

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-023206**Date Inspected:** 27-Apr-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:** Sun Tian Liang**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**Summary of Items Observed:**

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

This Quality Assurance (QA) Inspector observed the following work in progress:

OBG TA YARD

Segment 14W:

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3020E-001 [Deck Panel (DP) diaphragm to Floor Beam (FB) Sub Assembly FB3343A, Complete Joint Penetration (CJP) weld at Panel Point (PP) 128.3]. The welder is identified as 066695 and was observed welding in 2G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

The FCAW process on weld joint no: SEG3020D-038 [DP diaphragm to FB Sub Assembly FB3343A, CJP weld at PP 128.3]. The welder is identified as 067103 and was observed welding in 2G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

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The FCAW process on weld joint no: SEG3020B-055 [FB 3347A to Bottom Plate Sub Assembly (SA) 8509A, CJP weld at PP 128.7]. The welder is identified as 067103 and was observed welding in 2G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

The FCAW process on weld joint no: SEG3020C-057 [FB 3347A to Bottom Plate Sub Assembly (SA) 8509A, CJP weld at PP 128.7]. The welder is identified as 066695 and was observed welding in 2G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

During random in process visual inspection this QA Inspector observed the following in process activities.

ZPMC personnel were performing alignment of OBG segment 14W with segment 13CW.

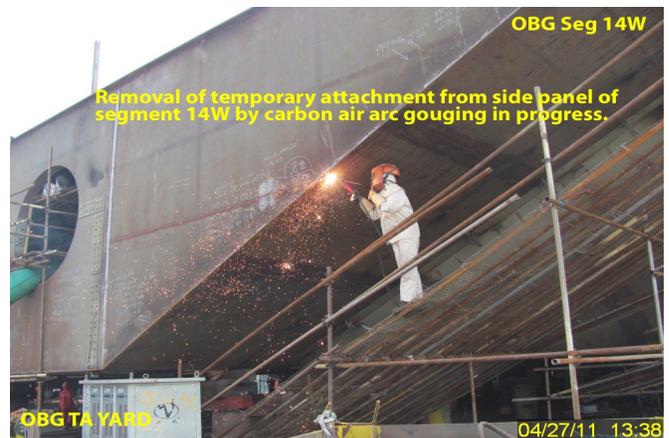
ZPMC personnel performing alignment of Cross Beam (CB) 19 with FL3 area of segment 14W.

The removal of the temporary attachments from side panels (SP) by carbon air arc gouging in progress.

Repair excavation of weld joint SEG3020AZ-001 [Joining SP 3142A to Bottom Panel (BP) 3094A] by carbon air arc gouging from PP127 to PP128.

Attached photographs provide additional details.

Unless otherwise noted, all work observed on this date appeared to generally comply with 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 Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

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