

**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-018834**Date Inspected:** 06-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:** Geng Wei**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:

**ULTRASONIC TESTING**

BAY # 14

ZPMC NWIT: 07256

This QA Inspector performed Ultrasonic Testing (UT) of approximately 10% of the length previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an (UT) report on this date. The members are identified as OBG 13BE. The weld designations are as follows:

SEG3009B-008; SEG3009C-007; SEG3009D-008; SEG3009E-007; SEG3009F-008; SEG3009G-008;  
SEG3009H-008; SEG3009J-008

This QA Inspector randomly observed the following work in progress.

BAY # 14

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## WELDING INSPECTION REPORT

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### OBG13 EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067993 performing the Flux Cored Arc Welding process on weld 138 located at PCMK SEG3011B. ZPMC QC Mr. Zhong Yong Gang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066673 performing the Flux Cored Arc Welding process on weld 400 located at PCMK SEG3011E. ZPMC QC Mr. Zhong Yong Gang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 048047 performing the Shielded Metal Arc Welding process on weld 116 located at PCMK SEG3007H. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2313-Tc-p5-fcm.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 200113 performing the Shielded Metal Arc Welding process on weld 108 located at PCMK SEG3007H. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2313-Tc-p5-fcm.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 20009 performing the Flux Cored Arc Welding process on weld 046 located at PCMK SEG3007F. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-u5-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044795 performing the Flux Cored Arc Welding process on weld 047 located at PCMK SEG3007F. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-u5-f.

### OBG 14WEST

This Quality Assurance (QA) Inspector observed ZPMC personnel performing heat straightening, members identified as anchorage plate AP3021, AP3022, AP3013. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Zhang Lin was present to monitor the heat straightening process. The heat straightening appeared to comply with heat straightening Report HSR1 (B)-9697. Weld number was identified as SEG3020AP-004 and SEG3020AQ-026.

### OBG 14EAST

This QA Inspector observed ZPMC personnel performing Ultrasonic Testing for the splice weld between AP3011 and AP3010. Weld number was identified as SEG3019AQ-028.

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

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# WELDING INSPECTION REPORT

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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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<b>Inspected By:</b>	Utekar,Shrikant	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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