

**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-012953**Date Inspected:** 23-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 9CE:

This QA Inspector observed the following work in progress:

Repair welding of weld no: SSD20-PP77- 253 & 237 (for 9CE). Welder was identified as 067589 performing Shielded metal Arc Welding (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 9DW:

This QA Inspector observed the following work in progress:

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SMAW of weld no: SP732B-001 – 115, 116, 118, 119, 121, 122, 124, 125, 127, 128, 130 & 131 (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.

Repair welding of weld no: SSD10A-PP80 – 252 (for 9DW). Welder is identified as 066179 performing SMAW. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-4G (4F)-FCM-Repair, as per Weld Repair Report (WRR) No: B-WR11129 (& UT report No: B787-UT-11780). 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 – 073 to 078 & 085 to 090 (for 9EW). Welder is identified as 200569. 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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