

**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-021107**Date Inspected:** 21-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 # 9W:**

Flux Cored Arc Welding (FCAW) of weld joint OBW10-005(10AW+10BW, CB Side), Welder is identified as 202384. ZPMC Quality Control (QC) is identified as Mr. Zhu Peng. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2233T-1.

Shielded Metal Arc Welding (SMAW) welding of welds joint OBW10B-003(10AW+10BW, BP-BP), Welder is identified as 067752,067829. ZPMC Quality Control (QC) is identified as Mr. Zhu Peng. The welding variables appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

SMAW of weld joint SEG053B-006(9BW-9CW, LD, CW-Side), And Welding Repair Report (WR), B-WR14566, Welder is identified as 041713. And ZPMC Quality Control (QC) is identified as Mr. Zhu Yuan Yuan. The welding variables appeared to comply with the Applicable WPS: WPS-345-SMAW-4G (4F)-FCM-REPAIR.

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# WELDING INSPECTION REPORT

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SMAW welding of welds joint OBW10B-002, 001, Welder is identified as 067571,044556. ZPMC Quality Control (QC) is identified as Mr. Zhu Peng. The welding variables appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

OBG DCP Hand Measurement Survey:

WT Stiffener Offset-FL3 Splices:

This QA Inspector along with Caltrans QA Mr. Manoj Prabhune performed Hand Measurement Survey Inspection for the T-Ribs to T-Ribs FL3 Vertical Offset, Panel Points(PP)-PP80~80.5, PP81~82.

Refernce as shown in photo below.

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
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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