

**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-014017**Date Inspected:** 16-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:** Mr. Li Yang 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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu 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:

**BLAST SHOP#1**

This QA Inspector performed random visual inspection of North Tower Lift-1 Exterior skin A~E after grit blasting. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA. Repair work is in progress.

Lay Down Yard.

Segment: 10BE.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 005723.

**Visual Testing (VT)**

This QA Inspector performed Random VT of of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. The members are identified as OBG Segment: 10BE-Panel Point (PP)#88.5~89.

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During VT this QA Inspector observed 1 (one) Rounded indication(Appx.04 mm in dia) on angle truss plate weld at PP#88.5 Bike Path side. This weld is joins to angle truss plate to Longitudinal Diaphragm. This QA informed to ZPMC QC identified as Wang wei ming of this issue. As per ZPMC QC weld will be repaired and perform Magnetic Particle Testing. Refer attached photos for reference.

Segment# 10AW.

This QA Inspector Randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) of weld joint SP735-001-300. Welder is identified as 215677. ZPMC Quality Control (QC) is identified as Mr. Tang Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2112-FCM-1.

Segment#11AE/BE.

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

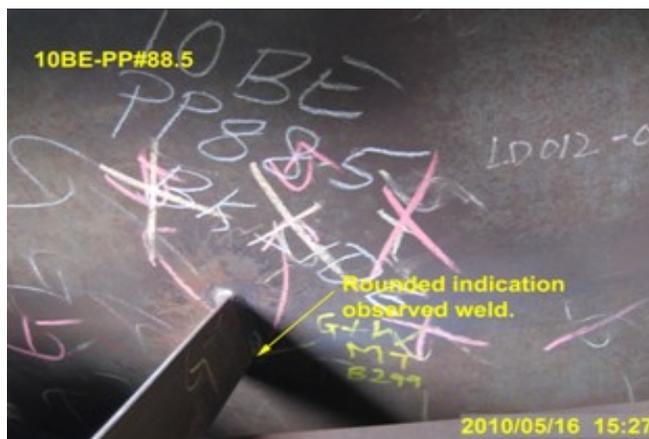
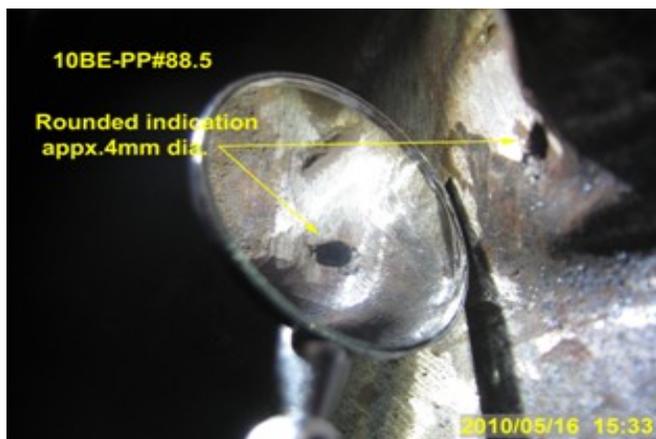
BAY-14

Segment: 12AE.

Flux Cored Arc Welding (FCAW) of weld joint SEG3001AA-004. Welder is identified as 005564. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4b-F.

FCAW of weld joint SEG3001P-001. Welder is identified as 206623. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2233-B-U2-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

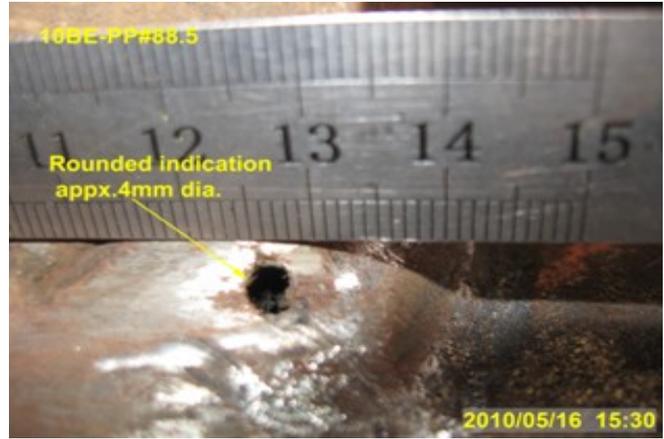


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## Summary of Conversations:

Only general conversation was held between QA and Quality Control (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 15000422372, who represents the Office of Structural Materials for your project.

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

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