

**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-024443**Date Inspected:** 03-May-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. Gang Wei		
<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:**

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 Chang xing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

**OBG Trial Assembly****SMAW Process:**

This QA Inspector observed ZPMC qualified welding personnel identified as 068091 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 14 East. Joint identified as SEG3019AH-001. ZPMC QC Identified as Zhu Yuan Yuan. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2212-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 066733 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 14 East. Joint identified as SEG3019\*-020. ZPMC QC Identified as Zhu Yuan Yuan. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2212-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 066416, 068924, 068097, Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 13AE+13BE Deck panel to Deck panel. Joint identified

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as OBE13-002. ZPMC QC Identified as Wang Li Yang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2211-B-U2a-FCM-1. For more information see below attached picture number 1.

### FCAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 051356 Perform Flux Core Arc Welding (FCAW) on OBG Segment 13 East. Joint identified as SEG3019G-097, 099. ZPMC QC Identified as Zhu Yuan Yuan. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2133-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 067079 Perform Flux Core Arc Welding (FCAW) on OBG Segment 13 East. Joint identified as SEG3019V-097, 102, 107, 112, 117. ZPMC QC Identified as Zhu Yuan Yuan. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132-ESAB.

### Repair welding, SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 037723 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 14 East. Joint identified as SEG3019AW-148, 138. ZPMC CWIQC Identified as Zhu Yuan Yuan with Temporary welding repair report WRR-B-WR20791. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1.

### Repair welding, SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 066418 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 14 East. Joint identified as SEG3019P-197, 202. ZPMC CWIQC Identified as Zhu Yuan Yuan with Temporary welding repair report WRR-B-WR20247. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1.

### Repair welding, SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 216086 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 14 East. Joint identified as SEG3019\*-033. ZPMC CWIQC Identified as Zhu Yuan Yuan with Temporary welding repair report WRR-B-WR20899. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. For more information see below attached picture number 2.

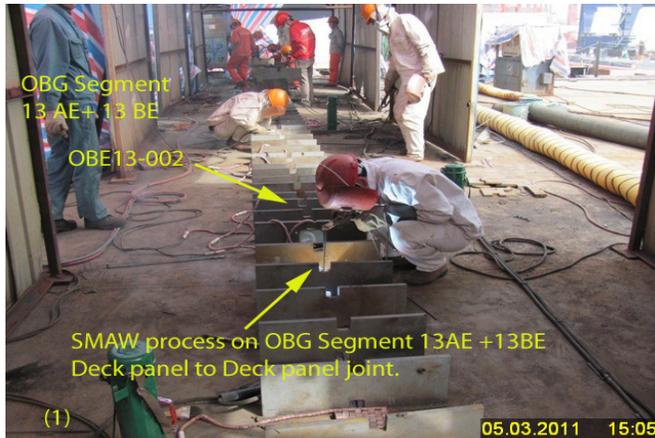
Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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

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**Inspected By:** Gaikwad,Shailesh Quality Assurance Inspector

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**Reviewed By:** Patterson,Rodney QA Reviewer