

**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-017045**Date Inspected:** 12-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Jie**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 Umesh Gaikwad 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. QA observed and/or found the following:

TRIAL ASSEMBLY YARD, 10AW+10BW HOLD BACK (NWIT # 06654)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

DP688-001-015, 016

DP727-001-009, 010

EP132-002-019, 020

EP133-001-007, 008

SP676-002-057, 058

SP677-001-017, 018

SP498-002-045, 046

SP499-001-003, 004

SP736-002-059, 060

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SP737-001-011, 012  
SP776-002-057, 058  
SP777-001-011, 012  
SP164-001-025, 026  
SP165-001-001, 002  
SP137-001-035, 036  
SP138-001-011, 012  
SP110-001-039, 040  
SP111-001-011, 012  
SP660-001-025, 026  
SP661-001-015, 016  
EP116-001-011, 012  
EP117-001-010, 011  
DP675-001-015, 016  
DP676-001-009, 010

This Quality Assurance (QA) Inspector observed the following work in progress:

## BAY 14, "K" PLATE SUBASSEMBLY

FCAW welding of weld joint 008 located on KP3001-001.

Welder is identified as 044795. ZPMC QC is identified as Mr. Wang Xu.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint 002(Repair) located on KP3003-001.

Welder is identified as 066236. ZPMC QC is identified as Mr. Wang Xu.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-REPAIR.

FCAW welding of weld joint 023 located on SEG3013AD(SP3091F+SP3092F).

Welder is identified as 201215. ZPMC QC is identified as Mr. Xia Chun Hui.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-U2-F.

## BAY 16, Bottom Plate

FCAW welding of weld joint 001 located on BP3101-001.

Welder is identified as 201879. ZPMC QC is identified as Mr. Xia Chun Hui.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-U2-F.

SAW welding of weld joint 001 located on BP3095-001.

Welder is identified as 201917. ZPMC QC is identified as Mr. Xia Chun Hui.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

During random in process inspection this QA inspector observed that the crack like indication on the tack weld at two locations on the weld joint BP3101-001-001. This issue has been discussed with ZPMC QC Mr. Xia Chun

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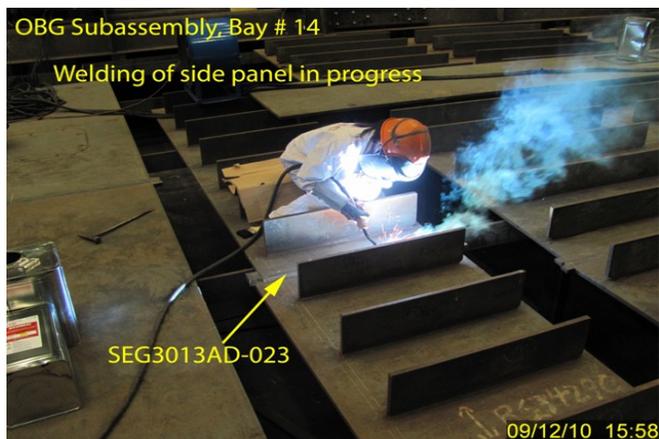
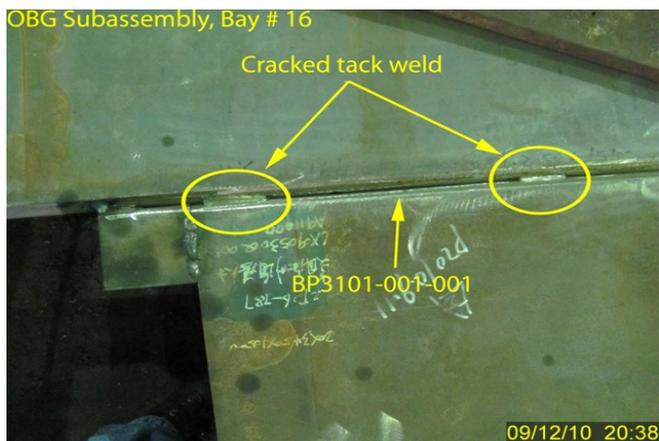
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Hui, and as per conversation ZPMC agreed to remove the tack and perform Magnetic Particle Testing prior to start the welding on specific locations.

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



## Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

## 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 : 15000422372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Gaikwad,Umesh

Quality Assurance Inspector

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**Reviewed By:** Carreon,Albert

QA Reviewer