

**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-017640**Date Inspected:** 13-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1100**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Jie**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 Umesh Gaikwad 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. QA observed and/or found the following:

BAY 04, DECK PANEL (NWIT # 06658)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

DP3176(PL3489A)-001-001~008 GREEN TAG # 14630

DP3176(PL3489B)-001-009~016 GREEN TAG # 14631

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 04

FCAW welding of weld joint 005 located on SA3084B-012.

Welder is identified as 062265. ZPMC CWI is identified as Mr. Yang Bai Qiang.

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The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint 006 located on SA3084B-007.

Welder is identified as 062265. ZPMC CWI is identified as Mr. Yang Bai Qiang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint 005 located on SA3084B-006.

Welder is identified as 203805. ZPMC CWI is identified as Mr. Yang Bai Qiang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint 006 located on SA3084B-004.

Welder is identified as 203805. ZPMC CWI is identified as Mr. Yang Bai Qiang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-F.

BAY 16, Bottom Plate

SAW welding of weld joint 001 located on BP3101-001.

Welder is identified as 201917. ZPMC CWI is identified as Mr. Wang Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

FCAW welding of weld joint 041(Repair) located on LD3035-001.

Welder is identified as 045143. ZPMC CWI is identified as Mr. Wang Jie.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-FCM-REPAIR.

FCAW welding of weld joint 031(Repair) located on LD3033-001.

Welder is identified as 045280. ZPMC CWI is identified as Mr. Wang Jie.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-FCM-REPAIR.

During random in process inspection this QA inspector observed the melt through on the weld during SAW welding of the weld joint BP3101-001-001. This issue has been discussed with ZPMC CWI Mr. Wang Jie, and as per conversation ZPMC agreed to perform the repair and required NDT prior, during and after welding on specific locations as per repair procedure.

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

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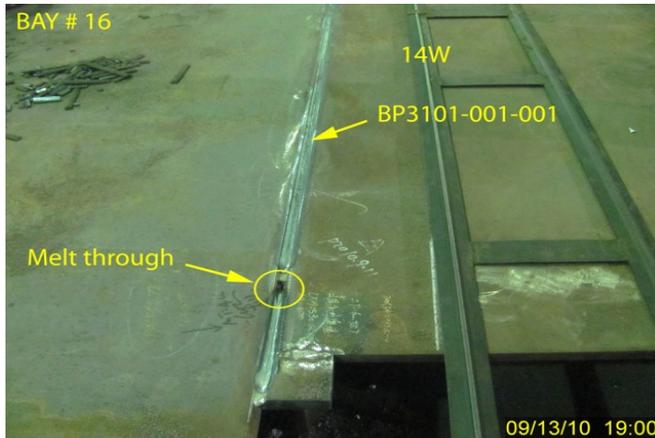
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## Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

## 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 : 15000422372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Gaikwad,Umesh

Quality Assurance Inspector

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**Reviewed By:** Carreon,Albert

QA Reviewer