

**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-018740**Date Inspected:** 18-Dec-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. 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 Shailesh 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:

This QA Inspector observed the following work in progress:

**OBG TRIAL ASSEMBLY****OBG Segment 12AE~12BE**

This QA Inspector observed ZPMC qualified welding personnel identified as 050289 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AE Side plate to Edge plate Hold back area Cross beam side. Joint identified as SEG3001AA-022 and CA3002-001. ZPMC QC Identified as Liu Hua Jie. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1.

**OBG Segment 12AW ~12BW**

This QA Inspector observed ZPMC qualified welding personnel identified as 046709 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AW +12BW Bottom plate to Side plate Hold back area Cross beam side. Joint identified as SEG3004A-004 and SEG3005A-004. ZPMC QC Identified as Zhu Zhong Hai. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1.

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## OBG Segment 12AW ~12BW

This QA Inspector observed ZPMC qualified welding personnel identified as 040611 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AW+12BW Bottom plate to Side plate Hold back area counter weight side. Joint identified as SEG3004A-001 and SEG3005A-003. ZPMC QC Identified as Zhu Zhong Hai. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1.

## OBG Segment 12AW~12BW

This QA Inspector observed ZPMC qualified welding personnel identified as 044560 Perform Submerged Arc Welding (SAW) on OBG segment 12AW+12BW Deck plate to deck plate joint. Joint identified as OBW12-001. ZPMC QC Identified as Wang Zhu. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-223(2) 1 T-ESAB. For more information see below attached picture number 2.

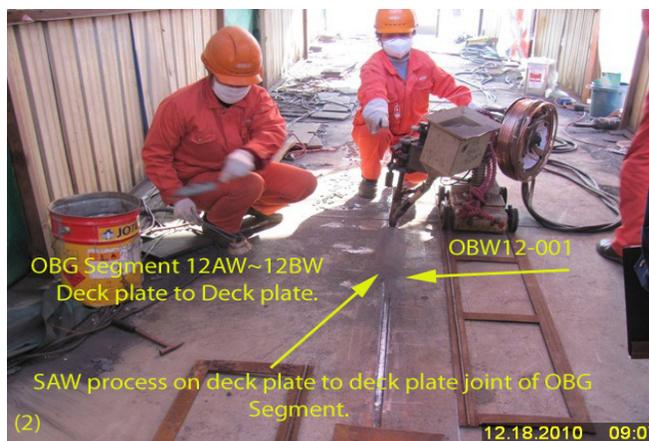
## Visual Inspection after Blast at West Tower Lift -4

This Quality Assurance (QA) Inspector performed random visual inspection of West Tower Lift-4 External side Skin Plate A to E surfaces. After grit blasting at Blast shop number 2. Areas that marked for repair were recorded for future repair. And some areas requiring additional grinding were marked by QA Inspector and repaired by ZPMC personnel.

## Visual Inspection after Blast at North Tower Lift -4

This Quality Assurance (QA) Inspector performed random visual inspection of North Tower Lift-4 inside Skin Plate A to E surfaces and diaphragm elevation 131M to 146M. After grit blasting at Blast shop number 1. Areas that marked for repair were recorded for future repair. And some areas requiring additional grinding were marked by QA Inspector and repaired by ZPMC personnel.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



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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 phone :150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Gaikwad,Shailesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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