

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-016626**Date Inspected:** 07-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 10AE and Seg 10BE:

Repair welding on weld joint no's: OBE10B-004 and 005. Welding process was identified as Shielded Metal Arc Welding (SMAW). The welder was identified as 040320 and was observed welding in the 4G position. ZPMC Quality Control (QC) was identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR-14937 Rev-0.

Repair welding on weld joint no: OBE10B-003. Welding process was identified as SMAW. The welder was identified as 040320 and was observed welding in the 4G position. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per WRR: B-WR-14945 Rev-0.

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### OBG Seg 10AE:

The SMAW process on weld joint no's: SEG060B-001-006 and 036. The welder is identified as 044504 and was observed welding in the 4G position. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

The Flux Cored Arc Welding (FCAW) process on weld joint no's: SP590-001-055 and 056. 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.

### OBG Seg 10BE:

The FCAW process on weld joint no's: SP591-001-007 and 008. 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.

### OBG Seg 10AW:

Repair welding on weld joint no: SEG059-035. Welding process was identified as SMAW. The welder was identified as 046709 and was observed welding in the 4G position. ZPMC QC was identified as Zhong Peng. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per WRR: B-WR-14934 Rev-0.

### OBG Seg 10AW and Seg 10BW:

Repair welding on weld joint no: OBW10-005. Welding process was identified as SMAW. The welder was identified as 046709 and was observed welding in the 3G position. ZPMC QC was identified as Zhong Peng. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per WRR: B-WR-14906 Rev-0.

The SMAW process on weld joint no's: OBW10C-002 and 003. The welders are identified as 067656, 066361, 068917 and 067752 and were observed welding in the 4G position. ZPMC QC was identified as Zhong Peng. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

### Tower assembly yard:

#### Cross Beam 11 (CB11):

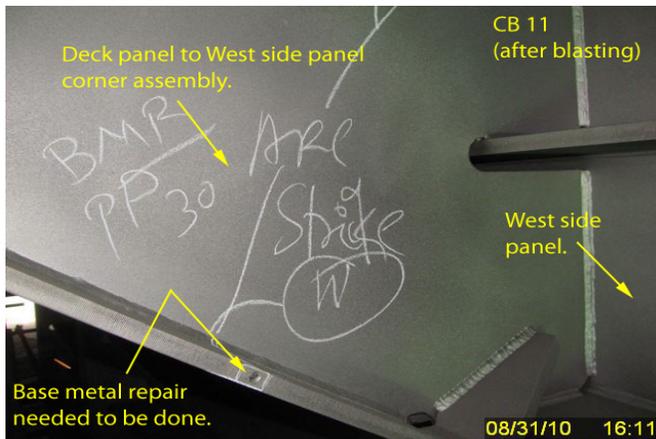
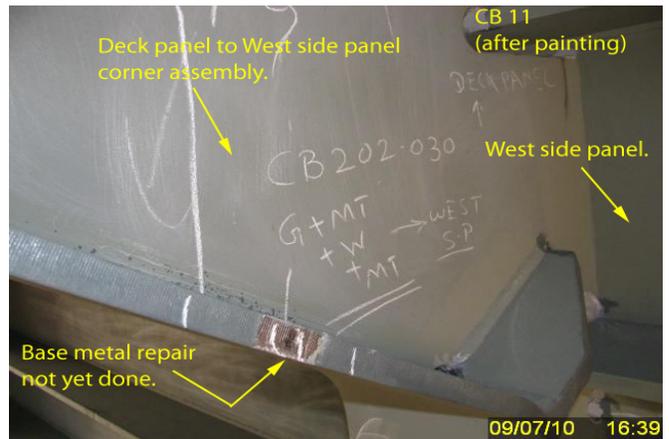
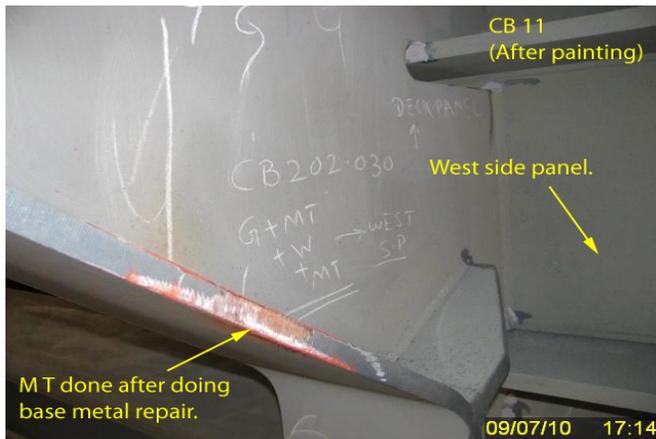
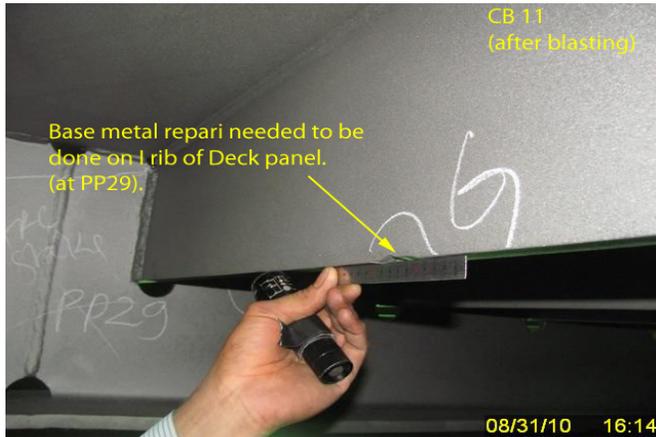
- During random visual inspection of this CB, this QA Inspector observed that for some of locations (identified for either repair / grinding, during blasting inspection), Magnetic Particle Testing (MT) was still to be done.
- At two locations base metal repair was still to be done.
- Earlier, during blasting inspection of CB11 (on 08/31/10), this QA Inspector identified and marked various locations / areas needed for grinding due to arc strikes.

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- This QA Inspector did MT of these identified areas. The locations of the same were recorded on the drawings / weld maps and were submitted to the Task Leader for review.
- See attached photo for further details.

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

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