

**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-017211**Date Inspected:** 01-Oct-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:

This QA Inspector randomly observed the following work in progress.

**BAY # 16**

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045143 performing the Flux Cored Arc Welding process on weld 034 located at PCMK LD3032-001. ABF QA Mr. Zou Liu Hai 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 045175 performing the Flux Cored Arc Welding process on weld 036 located at PCMK LD3036-001. ABF QA Mr. Zou Liu Hai 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 048696 performing the Flux Cored Arc Welding process on weld 155 located at PCMK LD3031-001. ABF QA Mr. Zou Liu Hai 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 045280 performing the Flux Cored Arc

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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Welding process on weld 071 located at PCMK LD3031-001. ABF QA Mr. Zou Liu Hai 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 084 located at PCMK LD3034-001. ABF QA Mr. Zou Liu Hai was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2232-Tc-u5-f.

BAY # 14

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044795 performing the Flux Cored Arc Welding process on weld 006 located at PCMK VP3004-001. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-345-FCAW-2G (2F)-Fcm-Repair. Weld repair report identified as B-CWR1982.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067520 performing the Flux Cored Arc Welding process on weld 012 located at PCMK VP3005-001. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-345-FCAW-2G (2F)-Fcm-Repair. Weld repair report identified as B-WR15333.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066763 performing the Flux Cored Arc Welding process on weld 002 located at PCMK VP3006A-001. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-345-FCAW-2G (2F)-Fcm-Repair. Weld repair report identified as B-WR16011.

This Quality Assurance (QA) Inspector observed ZPMC personnel performing ultrasonic testing on the weld VP3007-001-063.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 45265 performing the Submerged Arc Welding process on weld 006 located at PCMK SEG3020A\*. ABF QA Mr. Li Yun was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2221-B-U2c-s-2.

This Quality Assurance (QA) Inspector observed ZPMC personnel performing heat straightening on the weld VP3002A-002. Heat straightening report identified as HSR1 (B)-09467.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 058100 performing the Submerged Arc Welding process on weld 003 located at PCMK SEG3019A. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2221-B-U2c-s-2.

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

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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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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**Inspected By:** Utekar,Shrikant

Quality Assurance Inspector

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**Reviewed By:** Peterson,Art

QA Reviewer