

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-020239**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:** Mr. Zhu Zhong Hai.**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 Shailesh Gaikwad 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:

**OBG TRIAL ASSEMBLY****OBG Segment 12AW~12BW**

This QA Inspector observed ZPMC qualified welding personnel identified as 040656, Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AW to 12 BW Deck plate to Deck plate joint from inside. Joint identified as CA3012-009. ZPMC QC Identified as Zhou Peng. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1.

**OBG Segment 12AW~12BW**

This QA Inspector observed ZPMC qualified welding personnel identified as 041713, Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AW to 12 BW Deck plate I Rib Hold back area cross beam side. Joint identified as DP3039-001-018, 019, 020, 021, 022, 023. ZPMC QC Identified as Zhou Peng. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-4114-1.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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## OBG Segment 12AW~12BW

This QA Inspector observed ZPMC qualified welding personnel identified as 057333, Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AW to 12 BW Deck plate I Rib Hold back area Counter weight side. Joint identified as DP3049-001-031~036. ZPMC QC Identified as Zhou Peng. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-4114-1. For more information see below attached picture number 1.

## OBG Segment 12AE~12BE Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 040270 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AE~12BE Side plate to Side plate T Rib hold back area VT repair, Bike path side . ZPMC CWI Identified as Liu Hua Jie. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1.

## OBG Segment 12AE~12BE Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 052910 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AE~12BE Side plate to Side plate T Rib hold back area VT repair, Cross beam side . ZPMC CWI Identified as Liu Hua Jie. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1.

## Magnetic Particle Testing:

This QA Inspector observed AB/F Magnetic Particle Testing Inspector, performed MT on OBG Segment 12AE~12BE Bottom plate to Bottom plate T Rib hold back joint. For more information see below attached picture number 2.

## OBG Cross Beam (CB18) Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 054467 Perform Shielded Metal Arc Welding (SMAW) on OBG Cross beam (CB 18) Floor beam diaphragm. ZPMC QC Identified as Huang Min with Critical welding repair report CWR-B-CWR2557. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-4G (4F) -Repair. For more information see below attached picture number 3.

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

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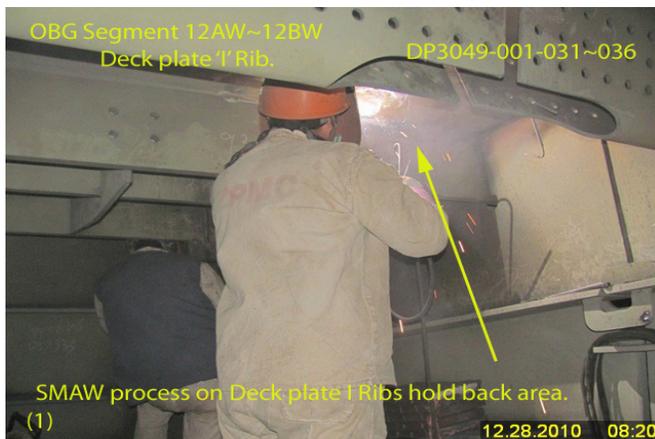
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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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## 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 phone :150-0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Gaikwad,Shailesh

Quality Assurance Inspector

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**Reviewed By:** Carreon,Albert

QA Reviewer