

**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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011972**Date Inspected:** 05-Feb-2010**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

<b>CWI Name:</b>	NA	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG.	

**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) 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 observed and/or found the following:

Outside Yard:

SEG 7DW.

- During inprocess visual inspection this QA Inspector observed ZPMC personnel grinding the 50mm radii at the bottom end of Floor Beam Flange of X7k Flange Plate.
- On DT: 02/04/10, as per Welding Repair Report (WRR) B-WR10642, repair welding was done on this R50mm area for its correction / rectification. Welding process used was Shielded Metal Arc Welding (SMAW). Welder was identified as 045133. ZPMC QC was identified as Wang Wei Ming. The welding variables recorded by QC appeared to comply with the applicable WPS: 345-SMAW-1G (1F)-Repair.
- After completion of grinding of R50mm radii (on PP56, PP57 & PP58), this corrected area appeared to comply with drawing or contract documents.
- For details, refer attached photos.

SEG 9BE:

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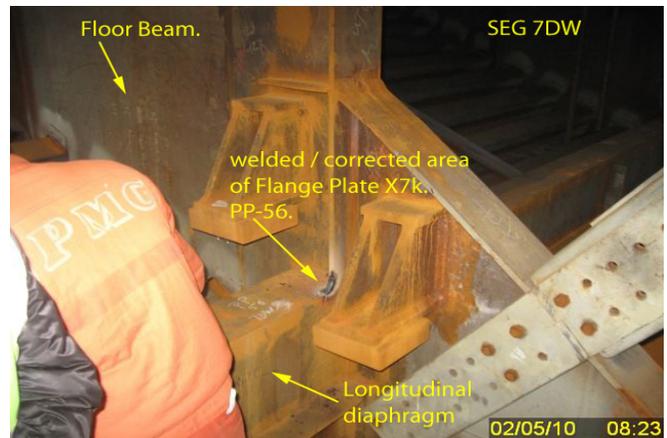
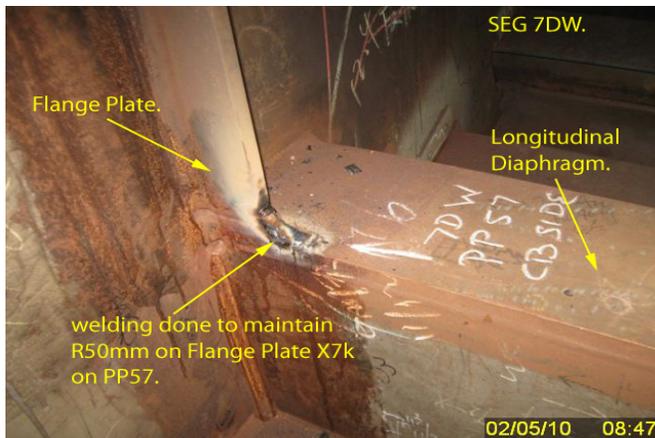
- This QA inspector performed in process Visual Inspection of the below mentioned fillet welds between Floor Beam and Floor Beam Flange.

- 1) PP74-FB020-007 – 092, 093.
- 2) PP74-FB003-142 – 004, 005.
- 3) PP74-FB012-024 – 001, 002.
- 4) PP75-FB012-023 – 002.
- 5) PP75-FB024-006 – 093.
- 6) PP75-FB003-133 – 005.

- These welds were previously MT tested and accepted by ZPMC Quality Control (QC) personnel. As per contract documents, ZPMC QC is required to perform 25% MT of these welds.

- Visually, these welds appeared to comply with the contract documents.
- The member(s) are identified as OBG components – Floor Beam & Floor Beam Flange.

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.

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# WELDING INSPECTION REPORT

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## 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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<b>Inspected By:</b>	Wadkar,Sailesh	Quality Assurance Inspector
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<b>Reviewed By:</b>	Hall,Steven	QA Reviewer
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