

**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-019384**Date Inspected:** 17-Jan-2011**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:** Liu Hua Jie**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:**

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

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

**WELDING:****Segment 12BE**

This QA Inspector observed ZPMC qualified welding personnel identified as 050289 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG3001X-051; located On Orthotropic Box Girder (OBG) Bottom Plate to Longitudinal Diaphragm CJP Weld; The Welding Repair Report (WRR) was B-WR20103. ZPMC Quality Control (QC) is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appeared to comply with applicable WPS-345-SMAW 2G (2F) FCM-Repair-1. See attached photo for further details.

**Segment 12BE ~ 12CE**

This QA Inspector observed ZPMC qualified welding personnel identified as 044515 perform Shielded Metal Arc Welding (SMAW), weld joint identified as EP3005-001-013; located On Orthotropic Box Girder (OBG) Corner

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Assembly Edge Plate to Edge Plate Transverse Splice CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2214-B-U2-FCM-1. See attached photo for further details.

### Segment 12BE ~ 12CE

This QA Inspector observed ZPMC qualified welding personnel identified as 040320 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SP3020-001-035; located On Orthotropic Box Girder (OBG) Side Plate I-rib to I-rib CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2214-B-U2-FCM-1.

### Segment 12BW

This QA Inspector observed ZPMC qualified welding personnel identified as 046704 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG300K-090; located On Orthotropic Box Girder (OBG) Bottom Plate to Longitudinal Diaphragm CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2212-TC-U4b-FCM-1.

### Segment 12BW ~ 12CW

This QA Inspector observed ZPMC qualified welding personnel identified as 040270 perform Shielded Metal Arc Welding (SMAW), weld joint identified as BP3024-001-037; located On Orthotropic Box Girder (OBG) Bottom Plate T-rib to T-rib CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2213-B-U2-FCM-1.

### Segment 12BW ~ 12CW

This QA Inspector observed ZPMC qualified welding personnel identified as 040270 perform Shielded Metal Arc Welding (SMAW), weld joint identified as BP3024-001-037; located On Orthotropic Box Girder (OBG) Bottom Plate T-rib to T-rib CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2213-B-U2-FCM-1.

DCP:

### Segment Lift 11 (West)

This Quality Assurance (QA) received ZPMC inspection notification sheet 00614 to perform Wire Rope Final tension verification at Panel Point (PP) 95 and PP 108 for Segment 11 (West) Counter Weight and Cross Beam Side Inspected 10% on a random basis and found the tension to be in general compliance.

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

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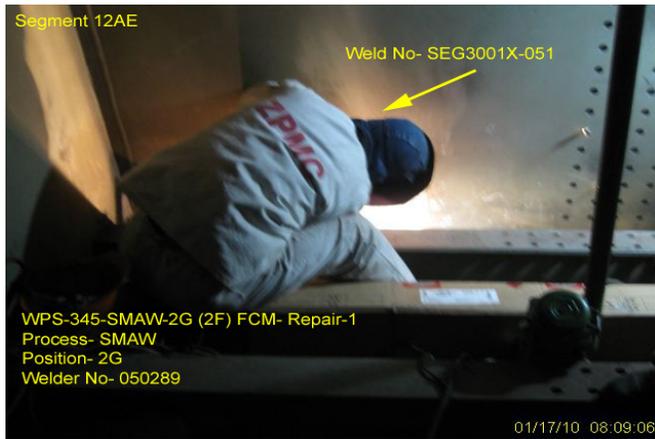
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# WELDING INSPECTION REPORT

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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>	Prabhune,Manoj	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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