

**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-017420**Date Inspected:** 14-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:

BAY # 14

This QA Inspector randomly observed the following work in progress.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045265 performing the Submerged Arc Welding process on weld 031 located at PCMK SEG3020AQ. ABF QA Miss. 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 qualified welder 044824 performing the Flux Cored Arc Welding process on weld 068 located at PCMK AP3003-001. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 062406 performing the Submerged Arc Welding process on weld 002 located at PCMK SA3214. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-u2c-s-2.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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This Quality Assurance (QA) Inspector observed ZPMC qualified welder 047079 performing the Flux Cored Arc Welding process on weld 068 located at PCMK VP3007-001. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044774 performing the Flux Cored Arc Welding process on weld 035 located at PCMK VP3007-001. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-u4b-f.

This Quality Assurance (QA) Inspector observed longitudinal diaphragm LD3035 fit-up was in progress. ZPMC performed tack welding for the weld between longitudinal diaphragm and side panel.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044771 performing the Submerged Arc Welding process on weld 019 located at PCMK SEG3007AC. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-u2c-s-2.

This Quality Assurance (QA) Inspector observed ABF personnel performing Magnetic Particle testing for the side panel splice weld between OBG segment 13BE and 13CE (CB side). Weld number was identified as OBE13C-003.

This Quality Assurance (QA) Inspector observed longitudinal diaphragm LD3029 fit-up was in progress. ZPMC performed tack welding for the weld between longitudinal diaphragm and bottom panel.

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



## Summary of Conversations:

No significant conversations were reported on this date.

## Comments

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## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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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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