

**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-016330**Date Inspected:** 22-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**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr. 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. The QA Inspector observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC TESTING

CROSS BEAM # 12

ABF Report No: CB12-006

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the hold back welds between side panel and bottom panel of cross beam #12 on east side. The weld designations were as follows:

CB201A-012-004, 006 (CB#12, SP to BP, East side)

TRIAL ASSEMBLY YARD

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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This QA Inspector randomly observed the following work in progress.

### OBG SEGMENT 10AW-10BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067752 performing the Shielded Metal Arc Welding process on weld 004 located at PCMK OBW10B. ZPMC QC Mr. Zhou Peng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-u2-f-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067829 performing the Shielded Metal Arc Welding process on weld 005 located at PCMK OBW10B. ZPMC QC Mr. Zhou Peng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-u2-f-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067571 performing the Shielded Metal Arc Welding process on weld 032 located at PCMK SP660-001. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-u2-fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040609 performing the Flux Cored Arc Welding process on weld 044 located at PCMK BP156-001. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

### OBG SEGMENT 9CW-9DW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 041713 performing the Shielded Metal Arc Welding process on weld 019 located at PCMK DP673-001. ZPMC QC Mr. Zhou Peng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-485-SMAW-3G (3F)-Repair.

### OBG SEGMENT 10AE-10BE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040458 performing the Flux Cored Arc Welding process on weld 003 located at PCMK OBE10. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2231T.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040367 performing the Flux Cored Arc Welding process on weld 002 located at PCMK OBE10. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2231T.

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

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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

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**Inspected By:** Utekar,Shrikant

Quality Assurance Inspector

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**Reviewed By:** Peterson,Art

QA Reviewer