

**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-012759**Date Inspected:** 21-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:** 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**

This QA Inspector randomly observed the following work in progress:

Segment # 7AW-PP48

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 048659 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG033A-004; The Critical Welding Repair Report (CWRR) was B-CWR1212. ZPMC QC is identified as Mr. Zhang Hai Tao. 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# 7AE

During in process visual inspection of 7BE, This QA Inspector observed ZPMC Quality Control (QC) personnel, identified as Mr. Tang Xing Shan, performing Ultrasonic Testing (UT) of the Web to Web Complete Joint Penetration (CJP). For more comprehensive information refer the attached Photo.

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# WELDING INSPECTION REPORT

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## Segment# 7BE

This QA inspector observed, ZPMC qualified welding personnel identified as 037743 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG036A-028; ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2212-TC-U4b-FCM-1

## Segment # 7CW

### Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 066422 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA037-004; The Critical Welding Repair Report (CWRR) was B-CWR1228. ZPMC QC is identified as Mr. Sun Bai Zheng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1.

## Segment # 7AE

### Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 057359 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA036-004; The Critical Welding Repair Report (CWRR) was B-CWR1224. ZPMC QC is identified as Mr. Sun Bai Zheng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1.



## 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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## WELDING INSPECTION REPORT

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**Inspected By:** Prabhune,Manoj

Quality Assurance Inspector

**Reviewed By:** Miller,Mark

QA Reviewer