

**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-014059**Date Inspected:** 09-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

<b>CWI Name:</b>	Mr. Huang min		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	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:

BAY-5

This QA Inspector Randomly observed the following work in progress:

This QA Inspector observed ZPMC MT Technician Mr. Tan Chao wei was performing Magnetic Particle Testing (MT) for the Traveler Rail bracket weld No: TR6B-PP108-003.

Refer attached photo for reference.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 005694.

**Visual Testing (VT)**

This QA Inspector performed VT of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. The members are identified as OBG Traveler Rail bracket weld Components. Total number of Components Tested: 08 No's. The weld designations are review as follows:

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1. TR6A-PP54, 50, 56, 58.
2. TR5B-PP53, 55, 59, 51.

Signed off following green tag.

1.11138.

BAY-6

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 005697.

Ultrasonic Testing (UT)

This QA performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated UT report for this date. The member is identified as OBG U Rib Connection Plate weld Components. Total number of welds UT Tested: 08 No's. The weld designations are review as follows:

1. USPL1-410,418-001,002.
2. USPL1-429,433-001,002.

Flux Cored Arc Welding (FCAW) on Traveler Rail (TR) bracket weld joint TR6A-PP070-001. Welder is identified as 204342. ZPMC Quality Control (QC) is identified as Mr. Shen jian guo. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U4c-F.

FCAW on TR bracket weld joint TR6A-PP066-001. Welder is identified as 217185. ZPMC Quality Control (QC) is identified as Mr. Shen jian guo. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U4c-F.

BAY-7

Shielded Metal Arc Welding (SMAW) Tack welding on Deck panel weld joint DP3153-001-042. Welder is identified as 049771. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-4112-4.

SMAW Tack welding on Deck panel weld joint DP3142-001-007. Welder is identified as 203204. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-4112-4.

SMAW Tack welding on Deck panel weld joint DP3142-001-009. Welder is identified as 049485. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-4112-4.

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This QA Inspector observed ZPMC Personnel performing Heat Straightening for the DP3082-001-001/002. Heat Straightening was being performed appeared to comply with the Applicable HSR Repot# HSR1 (B)-8450. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang.

BAY-8

SMAW Tack welding on Bike Path weld joint BK004A3-056-025. Welder is identified as 054015. ZPMC Quality Control (QC) is identified as Mr. Liu chuan gang. The welding variables appeared to comply with the Applicable WPS: WPS-B-P-2112.

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 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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