

**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-014431**Date Inspected:** 22-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:** Li Jia.**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 that no significant work was being performed on this CB at the time when this QA was present.

Bay 8: CB17:

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) of weld joints CB3001A-017-008. Welder is identified as 040671. ZPMC Quality Control (QC) is identified as Liu Cheng Guang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2132.

FCAW of weld joints CB3001G-056-001 & 003. Welder is identified as 054459. ZPMC QC is identified as Liu Cheng Guang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2133.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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FCAW of weld joints CB3001G-053-001 & 003. Welder is identified as 040671. ZPMC QC is identified as Liu Cheng Guang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2133.

Outside Yard:

CB11, CB12, CB13 & CB16:

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 that no significant work was being performed on the above mentioned CB's at the time when this QA was present. However, it was observed that the base metal repair on Floor Beam: FB202G-041 is not yet completed. This repair welding is needed to be done on the locations from where the temporary attachments were removed.

Trial Assembly:

CB7, CB9 & CB10:

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

CB8:

During random in process Visual Testing (VT) of the deck panel hold back welds at the south end of this Crossbeam (CB), this QA discovered several discontinuities that did not appear to comply with the contract documents. The areas were marked by this QA for the contractors Quality Control (QC) to inspect and evaluate. This QA informed ZPMC QC identified as Mr. Cai Xiao Feng and American Bridge Fluor (ABF) QA identified as Mr. Zane of these discontinuities. This QA observed that the hold back welds on the north end of this CB have not yet been welded.

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

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# WELDING INSPECTION REPORT

*( Continued Page 3 of 3 )*

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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