

**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-015266**Date Inspected:** 01-Jul-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:** 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:** 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 the above mentioned CB at the time when this QA was present.

Bay 8: CB17.

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

Tower Trial Assembly:

CB8:

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated UT report for this

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date. UT was done on the areas of Bottom Panel where repair welding was done after removal of temporary attachments.

UT was done on the following areas:

- 1) On BP202A – CB PP017 & CB PP019.
- 2) On BP203A – CB PP017 & CB PP020.
- 3) On BP204A – CB PP019.
- 4) On BP205A – CB PP017.

Photos attached for reference.

Outside Yard:

CB14:

This QA Inspector observed the following work in progress:

Repair welding of weld joint no: FB204-044-060. Welding process was identified as Shielded Metal Arc Welding (SMAW). Welder is identified as 058087. ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G(2F)-Repair-1 (WRR No: B-WR-13776 Rev-0 & UT report no: B-787-UT-12938 R1).

Repair welding of weld joint no: FB204-043-070. Welding process was identified as SMAW. Welder is identified as 058087. ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G(2F)-Repair-1 (WRR No: B-WR-13773 Rev-0 & UT report no: B-787-UT-12937 R1).

Repair welding of weld joint no: CB202G-043-135/136 & 137/138. Welding process was identified as SMAW. Welder is identified as 058087. ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G(2F)-Repair-1 (WRR No: B-WR-13105 Rev-0 & B-WR-13104 Rev-0).

Repair welding of weld joint no: FB205-044-036. Welding process was identified as SMAW. Welder is identified as 058087. ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-3G(3F)-Repair-1 (WRR No: B-WR-13785 Rev-0 & UT report no: B-787-UT-12939 R1).

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.

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

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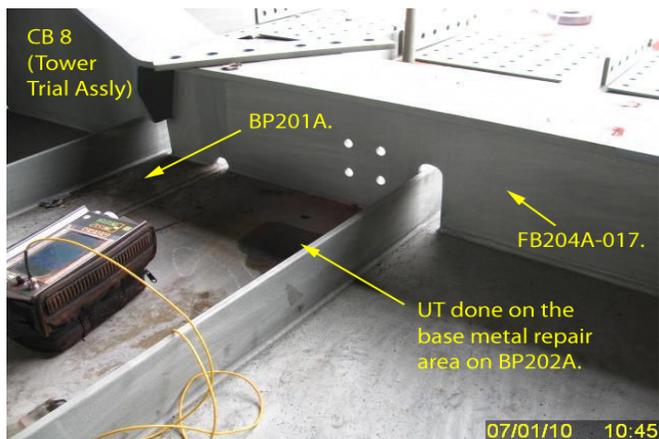
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documents.



## Summary of Conversations:

Only general conversation was held between QA and 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

**Reviewed By:** Hall,Steven

QA Reviewer

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