

**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-019269**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:** 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:

Notification no: 007918.

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The members are identified as OBG components. The weld designations MT inspected are as follows:

1) SEG3013T- 083, 106, 107, 108.

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

Repair welding of weld joint no: SEG3013Q-040 [Longitudinal Diaphragm (LD) to Floor Beam (FB), complete

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## WELDING INSPECTION REPORT

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joint penetration (CJP) weld at PP118]. The welder is identified as 045221 and was observed welding in the 3G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Liming Yang. The welding variables recorded by this QC appeared to comply with WPS:

345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per Critical Welding Repair Report (CWR): B-CWR 2523 Rev-0.

OBG Seg 14W:

The Flux Cored Arc Welding (FCAW) process on weld joint nos: SEG3020Z-079, 080 and 081 [LD to Bottom panel (BP) CJP weld, at PP125.5 to PP127]. The welders are identified as 066734, 045175 and 058240 and were observed welding in the 2G position. ZPMC QC was identified as Zhang Lin. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

The FCAW process on weld joint nos: SEG3020X-014 and 011 (LD to BP, CJP weld, at PP126.5 to PP127). The welders are identified as 069494 and 045276 and were observed welding in the 2G position. ZPMC QC was identified as Zhang Lin. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

The FCAW process on weld joint no: SEG3020Y-030 (LD to BP, CJP weld, at PP127 to PP127.3). The welder is identified as 047866 and was observed welding in the 2G position. ZPMC QC was identified as Zhang Lin. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

This QA Inspector did the visual inspection of the FB to RS stiffeners weld at PP119+1500 and at PP119-1500.

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

### 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
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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