

**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-014067**Date Inspected:** 19-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 Jia / Mr. Chen Xi**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:

**BAY-1**

This QA Inspector Randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW) welding of weld joint 20TR1-045-005. Welder is identified as 251246. ZPMC Quality Control (QC) is identified as Mr. Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U5-F.

FCAW of weld joint 20TR2-049-009. Welder is identified as 216575. ZPMC Quality Control (QC) is identified as Mr. Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U5-F.

**BAY-2**

FCAW of weld joint FB3177-001-012. Welder is identified as 045240. ZPMC Quality Control (QC) is identified as Mr. Zhu Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS:

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WPS-B-T-2232-3.

FCAW of weld joint FB3177-001-092. Welder is identified as 045203. ZPMC Quality Control (QC) is identified as Mr. Zhu Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS:

WPS-B-T-2232-3.

BAY-3

Submerged Arc Welding (SAW) welding of weld joint FB3125-001-007. Welder is identified as 050502. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2221-B-U3c-S-2.

SAW of weld joint FB3127-001-001. Welder is identified as 062406. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS:

WPS-B-T-2221-B-U3c-S-2.

FCAW of weld joint FB3127-001-004. Welder is identified as 208035. ZPMC Quality Control (QC) is identified as Mr. Zhu Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS:

WPS-B-T-2132-3.

During random in process Visual Inspection this QA Inspector observed 1 (one) Crack tack on Floor beam weld No: FB3120-001-015. This QA informed to ZPMC Quality Control (QC) identified as Mr. Zhu Jun and American Bridge/Fluor (AB/F) QA Inspector identified as Mr. Wang wen bin of the above issue, As per ZPMC QC and AB/F QA the Tack weld shall be removed by grinding and perform Magnetic Particle Testing(MT) for verifying no more defects.

Refer attached photos for additional details.

BAY-5

This QA Inspector observed ZPMC Personnel performing Heat Straightening for the Traveler Rail 20TR2-003. Heat Straightening was being performed appeared to comply with the Applicable HSR Repot# HSR1 (B)-8350. ZPMC Quality Control (QC) is identified as Mr. Shen jian guo.

BAY-6

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

BAY-7

FCAW of weld joint DP3109-001-073/074. Welder is identified as 051246. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-4132.

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

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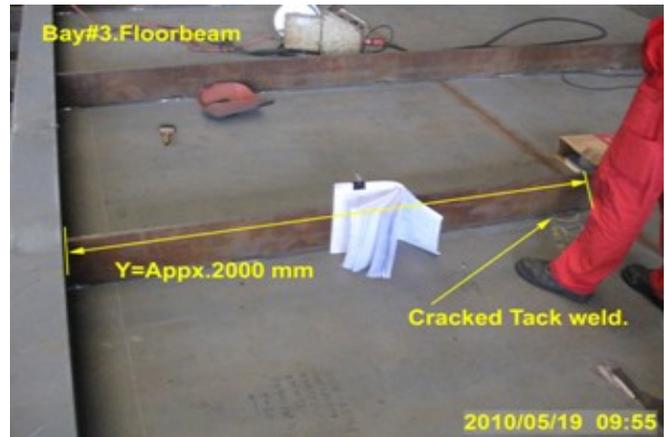
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documents.



## 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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**Inspected By:** Prabhu,Surendra

Quality Assurance Inspector

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**Reviewed By:** Hall,Steven

QA Reviewer