

**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-021592**Date Inspected:** 20-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:** Mr. Xu Le Feng.**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:** Tower and Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad 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:

**BAY 10**

This QA Inspector performed randomly Visual Inspection and Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 (UT) report for this date. The member is identified as Tower lift 6 Ring hole. The weld designations reviewed are as follows.

SSD1-TPSA6-1-3, 4

NSD1-TPSA6-1-3, 4

NDT Notification No-08349

This QA Inspector observed the following work in progress:

**BAY 10: SMAW Process:**

This QA Inspector observed ZPMC qualified welding personnel identified as 044011, 040581, Perform Shielded Metal Arc Welding (SMAW) on OBG Cantilever box bracket. Joint identified as BK15A-001-011, 012. ZPMC QC Identified as Yin Chun Fang. The welding parameters as measured using QC's calibrated instrument appeared

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to be in general compliance with WPS-B-P-2212-Tc-U4c. For more information see below attached picture number 1.

This QA Inspector observed ZPMC qualified welding personnel identified as 040581, Perform Submerged Arc Welding (SAW) on OBG Cantilever Beam Plate. Joint identified as BK16B-001-001, 002. ZPMC QC Identified as Wang Chang Xin. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2221-B-U2S-4.

Tower Lift 6: FCAW Process,

This QA Inspector observed ZPMC qualified welding personnel identified as 052075, Perform Flux Core Arc Welding (FCAW) on Tower lift 6 Diaphragm Box. Joint identified as SSD1-DPSA6-1-1, 2 and NSD1-DPSA6-3-3, 4. ZPMC QC Identified as Li Peng Fei. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132-ESAB and WPS-B-T-2232-ESAB. For more information see below attached picture number 2.

SMAW Process:

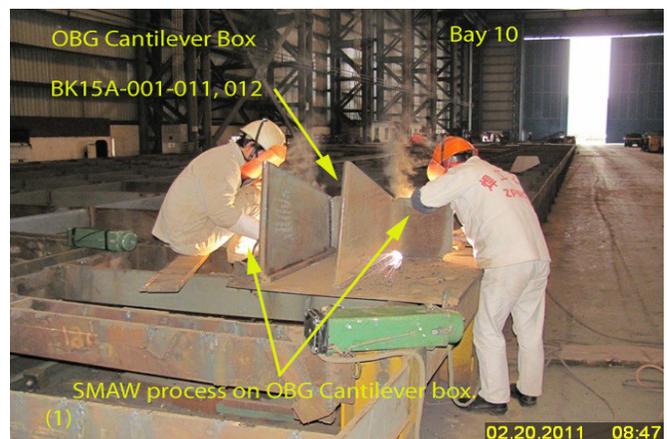
This QA Inspector observed ZPMC qualified welding personnel identified as 053829, 500363, 057258, Perform Shielded Metal Arc Welding (SMAW) on OBG Bike path sole plate. Joint identified as BK004A2-032-030, 031, 032, 033, 34, 35. ZPMC CWI Identified as Guo Yan Fei. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2312-Tc-P4.

BAY 11,

FCAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 205649, Perform Flux Core Arc Welding (FCAW) on OBG Bike path angle plate. Joint identified as BK005A7-003-235. ZPMC QC Identified as Shao Hai Lang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2112-ESAB.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



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**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 Thomas Ho: 150002048250, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Gaikwad,Shailesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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