

**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-019261**Date Inspected:** 17-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen.**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 components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar 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 Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3013H-007 [I-rib stiffener of Floor Beam (FB) 3192A to Sub Assembly (SA) 3178A, complete joint penetration (CJP) weld; at Panel Point (PP) 119]. The welder is identified as 067183 and was observed welding in the 4G position. ZPMC Quality Control (QC) was identified as Qiu Wen. The welding variables recorded by QC appeared to comply with Welding Procedure Specification (WPS): B-P-2214-TC-U4b-FCM-1.

The SMAW process on weld joint no: SEG3013Y-357 (I-rib stiffener of FB3191A to SA3167A, CJP weld; at PP119]. The welder is identified as 067183 and was observed welding in the 4G position. ZPMC QC was identified as Qiu Wen. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

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The SMAW process on weld joint nos: SEG3013AA-005, 007 and 009 [I-rib stiffener of Edge Panel (EP) 3020A to FB3178A, CJP weld; at PP118]. The welder is identified as 051348 and was observed welding in the 4G position. ZPMC QC was identified as Qiu Wen. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3013Q-210 [I-rib stiffener on Bottom Panel (BP) to FB3178A, CJP weld; at PP118]. The welder is identified as 066421 and was observed welding in the 3G position. ZPMC QC was identified as Sun Tian Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-ESAB.

OBG Seg 13CW:

The FCAW process on weld joint no: SEG3015H-201, fillet weld on FB3224A, at PP123. The welder is identified as 066734 and was observed welding in the 2F position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2132-ESAB.

The FCAW process on weld joint no: SEG3015H-205, CJP weld on FB3224A, at PP123. The welder is identified as 066734 and was observed welding in the 2G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

The FCAW process after back gouging on weld joint no: SEG3015B-271 [Vertical Plate (VP) to Side Panel (SP), CJP weld; at PP122.5 to 124.5]. The welder is identified as 067876 and was observed welding in the 4G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2234-ESAB.

OBG Seg 13BW:

The FCAW process on weld joint no: SEG3015B-271 [Vertical Plate (VP) to SP, CJP weld at PP122. The welder is identified as 067896 and was observed welding in the 2G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

During random inprocess visual inspection, this QA Inspector observed that the Edge Beams (EB) 3037A and EB3036A (at PP122; Cross Beam side) are misaligned by 12mm and needs to be corrected. This is also informed to ZPMC QC. See attached photo for further details.

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

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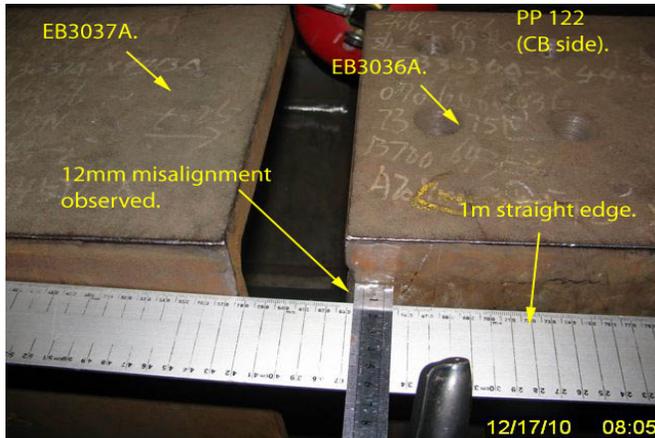
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# WELDING INSPECTION REPORT

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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; phone: 15000422372., who represents the Office of Structural Materials for your project.

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