

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-017080**Date Inspected:** 28-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 10BE and Seg 10CE:

Repair welding of weld joint no: OBE10C-004. Welding process was identified as Shielded Metal Arc Welding (SMAW). The welder was identified as 044504 and was observed welding in the 4G position. ZPMC Quality Control (QC) was identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR-15363 Rev-0.

OBG Seg 11AW and Seg 11BW:

The Flux Cored Arc Welding (FCAW) process on weld joint nos: OBW11-002, 003 and 004. The welders are identified as 040759 and 053316 and were observed welding in the 1G position. ZPMC QC was identified as Shi

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

Lei. The welding variables recorded by QC appeared to comply with WPS: B-T-223(2)1T-2.

The FCAW process on weld joint nos: OBW11B-002 and 004. The welders are identified as 069683, 053486, 040759 and 053316 and were 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-T.

The FCAW process on weld joint no: OBW11B-003. The welder is identified as 040609 and was observed welding in the 1G position. ZPMC QC was identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS: B-T-2231-T.

Cross Beam 14 (CB 14):

The SMAW process on weld joint nos: FB023-PP93-016, 018 and 020. The welder is identified as 040656 and was observed welding in the 4F position. ZPMC QC was identified as He Ya Bing. The welding variables recorded by QC appeared to comply with WPS: B-T-4114-1.

The SMAW process on weld joint nos: FB027-PP93-006, 008 and 010. The welder is identified as 057333 and was observed welding in the 4F position. ZPMC QC was identified as He Ya Bing. The welding variables recorded by QC appeared to comply with WPS: B-T-4114-1.

The SMAW process on weld joint nos: FB024-PP93-016, 018 and 020. The welder is identified as 046704 and was observed welding in the 4F position. ZPMC QC was identified as He Ya Bing. The welding variables recorded by QC appeared to comply with WPS: B-T-4114-1.

The SMAW process on weld joint nos: FB028-PP93-010 and 012. The welder is identified as 041713 and was observed welding in the 4F position. ZPMC QC was identified as He Ya Bing. The welding variables recorded by QC appeared to comply with WPS: B-T-4114-1.

Cross Beam 13 (CB13):

Repair welding of weld joint no: SEG060D-049. Welding process was identified as SMAW. The welder was identified as 216086 and was observed welding in the 3G position. ZPMC QC was identified as He Ya Bing. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-3G(3F)-Repair-1. Repair welding was done as per WRR: B-WR-15309 Rev-0.

Repair welding of weld joint no: SEG060E-083. Welding process was identified as SMAW. The welder was identified as 215553 and was observed welding in the 3G position. ZPMC QC was identified as He Ya Bing. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-3G(3F)-Repair-1. Repair welding was done as per WRR: B-WR-15317 Rev-0.

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

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

**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.

---

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

---