

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-012435**Date Inspected:** 07-Mar-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**CWI Name:** Li Yang**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune 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:

OBG # TRIAL ASSEMBLY YARD

Segment: LIFT 7 East

This QA Inspector along with Caltrans QA Mr. Surendra Prabhu performed Individual Inspection for the Flatness of Panels Segment 7AE, 7BE and 7CW between Panel Point (PP) 48 and PP 55.

This QA Inspector randomly observed the following work in progress:

Segment # 6CE-PP47

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 054467 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA030-005; The Welding Repair Report (WRR) was B-WR10758. ZPMC QC is identified as Mr. Zhong Yong Gang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-1G (1F)-FCM-Repair-1. See the attached

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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below Photo.

Segment # 6AW-PP39

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 048659 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SSD11A-PP039-168; The Welding Repair Report (WRR) was B-WR10688. ZPMC QC is identified as Mr. Zhong Yong Gang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. See the attached below Photo.

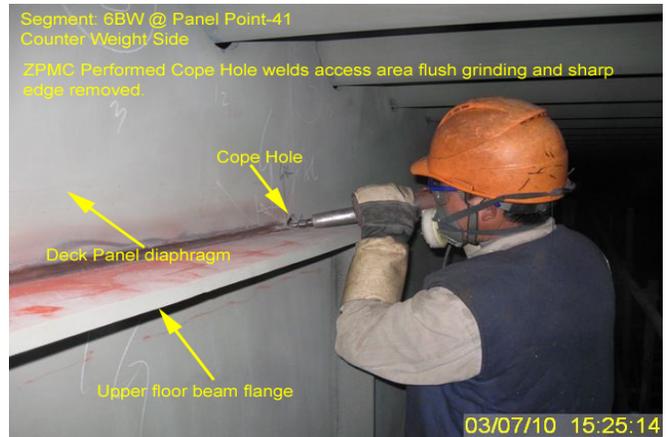
Segment# 6BW-PP41

This QA inspector observed, ZPMC performed cope hole weld access area flush grinding and sharp edge removed. All the details see the attached below Photo.

Segment# 6AW-PP38

This QA inspector observed, ZPMC qualified welding personnel identified as 037743 perform Shielded Metal Arc Welding (SMAW), Deposition of weld metal (buttering / build up) at 6AW strut plate end inner stiffener. The Welding Repair Report (WRR) was B-WR10880. ZPMC QC is identified as Mr. Feng Ya Jun.

Segment: 6AW@ Panel Point-39 Cross Beam-6



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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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

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<b>Inspected By:</b>	Prabhune,Manoj	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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