

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-012782**Date Inspected:** 24-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 Yan Hua.**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.**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 9DW:

This QA Inspector observed the following work in progress:

Shielded metal Arc Welding (SMAW) of weld no: SP732B-001 – 097, 098, 100, 101, 103, 104, 106, 107, 109, 110, 112 & 113 (for 9DW). Welder is identified as 045204. ZPMC Quality Control (QC) is identified as Tang Ya Jua. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2112-FCM-1 & WPS-B-P-2114-FCM-1.

SEG 10AE:

This QA Inspector observed the following work in progress:

Repair welding of weld no: SSD16A-PP86-004 (for 10AE). Welder was identified as 058102 performing SMAW. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G (2F)-Repair, as per Weld Repair Report (WRR) No: B-WR8297 Rev-0. This QA Inspector also verified the

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applicable UT report (No: B787-UT-9309R1). ZPMC Quality Control (QC) is identified as Tang Ya Jua. This weld as per drawing is fillet weld. But due to excessive root gap, it is welded as CJP joint.

SEG 9CE:

This QA Inspector observed the following work in progress:

Repair welding of weld no: SSD20A-PP79- 222, 242 & 252 (for 9CE). Welder was identified as 037723 performing SMAW. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2214-TC-U4b-FCM-1, as per approved draft / temporary copy of Weld Repair Report (WRR). This QA Inspector also verified the applicable UT report (No: UT-9E-015). ZPMC Quality Control (QC) is identified as Tang Ya Jua.

SEG 9EW:

This QA Inspector observed the following work in progress:

SMAW of weld no: CA066-001 – 025 to 030, 037 to 042, 049 to 054 & 061 to 066 (for 9EW). Welders are identified as 200569 & 205098. ZPMC Quality Control (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-4113-2.

SMAW of weld no: CA067-001 – 073 to 078 & 085 to 090 (for 9EW). Welder is identified as 066038. ZPMC Quality Control (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-4113-2.

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

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