

**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-020279**Date Inspected:** 07-Feb-2011**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:

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

Repair welding of weld joint no: SEG3013AH-041 [K-Plate 3010A to Side Panel (SP) 3101A, complete joint penetration (CJP) weld at Panel Point (PP) 118.35]. The welder is identified as 066002 and was observed welding in the 2G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC Quality Control (QC) was identified as Zhang Ling. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR 20173 Rev-0.

Repair welding of weld joint no: SEG3013AA-010 [Floor Beam (FB) 3178A to I-rib on Edge Plate (EP) 3020B, CJP weld at PP118). The welder is identified as 066261 and was observed welding in the 4G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhang Ling. The welding variables recorded by

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

this QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per WRR: B-WR 20128 Rev-0.

Repair welding of weld joint no: SEG3013AH-024 (FB3187A to KP3012, CJP weld at PP119). The welder is identified as 066261 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhang Ling. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per WRR: B-WR 20171 Rev-0.

OBG Seg 13BW:

The SMAW process on weld joint no: DP3135-020 (X4079F to X4127B of DP3135A, CJP weld at PP120.5). The welder is identified as 037840 and was observed welding in the 3G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-P-2213-TC-U4b-FCM-1.

The SMAW process on weld joint no: DP3135-022 (X4079N to X4127B of DP3135A, CJP weld at PP121). The welder is identified as 066674 and was observed welding in the 3G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-P-2213-TC-U4b-FCM-1.

OBG Seg 14W:

Repair welding of weld joint no: SEG3020X-010 [Longitudinal Diaphragm (LD) 3049A to Bottom Panel (BP) 3091A, CJP weld]. The welder is identified as 045246 and was observed welding in the 2G position. Welding process was identified as SMAW. ABF QA was identified as Xiao Jun Peng. The welding variables appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per Critical Welding repair Report (CWR): 2659 Rev-0.

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3020E-128 (LD3050A to stiffener on FB3343A, fillet weld at PP128.3). The welder is identified as 201215 and was observed welding in the 1F position. ABF QA was identified as Xiao Jun Peng. The welding variables appeared to comply with WPS: B-T-2231-ESAB.

Bay 13:

This QA Inspector observed that the machining of West Grillage is in progress.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---



## Summary of Conversations:

No significant conversations were reported on this date.

## 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>	Peterson,Art	QA Reviewer

---