

**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 #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019936**Date Inspected:** 20-Sep-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:** Mr. Xu Le Feng.**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:** Tower BAY 10, 11 & jetty**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy 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 observed the following work in progress:

**TOWER BAY 10 & 11:**

Flux Cored Arc Welding (FCAW) welding of welds joint BK004A5-026-076,077,082,083, and Welder is identified as 052075,057180,057266,054069. ZPMC Quality Control (QC) is identified as Mr. Ma Qian Li. The welding variables appeared to comply with the Applicable WPS-B-T-2132.

Shielded Metal Arc Welding (SMAW) welding of welds joint NSD1-FASA3-1B/E-29(North Tower Lift 3), and Critical Welding Repair Report (CWR) T-CWR686, Welder is identified as 050038. ZPMC Quality Control (QC) is identified as Mr. Zhao Qin Sun. The welding variables appeared to comply with the Applicable WPS-345+485-SMAW-4G(4F)-FCM-Repair-2.

SMAW welding of welds joint SSD1-FASA3-1B/E-28(South Tower Lift 3), and Welding Repair Report (WR) T-WR3632, Welder is identified as 044511. ZPMC Quality Control (QC) is identified as Mr. Sun Zhi Wang. The welding variables appeared to comply with the Applicable WPS-345+485-SMAW-2G(2F)-FCM-Repair-2.

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The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06724

## Magnetic Particle Testing (MT)

This QA Inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a MT report for this date. The member is identified as North Tower Lift 5 weld. The weld designations reviewed are as follows.

1.NSD1-TL5-3B/F-16A/B,17A/B,21A/B,23A/B.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06724

## Visual Testing (VT)

This QA Inspector performed VT of 100% of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as North Tower Lift 5 welds. The weld designations reviewed are as follows.

1.NSD1-TL5-3B/F-16A/B,17A/B,21A/B,23A/B.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



## Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

## 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 Michael Ng (15921845703), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Tharikoppada,Reddy	Quality Assurance Inspector
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<b>Reviewed By:</b>	Miller,Mark	QA Reviewer
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