

**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-019995**Date Inspected:** 02-Nov-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

<b>CWI Name:</b>	Mr. Huang Min		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	Yes	No	N/A

**Bridge No:** 34-0006**Component:** OBG BAY 6 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**

Shielded Metal Arc (SMAW) welding of Weld Joint FB3168-002-036, And Welder is identified as 054467, ZPMC Quality Control (QC) is identified as Mr. Shu Yang Hua. The welding variables appeared to comply with the Applicable WPS-B-P-2214-TC-U4b.

Shielded Metal Arc (SMAW) welding of Weld Joint FB3168-004-040, And Welder is identified as 049769, ZPMC Quality Control (QC) is identified as Mr. Shu Yang Hua. The welding variables appeared to comply with the Applicable WPS-B-P-2212-B-U2.

FCAW welding of welds joint CB3002J-001-253, And Critical Welding Repair Report(CWR)B-CWR2093, Welder is identified as 053609, ZPMC Quality Control (QC) is identified as Mr. Shu Yang Hua. The welding variables appeared to comply with the Applicable WPS-B-T-2234-TC-U4b-F.

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### BAY 7

FCAW welding of welds joint W2-SB10-032-126~131, And Welder is identified as 048625, ZPMC Quality Control (QC) is identified as Mr. Cui Jun Jie. The welding variables appeared to comply with the Applicable WPS-B-T-2132-3.

FCAW welding of welds joint W2-SB9-057-126~131, And Welder is identified as 215689, ZPMC Quality Control (QC) is identified as Mr. Cui Jun Jie. The welding variables appeared to comply with the Applicable WPS-B-T-2132-3.

### BAY 8

FCAW welding of Weld joint BK004A5-056-112,115,And Welder is identified as 066413, ZPMC Quality Control (QC) is identified as Mr. Liu Fa Wen The welding variables appeared to comply with the Applicable WPS-B-P-2213-B-U2.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 07199

#### 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 bike path welds. The weld designations reviewed are as follows.

1. BK004A2-055-001,007

#### Visual Testing (UT)

This QA Inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as Bike Path weld. The weld designations reviewed are as follows.

1. BK004A2-055-001,007

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 07205

#### Ultrasonic Testing (UT)

This QA Inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. The member is identified as Bike Path weld. The weld designations reviewed are as follows.

1. BK004A1-059-009
2. BK004A1-060-009

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The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 07207

Visual Testing (UT)

This QA Inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as Bike Path weld. The weld designations reviewed are as follows.

1. BK004A-055

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 Eric Tsang (15000422372), 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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