

**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-012582**Date Inspected:** 08-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, Wu Chi Cheng**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: 6-West (Individual Survey by Caltrans)

This QA Inspector along with Caltrans QA Mr. Surendra Prabhu performed Joint Inspection for the Deck panel to Deck panel diaphragm offset measured for LIFT: 6-West between Panel Point (PP) 39, PP-40 and PP-41. The measured readings were fed in spread sheet, generated the report and submitted to the Task Leader for further action.

Segment#9CE-PP72 (Individual Survey by Caltrans)

This QA Inspector along with Caltrans QA Mr. Surendra Prabhu performed Joint Inspection for the Bottom Plate Skin Flatness measured. See the attached below Photo.

This QA Inspector randomly observed the following work in progress:

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# WELDING INSPECTION REPORT

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Segment# 6AW-PP38

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 048659 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SSD10A-PP38-170; The Welding Repair Report (WRR) was B-WR10687. ZPMC QC is identified as Mr. Wan Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-4G (4F)-FCM-Repair-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 phone: 15000422372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Prabhune,Manoj

Quality Assurance Inspector

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**Reviewed By:** Miller,Mark

QA Reviewer