

**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-015904**Date Inspected:** 23-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 components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. 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 7: Cross Beam 18 (CB18):

This QA Inspector observed the following work in progress:

The Flux Cored Arc Welding (FCAW) process on weld joint no's: SP3085-001-015, 016, 019, 020, 023 and 024. The welders were identified as 062447, 204342 and 217185; and were observed welding in the 2F position. ZPMC Quality Control (QC) was identified as Guo Pan. The welding variables recorded by QC appeared to comply with WPS: B-T-2132-3.

OBG Trial Assembly Yard:

OBG Seg 9BW to Seg 9CW:

This QA Inspector observed the following work in progress:

The FCAW process on weld joint no: BP038-001-028. The welder was identified as 045143 and was observed

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welding in the 3G position. ZPMC QC was identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-B-U2-F.

The SMAW process on weld joint no: SP133-001-054. The welder was identified as 045196 and was observed welding in the 4G position. ZPMC QC was identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

FCAW process on weld joint no's: BK001-PP77-005 and 007. The welder was identified as 053742 and was observed welding in the 3G position. ZPMC QC was identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-TC-U4c-F.

OBG Seg 9BE:

Notification no: 006262.

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC QC personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG Seg 9BE. The weld designations reviewed are as follows:

- 1) Seg052B-001-041 and 043.
- 2) Seg052C-001-006, 041 and 043.
- 3) Seg052B-001-045 and 046.
- 4) Seg052C-001-045.

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

### Summary of Conversations:

No significant conversations were reported on this date.

### 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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<b>Inspected By:</b>	Wadkar,Sailesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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