

**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-017422**Date Inspected:** 15-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:** 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:

Seg 10E:

Notification no: 006962.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC QC personnel. This QA Inspector generated a UT report on this date. The members are identified as OBG components. The weld designations reviewed are as follows:

- 1) SP551-001-055, 059.
- 2) SP591-001-052.
- 3) SP631-001-052.
- 4) BP076-001-020, 026, 028.
- 5) BP130-001-022.
- 6) SP351-001-044.
- 7) SP324-001-059, 061, 063.

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

8) SEG064C-049, 052.

9) SSD27-PP87-171, 174, 137, 100, 047, 032, 222.

This QA Inspector observed the following work in progress:

OBG Seg 11AW and Seg 11BW:

Repair welding of weld joint no: OBW11B-003. Welding process was identified as Shielded Metal Arc Welding (SMAW). The welder was identified as 040611 and was observed welding in the 4G position. ZPMC QC was identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS:

345-SMAW-4G(4F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR-15966 Rev-0.

OBG Seg 11AE and Seg 11BE:

Base metal repair welding of after removal of temporary attachments at weld joint no: OBW11-003. Welding process was identified as SMAW. The welder was identified as 044515 and was observed welding in the 1G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-1G(1F)-Repair-1. Repair welding was done as per Critical Welding Repair Report (CWR): B-CWR-1957 Rev-0. See attached photo for further details.

Seg 11BW:

The SMAW process on weld joint no: OBW11-025. The welder is identified as 041713 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-P-2214-B-U2-FCM-1.

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

---