

**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-015513**Date Inspected:** 05-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:** Li Yang**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) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

**TRIAL ASSEMBLY YARD**

This QA Inspector randomly observed the following work in progress.

**OBG SEGMENT 9BE-9CE**

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 048659 performing Shielded Metal Arc Welding process for weld 009 located on PCMK OBE9B. ZPMC QC Mr. Wang Li Yang monitoring this welding.

The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-Fcm-Repair-1. Weld repair report identified as B-WR13917.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220069 performing Flux Cored Arc Welding process for weld 007 located on PCMK SEG054B. ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F)-Fcm-Repair-1. Weld repair report identified as B-WR13818.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220067 performing Shielded Metal Arc

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Welding process for weld 008 located on PCMK OBE9. ZPMC QC Mr. An Qing Xiang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-Fcm-Repair-1. Weld repair report identified as B-WR13915.

This Quality Assurance (QA) Inspector observed ZPMC QC Inspector performing Magnetic particle Inspection for the hold back weld between "T" stiffener and bottom panel in OBG segment 9BE at 9CE.

This Quality Assurance (QA) Inspector observed ZPMC personnel performing air carbon arc gouging on the deck panel splice weld between OBG segment 9BE and 9CE.

This Quality Assurance (QA) Inspector observed ABF QA Inspector performing Ultrasonic Inspection for the weld between side panel and bottom panel of OBG segment 9BE at 9AE (Cross beam side).

## OBG SEGMENT 9AW-9BW

This Quality Assurance (QA) Inspector observed ABF QA Inspector performing Ultrasonic Inspection for the side panel splice weld between OBG segment 9AW and 9BW (Counter weight side).

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037996 performing Shielded Metal Arc Welding process for weld 006 located on PCMK CA055. ZPMC QC Mr. Zhu Zhong Hai monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-u4b-Fcm-1.

## CROSS BEAM # 11

This Quality Assurance (QA) Inspector observed ABF QA Inspector performing Ultrasonic Inspection for the weld between side panel and deck panel east side of cross beam# 11.

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

## Comments

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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, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Utekar,Shrikant	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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