

**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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020918**Date Inspected:** 22-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:

West Grillage:

Repair welding of weld joint nos: SA712C-246, complete joint penetration (CJP) weld. The welder is identified as 047864 and was observed welding in the 1G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC Quality Control (QC) was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): 345-SMAW-1G(1F)-FCM-Repair. Repair welding was done as per Critical Welding Repair Report (CWR): CWR 2629 Rev-4.

OBG Seg 14W:

The SMAW process on weld joint no: DP3172-021 [Deck Panel (DP) to DP diaphragm, CJP weld]. The welder is identified as 037779 and was observed welding in 2G position. ABF QA was identified as Shen Jian. The welding

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variables recorded by this QC appeared to comply with WPS: B-P-2212-TC-U4b-FCM-1.

The SMAW process on weld joint no: DP3172-081 (DP to DP diaphragm, CJP weld). The welder is identified as 067520 and was observed welding in 2G position. ABF QA was identified as Shen Jian. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-TC-U4b-FCM-1.

The SMAW process on weld joint no: DP3174-019 (DP to DP diaphragm, CJP weld). The welder is identified as 066155 and was observed welding in 2G position. ABF QA was identified as Shen Jian. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-TC-U4b-FCM-1.

The Submerged Arc Welding (SAW) process on weld joint no: Seg3020AP-002 [Top Anchorage Plate (AP3019A) and AP3020A, CJP splice weld]. The welder is identified as 045270 and was observed welding in 1G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-223(2)1T-ESAB-1.

The SMAW process on weld joint no: Seg3020C-029 (SA3416C to FB3348A, fillet weld, at panel point 128.7 - 160). The welder is identified as 201215 and was observed welding in 4F position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2114-FCM-1.

OBG Seg 13AW:

The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3013Q-024 (DP diaphragm to Floor Beam, CJP weld at PP118). The welder is identified as 066734 and was observed welding in 2G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

The FCAW process on weld joint no: Seg3013S-011 (DP diaphragm to Floor Beam, CJP weld at PP117). The welder is identified as 066734 and was observed welding in 2G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

The FCAW process on weld joint no: Seg3013F-019 (DP diaphragm to Floor Beam, CJP weld). The welder is identified as 068445 and was observed welding in 2G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

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

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## 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.

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<b>Inspected By:</b>	Wadkar,Sailesh	Quality Assurance Inspector
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<b>Reviewed By:</b>	Peterson,Art	QA Reviewer
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