

**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-021314**Date Inspected:** 28-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:

The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3013C-133 (Deck Panel Diaphragm to Floor Beam, complete joint penetration (CJP) weld at panel point (PP) 119.65). The welder is identified as 203871 and was observed welding in 2G position. ZPMC Quality Control (QC) was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with Welding Procedure Specification (WPS): B-T-2232-ESAB.

East Saddle Grillage – West Line:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: Seg3013AH-014 (K-Plate 3009A to West Grillage, CJP weld at PP119-1500). The welder is identified as 066002 and was observed welding in 3G position.

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## WELDING INSPECTION REPORT

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ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: B-P-2213-B-U3b.

The SMAW process on weld joint no: Seg3013AH-030 (K-Plate 3015A to West Grillage, CJP weld at PP119+1500). The welder is identified as 066002 and was observed welding in 3G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: B-P-2213-B-U3b.

The FCAW process on weld joint no: Seg3013H-050 [Floor Beam (FB) 3187A to West Grillage, CJP weld at PP119). The welder is identified as 069469 and was observed welding in 3G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

The FCAW process on weld joint no: Seg3013F-052 (FB3191A to West Grillage, CJP weld at PP119+1500). The welder is identified as 068445 and was observed welding in 3G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

The SMAW process on weld joint no: Seg3013F-040 and 048 (35mm thickness extension piece to West Grillage, CJP weld at PP119+1500). The welder is identified as 066002 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-P-2212-B-U3b.

For the above mentioned welds, welding was performed after back-gouging. MT (by ABF) was observed to be after back gouging of these welds.

This QA Inspector also observed that the repair welding of 2 welds (weld joint nos: SA7512C-257 and 258) are still outstanding.

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

### 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
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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