

**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-017083**Date Inspected:** 30-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:** Lv Li Qing**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:

BAY # 14

**ULTRASONIC TESTING**

ZPMC NWIT: 06810 &amp; 06806

This QA Inspector performed Ultrasonic Testing (UT) of approximately 10% of the length previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an (UT) report on this date. The members are identified as OBG 13AW. The weld designations are as follows:

SEG3013AC-002, 001

**MAGNETIC PARTICLE TESTING**

ZPMC NWIT: 06813

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the length previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an (MT) report on this date. The members are identified as OBG 13CE. The weld designations are as follows:

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# WELDING INSPECTION REPORT

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\*Temporary attachments removed areas of bottom plate

This QA Inspector randomly observed the following work in progress.

## BAY # 16

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 048250 performing the Flux Cored Arc Welding process on weld 025 located at PCMK LD3033-001. ABF QA Mr. Li Shi You was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2233-Tc-u5-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 206358 performing the Flux Cored Arc Welding process on weld 180 located at PCMK LD3034-001. ABF QA Mr. Li Shi You was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2232-Tc-u5-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 201583 performing the Flux Cored Arc Welding process on weld 076 located at PCMK LD3034-001. ABF QA Mr. Li Shi You was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2233-Tc-u5-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 048696 performing the Flux Cored Arc Welding process on weld 025 located at PCMK LD3035-001. ABF QA Mr. Li Shi You was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2233-Tc-u5-f.

## BAY # 14

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 047866 performing the Flux Cored Arc Welding process on weld 025 located at PCMK AP3013-001. ABF QA Mr. Shao Jian Yuan was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2132.

## MAGNETIC PARTICLE TESTING

ZPMC NWIT: 06810

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the length previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an (MT) report on this date. The members are identified as OBG 13CW. The weld designations are as follows:

\*Removal of connection plates and padeyes.

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

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# WELDING INSPECTION REPORT

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

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

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