

**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-016134**Date Inspected:** 10-Aug-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:

OBG Trial Assembly Yard:

This QA Inspector observed the following work in progress:

OBG Seg 9DW and Seg 9EW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: OBW9C-010. The welders are identified as 067665, 066258, 067572 and 066038 and was observed welding in the 4G position. ZPMC Quality Control (QC) was identified as Zhou Pan. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-F-1. See attached photo for further details.

The Flux Cored Arc Welding (FCAW) process on weld joint no: OBW9A-010. The welder is identified as 202384 and was observed welding in the 3G position. ZPMC QC was identified as Zhou Pan. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-B-U2-F.

OBG Seg 9DW:

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The FCAW process on weld joint no: CA065-005. The welder is identified as 040704 and was observed welding in the 2G position. ZPMC QC was identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-TC-U4b-F.

OBG Seg 9EW:

The SMAW process on weld joint no: CA068-006. The welder is identified as 067610 and was observed welding in the 4G position. ZPMC QC was identified as Zhou Pan. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-F.

OBG Seg 10AW:

The SMAW process on weld joint no: SEG059-040. The welder is identified as 067610 and was observed welding in the 4G position. ZPMC QC was identified as Zhou Pan. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-F.

OBG Seg 11CW:

This QA Inspector, along with Mr. Math Manjunath; performed Green Tag DCP for OBG Seg 11CW from Panel Point (PP) 101 to PP103.5.

The details are as mentioned below:

- Dimension measurements of:

1) Corner assembly cope holes at PP101, PP101.5, PP102, PP102.5, PP103 & PP103.5 [at both Cross Beam (CB) side and Counter weight (CW) side].

- Plumbness and flatness measurement of Deck Panel (DP) to DP diaphragm at PP101, PP102 and PP103.

- Floor beam flatness at PP101, PP102 and PP103 (at both CB side and CW side).

The measured readings were noted on Dimension Control Forms and are submitted to the Task Leader for review.

Bay 1: Traveler Rail DCP.

This QA Inspector, along with Mr. Math Manjunath; performed dimensional inspection for Traveler Rail 20TR1-22 and 20TR2-023. Measurements were taken for the locations as mentioned below:

- Flange thickness.

- Flange width.

- Traveler Rail length.

- Traveler Rail longitudinal elevation.

- Depth of Traveler Rail and

- Flange tilt.

The measured readings were noted on Dimension Control Forms and are submitted to the Task Leader for review.

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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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