

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-019410**Date Inspected:** 28-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:** 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: 007964.

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) B3343-001-404 to 407, 115, 116, 119, 120, 129, 130, 133, 134.

This QA Inspector observed the following work in progress:

OBG Seg 14W and Seg 13CW:

During inprocess visual inspection, this QA Inspector observed that the alignment of Longitudinal Diaphragm

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

(LD) 3048A of Seg 14W and LD3033A of Seg 13CW needs to be corrected. This was observed after the completion of welding of lifting bracket on LD3048A. This is informed to ZPMC CWI Qiu Wen and ABF QA Qasi Wang. See attached photo for reference.

OBG Seg 13AW:

During random inprocess visual inspection of RS stiffeners (RS3449) with X4193B on Side Panel (SP) 3103B, this QA Inspector observed that the RS stiffeners are not aligned with X4193B. This needs to be corrected by approximately 6-7mm. See attached photos for reference. This is informed to ZPMC CWI Qiu Wen and ABF QA Shao Jian Yuan.

This QA Inspector verified that ZPMC personnel perform pre heating before the start of weld. Also verified that the temperature of the holding ovens for SMAW electrodes is maintained while the electrodes are in use.

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.

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

## 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.

---

<b>Inspected By:</b>	Wadkar,Sailesh	Quality Assurance Inspector
----------------------	----------------	-----------------------------

---

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