

**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-016149**Date Inspected:** 11-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 9BW and Seg 9CW:

Repair welding on weld joint no's: SP656-001-032, 033 and 035. Welding process was identified as Shielded Metal Arc Welding (SMAW). The welder was identified as 067904 and was observed welding in the 4G position. ZPMC Quality Control (QC) was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR-14510, 14511 and 14512; for the respective welds.

Repair welding on weld joint no's: DP685-001-019 to 021. Welding process was identified as SMAW. The welder was identified as 045196 and was observed welding in the 3G position. ZPMC QC was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair-1. Repair welding was done as per WRR: B-WR-14515, 14514 and 14513; for the respective welds.

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Repair welding on weld joint no: SEG053A-013. Welding process was identified as SMAW. The welder was identified as 067829 and was observed welding in the 4G position. ZPMC QC was identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair-1. Repair welding was done as per Critical Welding Report (CWR): B-CWR-1775 Rev-0.

OBG Seg 9EW:

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG057A-011. The welder is identified as 202384 and was observed welding in the 1G position. ZPMC QC was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS: B-T-2231-B-U2-F.

OBG Seg 10AW:

The FCAW process on weld joint no: SEG059A-041. The welder is identified as 202384 and was observed welding in the 1G position. ZPMC QC was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS: B-T-2231-B-U2-F.

OBG Seg 9DW and Seg 9EW:

Base metal repair welding on Side Panel of OBG Seg 9DW and Seg 9EW; after removal of temporary attachments. Welding process was identified as SMAW. The welder was identified as 062935 and was observed welding in the 4G position. ZPMC QC was identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-Repair-1. Repair welding was done as per CWR: B-CWR-1679 Rev-0. See attached photo for further details.

Cross Beam 12 (CB12):

Notification no: 006378 – for punch list item no: 296 and 314.

This QA inspector performed 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 component – CB12. The weld designations reviewed are as follows:

- 1) CB201A-012-005 (for punch list item no: 314).
- 2) FB204-035-066 (for punch list item no: 296).
- 3) FB204-033-065 (for punch list item no: 296).

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

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## 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
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<b>Reviewed By:</b>	Peterson,Art	QA Reviewer
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