

**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-018009**Date Inspected:** 22-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:** Mr. Chen xi**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:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu 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:

BAY- 2

This QA Inspector Randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW) of weld joint FB3343-001-167. Welder is identified as 066236. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2233-TC-U5-F.

FCAW of weld joint FB3343-001-049. Welder is identified as 045175. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2233-TC-U5-F.

FCAW of weld joint FB3343-001-033. Welder is identified as 045280. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2233-TC-U5-F.

Shielded Metal Arc Welding (SMAW) Tack welding of weld joint EB3056-001-009,010. Welder is identified as 066261. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables appeared to comply with

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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the Applicable WPS: WPS-B- P-2112.

## BAY- 3

FCAW of weld joint LD3041-001-158. Welder is identified as 206623. ZPMC Quality Control (QC) is identified as Mr. Zhang yaxu. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2233-TC-U4b-F.

FCAW of weld joint LD3041-001-018. Welder is identified as 052696. ZPMC Quality Control (QC) is identified as Mr. Zhang yaxu. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U5-F.

FCAW of weld joint LD3041-001-385,386. Welder is identified as 217805. ZPMC Quality Control (QC) is identified as Mr. Zhang yaxu. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2132-3.

## BAY- 4

During the Caltrans QA Random in process inspection of the steel barriers, this QA observed ZPMC has performed seal welding without first removing the paint from the surfaces to be welded on steel barrier sections. The welds are joining the W2-P1 and 3 to the skins. The barriers are affected by this condition is identified as W2-SB1-PP46-465 and W2-SB1A-PP26-PP26.5. This QA informed American Bridge/Fluor (AB/F) QA Inspector identified as Mr. Wang wen bin and Liu lai qian of this issue. Mr. Wang wen bin and Liu lai qian informed this QA that paint will be removed prior to welding on all future barriers. This QA also informed to Caltrans Lead QA Inspector for the above issue. Additionally, Mr. Wang wen bin and Liu lai qian has instructed ZPMC workers and QC to Remove the paint prior to welding on all future barriers, as specified in the contract documents. Refer the attached photos for reference.

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



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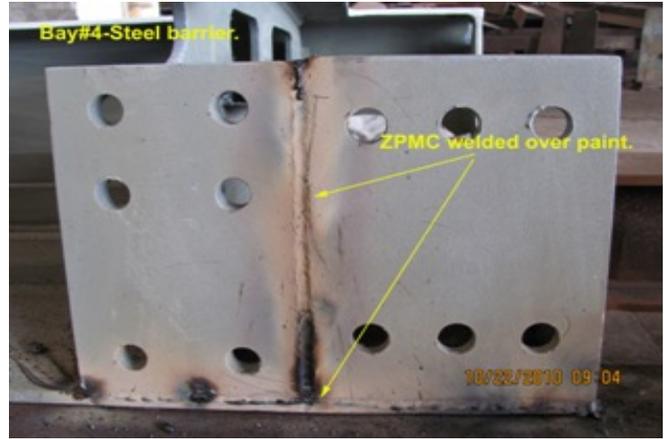
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# WELDING INSPECTION REPORT

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## Summary of Conversations:

Only general conversation was held between QA and Quality Control (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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<b>Inspected By:</b>	Prabhu,Surendra	Quality Assurance Inspector
<b>Reviewed By:</b>	Hall,Steven	QA Reviewer

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