

**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-017048**Date Inspected:** 16-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, Geng Wei**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:

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

BAY 14 "K" Plate Subassembly

FCAW welding of weld joint 001 located on KP3002-001.

Welder is identified as 067079. ZPMC QC is identified as Mr. Zhang Lin.

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

FCAW welding of weld joint 004 located on KP3001-001.

Welder is identified as 067876. ZPMC QC is identified as Mr. Zhang Lin.

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

BAY 19, Bike Path

FCAW welding of weld joint 025 located on BK004A3-014.

Welder is identified as 062761. ZPMC QC is identified as Mr. Li Ming Yang.

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

FCAW welding of weld joint 014 located on BK004A3-014.

Welder is identified as 062738. ZPMC QC is identified as Mr. Li Ming Yang.

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

FCAW welding of weld joint 090 located on BK004A5-008.

Welder is identified as 062841. ZPMC QC is identified as Mr. Li Ming Yang.

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

FCAW welding of weld joint 090 located on BK004A-002.

Welders are identified as 260562 and 208641. ABF QA is identified as Mr. Peng Wen Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2234-Tc-U4b-F.

BAY 16, Bottom Plate

SMAW welding of weld joint 027/028 located on W5-SB5A.

Welder is identified as 201905. ZPMC QC is identified as Mr. Guo Xing Hui.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112-1.

BAY 14, DECK PLATE

During random in process inspection this QA inspector observed that ZPMC personnel performing fit up by using Flux Cored Arc Welding (FCAW) process for deck plate SEG3014-007(DP3131A+DP3132A). Welder is identified as 202122. ZPMC QC is identified as Mr. Xia Chun Hui. The welding variables recorded by QC appeared to comply with WPS-B-P-2231-B-U2-F.

BAY 14, "K" PLATE SUBASSEMBLY (HSR-9377)

During random in process inspection this QA inspector observed that ZPMC personnel performing heat straightening on the weld joints of bottom plate of 13AW. The members are identified as OBG components and the weld designations reviewed are as follows.

KP3003-001-001, 002

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

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## 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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<b>Inspected By:</b>	Gaikwad,Umesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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