

**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-019963**Date Inspected:** 20-Oct-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. Huang Min**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 BAY 5 to 8**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:

**BAY 6**

Flux Cored Arc (FCAW) welding of welds joint CB3002L-018-128, And Welder is identified as 053609, ZPMC Quality Control (QC) is identified as Mr. Zhang Zhi Wei. The welding variables appeared to comply with the Applicable WPS-B-T-2333-TC-P5-F.

Flux Cored Arc (FCAW) welding of welds joint CB3002A-018-015, And Critical Welding Repair Report(CWR)B-CWR14626, Welder is identified as 066733, ZPMC Quality Control (QC) is identified as Mr. Zhang Zhi Wei. The welding variables appeared to comply with the Applicable WPS-345-FCAW-2G(2F)-Repair-1.

Shielded Metal Arc (SMAW) welding of welds joint CB3002K-003-046, And Welder is identified as 048659, ZPMC Quality Control (QC) is identified as Mr. Zhang Zhi Wei. The welding variables appeared to comply with the Applicable WPS-B-P-2113-B-U3b.

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## BAY 8

Flux Cored Arc (FCAW) welding of welds joint BK004A2-058-016, And Welder is identified as 040706, ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables appeared to comply with the Applicable WPS-B-T-2231-B-L1b-F-1.

FCAW welding of welds joint BK004A5-064-037, And Welder is identified as 500405, ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of welds joint BK004A3-064-051/052, And Welder is identified as 500479, ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables appeared to comply with the Applicable WPS-B-T-2132.

## BAY #7

FCAW welding of welds joint W2-SB9-032-126~131, And Welder is identified as 068047, ZPMC Quality Control (QC) is identified as Mr. Shen Jian Guo. The welding variables appeared to comply with the Applicable WPS-B-T-2132-3.

FCAW welding of welds joint W2-SB9-033-126~131, And Welder is identified as 037723, ZPMC Quality Control (QC) is identified as Mr. Shen Jian Guo. The welding variables appeared to comply with the Applicable WPS-B-T-2132-3.

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

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# WELDING INSPECTION REPORT

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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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