

**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-018153**Date Inspected:** 29-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:** Lv Li Qing**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 Mr. Shrikant Utekar 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. The QA Inspector observed and/or found the following:

This QA Inspector randomly observed the following work in progress.

BAY # 14

**OBG 13EAST**

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066695 performing the Flux Cored Arc Welding process on weld 0117 located at PCMK SEG3009K. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044795 performing the Flux Cored Arc Welding process on weld 0118 located at PCMK SEG3009K. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067079 performing the Flux Cored Arc Welding process on weld 0253 located at PCMK SEG3009L. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232Tc-u4b-f.

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This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068997 performing the Flux Cored Arc Welding process on weld 0254 located at PCMK SEG3009L. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 06613 performing the Flux Cored Arc Welding process on weld 0255 located at PCMK SEG3009L. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066439 performing the Flux Cored Arc Welding process on weld 0256 located at PCMK SEG3009L. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054013 performing the Shielded Metal Arc Welding process on weld 018 located at PCMK SEG3011B. ZPMC QC Mr. Guo Xing Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2113-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 050969 performing the Shielded Metal Arc Welding process on weld 021 located at PCMK SEG3011C. ZPMC QC Mr. Guo Xing Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2113-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066674 performing the Shielded Metal Arc Welding process on weld 026 located at PCMK SEG3011D. ZPMC QC Mr. Guo Xing Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2113-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066416 performing the Shielded Metal Arc Welding process on weld 035 located at PCMK SEG3011E. ZPMC QC Mr. Guo Xing Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2113-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068859 performing the Flux Cored Arc Welding process on weld 058 located at PCMK SEG3011G. ZPMC QC Mr. Guo Xing Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

This Quality Assurance (QA) Inspector observed ZPMC personnel performing heat straightening, member identified as VP3005. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Lv Li Qing was present to monitor the heat straightening process. The heat straightening appeared to comply with heat straightening Report HSR1 (B)-9662.

This QA Inspector observed ABF personnel performing ultrasonic testing (scanning pattern "D") on the weld between deck panel and edge panel of the corner assembly CA3014.

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

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## 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, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Utekar,Shrikant

Quality Assurance Inspector

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**Reviewed By:** Patterson,Rodney

QA Reviewer