

**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-018824**Date Inspected:** 25-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li jia**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- 1**

This QA Inspector Randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) Repair Welding of weld joint identified as E2-SB1C-012-050. Welder is identified as 215248. ZPMC Quality Control (QC) is identified as Mr. Xiang feng feng. The welding variables appeared to comply with Applicable the WPS: WPS-345-SMAW-1G (1F)-Repair. Refer the attached photos for reference.

**BAY- 2**

American Bridge/Flour QA Inspectors performing Magnetic Particle Testing for the Anchor plate AP3032A. Refer the attached photos for reference.

ZPMC personnel heat straightening OBG member identified as SA3415-002. Distortion appeared to be caused by welding of the material. ZPMC Quality Control (QC) inspector identified as Mr. Li jia was present to monitor the

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heat straightening process. The heat straightening appeared to comply with the Heat Straightening Report (HSR) HSR1 (B)-9974.

## BAY- 3

Shielded Metal Arc Welding (SMAW) welding of weld joint SP3071-001-171,183. Welder is identified as 037996. ZPMC Quality Control (QC) is identified as Mr. Wang liyang. The welding variables appeared to comply with the Applicable WPS: WPS-B-P-2213-TC-U4b.

FCAW Buttering welding of side plate identified as SP3083A-PL3264A. Welders are identified as 208035 and 050977. ZPMC Quality Control (QC) is identified as Mr. Wang liyang. The welding variables appeared to comply with the Applicable WPS: WPS-345-FCAW-1G-ESAB-Repair. The repair welding was being performed as per the Caltrans Engineer approved Critical Welding Repair Report (CWR) No: B-CWR2390. Refer the attached photos for reference.

## BAY- 4

This QA observed that no significant work was being performed in this bay during the time QA was present.

## BAY- 8

SMAW welding of weld joint BK004A5-064-002. Welder is identified as 067904. ZPMC Quality Control (QC) is identified as Mr. Liu chuan gang. The welding variables appeared to comply with the Applicable WPS: WPS-B-P-2211-B-U2.

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

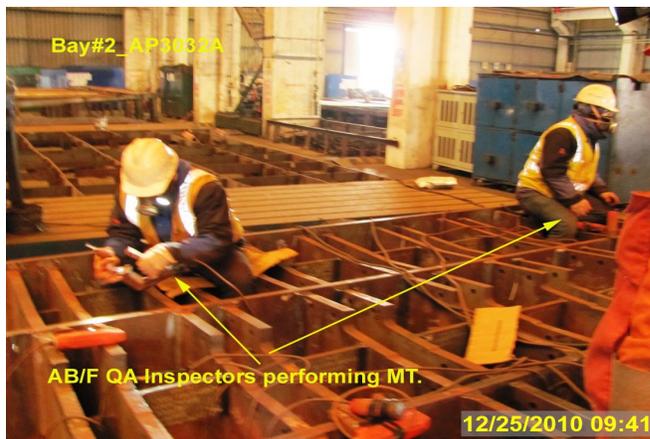


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## Summary of Conversations:

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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**Inspected By:** Prabhu,Surendra

Quality Assurance Inspector

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**Reviewed By:** Hall,Steven

QA Reviewer