

**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-016624**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:** 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**

This QA Inspector randomly observed the following work in progress.

**OBG LIFT # 10 WEST**

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067656 performing the Shielded Metal Arc Welding process on weld 002 located at PCMK OBW10B. ZPMC QC Mr. Wang Zhu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-Fcm-Repair-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 053486 performing the Flux Cored Arc Welding process on weld 047 located at PCMK BP103-001. ZPMC QC Mr. Wang Zhu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040609 performing the Flux Cored Arc Welding process on weld 028 located at PCMK SP661-001. ZPMC QC Mr. Wang Zhu was monitoring this

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040609 performing the Flux Cored Arc Welding process on weld 017 located at PCMK SP662-001. ZPMC QC Mr. Wang Zhu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040759 performing the Flux Cored Arc Welding process on weld 025 located at PCMK BP049-001. ZPMC QC Mr. Wang Zhu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-u2-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 222384 performing the Flux Cored Arc Welding process on weld 035 located at PCMK SP677-001. ZPMC QC Mr. Wang Zhu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-u2-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067752 performing the Shielded Metal Arc Welding process on weld 011 located at PCMK SEG061A. ZPMC QC Mr. Wang Zhu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-u4b-f.

## OBG LIFT # 10 EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040367 performing the Flux Cored Arc Welding process on weld 041 located at PCMK SEG060B. ZPMC QC Mr. Li Hua Jie was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-u4b-f.

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

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# WELDING INSPECTION REPORT

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<b>Inspected By:</b>	Utekar,Shrikant	Quality Assurance Inspector
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<b>Reviewed By:</b>	Peterson,Art	QA Reviewer
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