

**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-019024**Date Inspected:** 19-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:** 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:

BAY # 14

This QA Inspector randomly observed the following work in progress.

**OBG 13EAST**

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066422 performing the Shielded Metal Arc Welding process on weld 046 located at PCMK SEG3007L. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SAMW-3G (3F)-Fcm-Repair-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068097 performing the Shielded Metal Arc Welding process on weld 004 located at PCMK SEG3007L. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2211-B-u2-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037840 performing the Shielded Metal Arc Welding process on weld 154 located at PCMK SEG3011G. ZPMC QC Mr. Wang Xu was monitoring this

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welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2113-Fcm-1.

## OBG 14 EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 201087 performing the Shielded Metal Arc Welding process on weld 095 located at PCMK SEG3019X. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2212-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044772 performing the Shielded Metal Arc Welding process on weld 055 located at PCMK SEG3019Y. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-u4b-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044824 performing the Flux Cored Arc Welding process on weld 323 located at PCMK SEG3019D. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066283 performing the Flux Cored Arc Welding process on weld 46 located at PCMK SEG3019N. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2133-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC erected SA3357~SA3362 in lift 14 east.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066413 performing the Shielded Metal Arc Welding process on weld 023 located at PCMK SEG3019T. ZPMC QC Mr. Zhong Guo 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 067656 performing the Shielded Metal Arc Welding process on weld 031 located at PCMK SEG3019T. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2113-Fcm-1.

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

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