

**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-018082**Date Inspected:** 09-Nov-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 Inspector observed and/or found the following:

OBG Trial Assembly Yard:

This QA Inspector observed the following work in progress:

OBG Seg 11DW and Seg 11EW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: OBW11C-009 [Side Panel (SP) to SP – W6 side; transverse splice complete joint penetration (CJP) weld]. The welder is identified as 040656 and was observed welding in the 4G position. ZPMC Quality Control (QC) was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with Welding Procedure Specification (WPS): B-P-2214-B-U2-FCM-1.

The Flux Cored Arc Welding (FCAW) process on weld joint no: OBW11C-008 [Bottom Panel (BP) to BP; transverse splice CJP weld]. The welder is identified as 040609 and was observed welding in the 1G position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: B-T-2231-B-U2-F.

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### OBG Seg 11DW:

The FCAW process on weld joint no: SEG071A-049 [SP to Edge Panel (EP) – hold back CJP weld – W6 side, at PP107]. The welder is identified as 053486 and was observed welding in the 1G position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: B-T-2231-TC-U4b-F.

### OBG Seg 11EW:

The FCAW process on weld joint no: CA092-005 (EP to EP – hold back CJP weld – W6 side, at PP107). The welder is identified as 053486 and was observed welding in the 1G position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: B-T-2231-TC-U4b-F.

### OBG Seg 11DE and Seg 11EE:

The FCAW process on weld joint no: OBE11A-007 [Deck Panel (DP) to DP – transverse splice CJP weld]. The welder is identified as 040367 and was observed welding in the 1G position. ZPMC QC was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS: B-T-2231-B-U2-F.

### OBG Seg 11BE and Seg 11CE:

Repair welding of weld joint nos: OBE11-007, 008 and 009 (DP to DP – transverse splice CJP welds). The welder is identified as 040312 and was observed welding in the 1G position. Welding process was identified as SMAW. Repair welding was done as per welding repair report (WRR): B-WR-16658 Rev-0. ZPMC QC was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-1G(1F)-FCM-Repair.

### OBG Seg 11DE:

The FCAW process on weld joint no: SEG072A-045 (SP to BP – CJP hold back weld at E3, at PP107). The welder is identified as 052763 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: B-T-2231-B-U2-F.

### OBG Seg 11EE:

The FCAW process on weld joint no: SEG074A-014 (SP to BP – CJP hold back weld at E3, at PP107). The welder is identified as 052763 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: B-T-2231-B-U2-F.

### Cross Beam 15 (CB15):

The SMAW process on weld joint no: CB202A-015-018 (East Side Panel to BP – CJP hold back weld). The welder is identified as 052930 and was observed welding in the 2G position. ZPMC QC was identified as Li Yang.

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The welding variables recorded by QC appeared to comply with WPS: B-P-2212-TC-U4b-FCM-1.

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**

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>	Wadkar,Sailesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Dsouza,Christopher	QA Reviewer

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