

**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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016587**Date Inspected:** 06-Sep-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:** Zhu Zhong Hai.**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 10BW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no's: SEG061A-011 and 012. The welders are identified as 067752 and 066361 and were observed welding in the 4G position. ZPMC Quality Control (QC) was identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

The SMAW process on weld joint no: CA074-002. The welder is identified as 037723 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-T2214-TC-U4b-FCM-1.

OBG Seg 10CW:

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The SMAW process on weld joint no's: SEG063A-002 and 021. The welders are identified as 067752 and 066361 and were 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.

The SMAW process on weld joint no: SEG063\*-035. The welder is identified as 037723 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-T-2214-TC-U4b-FCM-1.

OBG Seg 10AW and Seg 10BW:

Repair welding on weld joint no: OBW10B-002. Welding process was identified as SMAW. The welder was identified as 067656 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: 345-SMAW-4G(4F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR-14920 Rev-0. See attached photo for further details.

OBG Seg 10BW and Seg 10CW:

The SMAW process on weld joint no: OBW10A-003. The welder is identified as 068917 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.

The Flux Cored Arc Welding (FCAW) process on weld joint no's: SP677-001-037 and 039. The welder is identified as 202384 and was observed 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.

OBG Seg 10AE:

The FCAW process on weld joint no: SEG060B-027. The welder is identified as 040367 and was observed welding in the 2F position. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS: B-T-2132. See attached photo for further details.

The FCAW process on weld joint no: SEG060B-041. The welder is identified as 040367 and was observed welding in the 2G position. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-TC-U4b-F. See attached photo for further details.

OBG Seg 10BE:

The FCAW process on weld joint no: SEG062B-007. The welder is identified as 040367 and was observed welding in the 2F position. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS: B-T-2132. See attached photo for further details.

OBG Seg 10AE and Seg 10BE:

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The SMAW process on weld joint no: DP714-001-035. The welder is identified as 044515 and was observed welding in the 3G position. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS: B-T-3213-B-U3b.

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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**Inspected By:** Wadkar,Sailesh

Quality Assurance Inspector

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**Reviewed By:** Peterson,Art

QA Reviewer