

**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-014477**Date Inspected:** 30-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:** Zhou Cheng.**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:

Outside Yard:

CB11, CB12 &amp; 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.

CB13:

During random inprocess inspection of this CB, this QA Inspector observed ZPMC personnel doing Magnetic Particle Testing (MT) of the welds of this CB. ZPMC Quality Control (QC) was identified as Wang Liang. This QA Inspector did random Visual Inspection (VT) of the welds & were found to be complying with the Contract documents. MT of the welds of this CB is not yet completed.

Photo attached for information.

CB14:

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This QA Inspector observed the following work in progress:

Repair welding of weld joint nos: FB204-044-053. Welder was identified as 12938. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC is identified as Zhan Hal Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-4G(4F)-Repair [welding repair report (WRR) no: B-WR13036 Rev-0 ].

Repair welding of weld joint no: FB204-044-069. Welder was identified as 12938. Welding process was identified as SMAW. ZPMC QC is identified as Zhan Hal Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G(2F)-Repair (WRR no: B-WR13046 Rev-0).

Trial Assembly:

CB7, CB8, CB9 & CB10:

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

Bay 14:

This QA Inspector observed ZPMC personnel shifting OBG Seg 12AE & 12BE from the bay to Outside Yard. No other significant work was being performed on other Segments.

Bay 19:

This QA Inspector observed the following work in progress:

Repair welding of weld joint no: SB015-068-004. Welder is identified as 0627565. Welding process was identified as Flux Cored Arc Welding (FCAW). ZPMC QC is identified as Zhong Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-Repair (WRR no: B-WR13215 Dt: 05/27/10).

Refer attached photos for further details.

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 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