

**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-022140**Date Inspected:** 26-Mar-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

<b>CWI Name:</b>	Mr. Liu hua jie		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	Yes	No	N/A

**Bridge No:** 34-0006**Component:** Orthotropic Box Girder( OBG)**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu 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 observed and/or found the following:

OBG Trial Assembly open yard.

This QA Inspector randomly observed the following work in progress:

Segment: 13AW

Shielded Metal Arc Welding (SMAW) welding of weld joint identified as SEG3013AA-109. Welder is identified as 067707. ZPMC QC is identified as Mr. Zhang Qiang. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2212-TC-U4b-FCM-1.

SMAW welding of weld joint identified as SEG3013AD-003. Welder is identified as 069683. ZPMC QC is identified as Mr. Zhang Qiang. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2214-TC-U4b-FCM-1.

Flux Cored Arc Welding (FCAW) welding of weld joint identified as SEG3013M-189,190. Welder is identified as 048696. ZPMC QC is identified as Mr. Zhang Qiang. The welding variables recorded by QC personnel observed

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appeared to comply with WPS: WPS-B-T-2132-ESAB.

FCAW welding of weld joint identified as SEG3013N-098,099. Welder is identified as 203871. ZPMC QC is identified as Mr. Zhang Qiang. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-T-2132-ESAB.

During random in process inspection of OBG Segment 13AW at Panel Point 120 at FL3 area, this QA observed an arc strikes on side plate. This QA marked the affected area and informed ZPMC QC identified as Mr. Zhang Qiang of this issue. Mr. Zhang Qiang informed this QA that the arc strikes would be corrected in a manner compliant with the contract documents. See attached photos for further information.

Segment:13AE

FCAW welding of weld joint identified as SEG3007R-011. Welder is identified as 066236. ZPMC QC is identified as Mr. Liu hua jie. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-T-2232-ESAB.

SMAW repair welding of weld joint identified as DP3078-001-012,014. Welder is identified as 066418. ZPMC QC is identified as Mr. Liu hua jie. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-345-SMAW-3G (3F)-FCM-repair-1. The repair welding was being performed as per Welding Repair Report (WRR) No: B-WR20509.

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 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prabhu,Surendra	Quality Assurance Inspector
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<b>Reviewed By:</b>	Peterson,Art	QA Reviewer
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