

**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-021030**Date Inspected:** 26-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:** Zhou 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:** OBG COMPONENT**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Subhasis Bera was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

In process Inspection

Trial Assembly

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG Segment 12AW, weld No. DP3043-001-333. The welder is identified as #067993. ZPMC QC is identified as Mr. Zhou Peng. The welding variables recorded by QC appear to comply with WPS-345-SMAW-3G(3F)-REPAIR-FCM-1. The weld repair report is identified as WR20149. The welding variables were recorded at, Amperage 155, volts 25.2. The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 3G position for the OBG Segment 12BW, weld No. DP3045-001-333. The welder is identified as #067993. ZPMC QC is identified as Mr. Zhou Peng. The welding variables recorded by QC appear to comply with WPS-345-SMAW-3G(3F)-REPAIR-FCM-1. The weld repair report is identified as WR20149. The welding variables were recorded at, Amperage 152, volts 24.7. The In-process SMAW appears to be progressing in compliance with approved contract documents.

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SMAW in the 1G position for the OBG Segment 12BW to 12CW ,UT repair weld No. OBW12C-001. The welder is identified as #046709. ZPMC QC is identified as Mr.Zhou Zhong Hai. The welding variables recorded by QC appear to comply with WPS-345-SMAW-1G(1F)-REPAIR-FCM-1.The weld repair report is identified as CWR2821. The welding variables were recorded at, Amperage 167, volts 23.7.The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 2G position for the OBG Crossbeam CB17 Weld No. CB3001-017-006. The welder is identified as #067752. ZPMC QC is identified as Mr. Li Yang. The welding variables recorded by QC appear to comply with WPS-B-P-2212-Tc-U4b-FCM-1.The welding variables were recorded at, Amperage 165, volts 25.1.The In-process SMAW appears to be progressing in compliance with approved contract documents.

Ultrasonic Testing (A,B,C and D-Scan )

This QA Inspector performed Ultrasonic testing (UT) verification of the area previously tested and accepted by ABF Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as corner joint joining between edge Plate to Deck Plate for OBG segment 12BW at cross Beam side . The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure 001 rev.1 that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

CA3002-006

This QA Inspector performed Ultrasonic testing (UT) verification of the area previously tested and accepted by ABF Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as corner joint joining between edge Plate to Deck Plate for OBG segment 12CW at cross Beam side . The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure 001 rev.1 that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

CA3004-002

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

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The ABF QA inspector performed D-Scan Ultrasonic Testing for butt joint joining between side plate to bottom plate hold back area at counter weight side on segment 12BW at trial assembly area



ZPMC personnel performing SMAW for holdback weld joint CB3001-017-006 at 2G position on side plate to bottom plate of Crossbeam CB17 at Trial Assembly area



## Summary of Conversations:

No relevant conversations

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

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<b>Inspected By:</b>	Bera,Subhasis	Quality Assurance Inspector
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<b>Reviewed By:</b>	Dsouza,Christopher	QA Reviewer
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