

**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-013516**Date Inspected:** 02-May-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:** Tian Lei.**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:

Bay 1: CB15:

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) of weld joints CB202G-045-148/166 & 147/165 and CB202G-046-148/166 & 147/165. Welders are identified as 059450 & 251246. ZPMC Quality Control (QC) is identified as Ai Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2132-3.

Bay 8: CB17:

This QA Inspector observed that no significant work was being performed on this CB at the time when this QA was present.

Outside Yard:

CB10, CB11, CB12, CB13 &amp; CB16:

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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This QA Inspector observed that no significant work was being performed on the above mentioned CB's at the time when this QA was present.

CB14:

This QA Inspector observed the following work in progress:

FCAW of weld joints CB202B-014-002. Welder is identified as 050977. ZPMC QC is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS:

WPS-B-T-2231-B-U2-F.

FCAW of weld joint FB204-044-053 & 054. Welder is identified as 044824. ZPMC QC is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS:

WPS-B-T-2231-B-U2-F.

This QA Inspector also observed ZPMC personnel performing base metal repair on Bottom Panel (BP204A) after removal of the temporary attachments. Bottom Panel of the Cross Beam is identified as Seismic Performance Critical Members (SPCM) and the base metal repair was found to be done without Engineers approval. This QA informed ZPMC QC identified as Mr. Tian Lei & Mr. Guo Yuan Ting and American Bridge Fluor (ABF) QA identified as Mr. Yang Yu of this issue and that an incident report would be generated.

Refer attached photos for reference.

Trial Assembly:

CB 7:

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) of weld joints CB201A-007-001, 003, 013 & 015. Welders are identified as 067609 & 037743. ZPMC QC is identified as Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2214-TC-U4b.

CB 8:

This QA Inspector observed the following work in progress:

SMAW of weld joints SP206-008-045 & 049. Welder is identified as 067764. ZPMC Quality Control (QC) is identified as Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2114-FCM-1.

CB 9:

This QA Inspector observed that no significant work was being performed on this CB at the time when this QA

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# WELDING INSPECTION REPORT

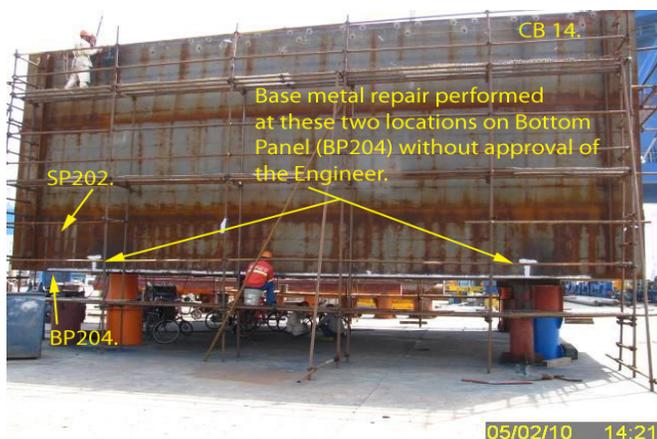
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was present.

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:** Wadkar,Sailesh

Quality Assurance Inspector

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**Reviewed By:** Hall,Steven

QA Reviewer