

**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-021105**Date Inspected:** 23-Aug-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 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:

**SEGMENT # 10W:**

Shielded Metal Arc Welding (SMAW) welding of welds joint SEG061A-014(10AW+10BW, SP-BP, CB Side), Welder is identified as 067829. ZPMC Quality Control (QC) is identified as Mr. Zhu Zhong Hai. The welding variables appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

SMAW welding of welds joint OBW10B-003(10AW+10BW, BP-BP), Welder is identified as 067589. ZPMC Quality Control (QC) is identified as Mr. Zhu Zhong Hai. The welding variables appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

SMAW welding of welds joint EP114-001-014(9DW+9EW, I Rib), And Repair Welding Report (WR) B-WR-14693, and Welder is identified as 044551. ZPMC Quality Control (QC) is identified as Mr. Zhu Yuan Yuan. The welding variables appeared to comply with the Applicable WPS-345-SMAW-4G(4F)-FCM-Repair.

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## WELDING INSPECTION REPORT

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SMAW welding of welds joint EP129-001-027,028(9DW+9EW,I Rib,CB Side),And Repair Welding Report (WR) B-WR-14682/B-WR-14683, Welder is identified as 041713. ZPMC Quality Control (QC) is identified as Mr. Zhu Yuan Yuan. The welding variables appeared to comply with the Applicable WPS-345-SMAW-4G(4F)-FCM-Repair.

SMAW welding of welds joint SEG051A-045(9AW+9BW,BP-SP), And Repair Welding Report (WR) B-WR-14700, Welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Zhu Yuan Yuan. The welding variables appeared to comply with the Applicable WPS-345-SMAW-1G(1F)FCM-REPAIR.

SMAW welding of welds joint SEG059A-040/SEG061A-013(10AW+10BW,SP-BP,CW Side), Welder is identified as 067752. ZPMC Quality Control (QC) is identified as Mr. Zhu Zhong Hai. The welding variables appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

### SNUG TIGHTINING:

During surveillance Inspection this QA Inspector was observed SNUG TIGHTINING Activity was in progress at 9BW,Panel Point(PP)76, FL3 Area.

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 Michael Ng (15921845703), 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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