

**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-017766**Date Inspected:** 27-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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune 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:

This QA Inspector randomly observed the following work in progress:

**OBG TRIAL ASSEMBLY YARD****WELDING:****Segment # 11BE ~ 11CE**

This QA Inspector observed ZPMC qualified welding personnel identified as 044504 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE11B-007; located On Orthotropic Box Girder (OBG) Side Plate to Side Plate Transverse CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2214-B-U2-FCM-1.

**Segment # 11BW ~ 11CW**

This QA inspector observed ZPMC qualified welding personnel identified as 040656 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW11B-008; located On Orthotropic Box Girder (OBG) Bottom Plate to Bottom Plate Transverse CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding

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variables recorded by QC appeared to comply with applicable WPS-B-P-2214-B-U2-FCM-1. See attached Photo for further details.

### Segment # 11BW ~ 11CW

This QA Inspector observed ZPMC qualified welding personnel identified as 041713 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW11B-007; located On Orthotropic Box Girder (OBG) Side Plate to Side Plate Transverse CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2214-B-U2-FCM-1.

### Segment # 11BW ~ 11CW

This QA inspector observed ZPMC qualified welding personnel identified as 040611 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP693-001-021; located On Orthotropic Box Girder (OBG) Corner Assembly I-Rib to I-Rib CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with applicable WPS-B-T-3213-B-U3b. See attached Photo for further details.

NDT:

### Segment # 10AE ~ 10CE (OGB Runner Plates For East Line)

This QA Inspector performed Magnetic Particle Testing (MPT) Verification inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MPT report for this date. The members are identified as Orthotropic Box Girder (OBG) Components. The weld designations verified are as follows.

SSD16-PP086-093, 094

SSD18-PP088-093, 094

SSD16-PP092-093, 094

SSD18-PP094-093, 094

Nondestructive testing (NDT) notification No. 07126

### Segment # 10AE

This QA Inspector performed Magnetic Particle Testing (MPT) Verification inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MPT report for this date. The members are identified as Orthotropic Box Girder (OBG) Components. The weld designations verified are as follows.

OBE10D-017, 008

SEG060B-027, 028

SEG060C-029, 030

Nondestructive testing (NDT) notification No. 07134

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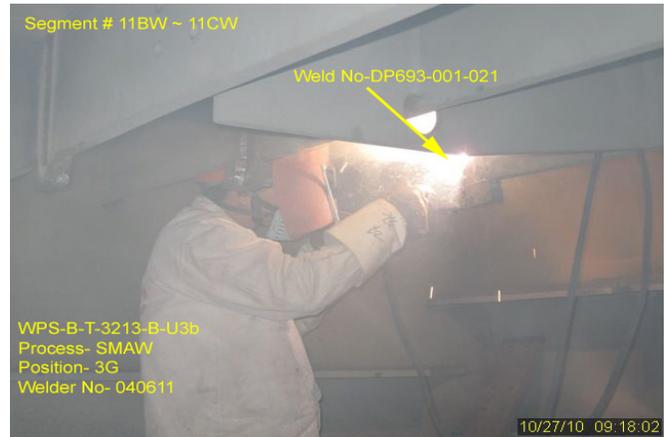
# WELDING INSPECTION REPORT

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



## Summary of Conversations:

No significant conversation 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.

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

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