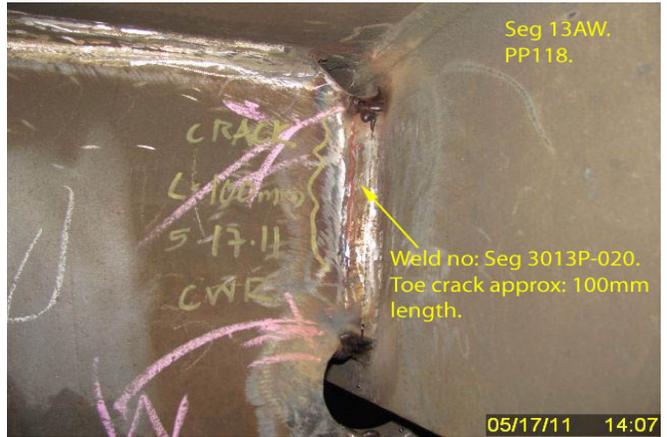
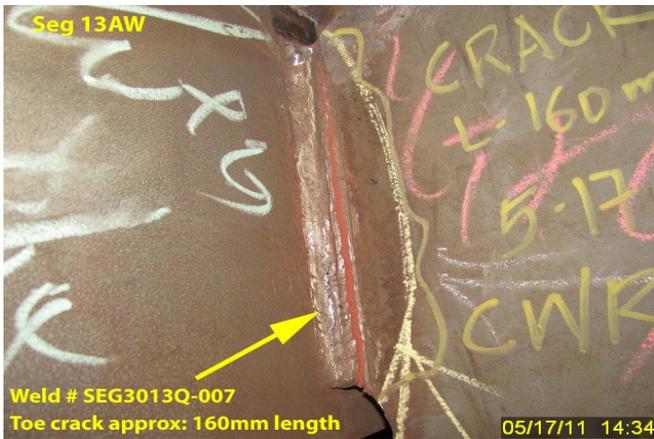
See attached photo for details.

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



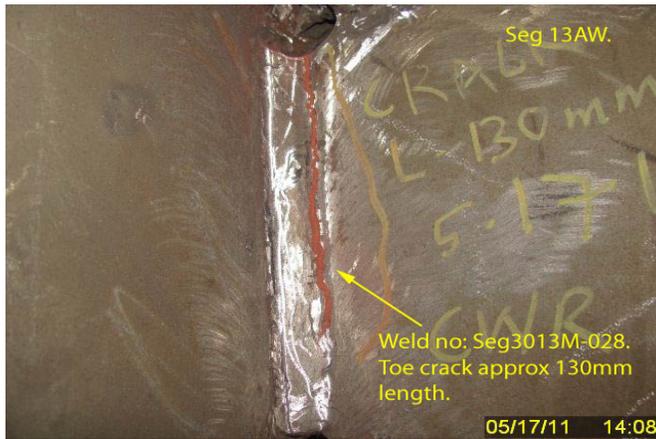
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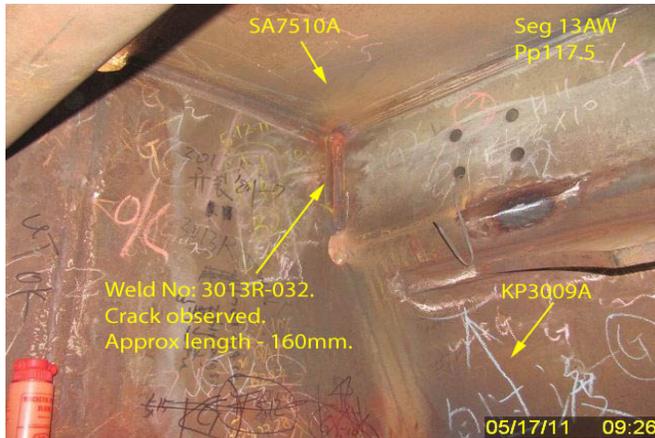


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## Summary of Conversations:

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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**Inspected By:** Wadkar,Sailesh

Quality Assurance Inspector

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**Reviewed By:** Peterson,Art

QA Reviewer