

**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-024510**Date Inspected:** 04-Jun-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:** Liu Hua Jie**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 COMPONENT**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Subhasis Bera was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

Ultrasonic Testing (A, B, C and D-Scan)

This QA Inspector performed Ultrasonic testing (UT) verification of the area previously tested and accepted by ABF Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as splice joint joining between side plate to side plate for OBG segment 13AW to 13 BW at cross beam side. The result was recorded onto a data sheet according to rejection criteria of "D" Scan procedure 001 rev.1 that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designations are as follows

OBW13D-003,004

CWR verifications (CWR3013R0)

Type – (D-Scan)

This QA Inspector was notified via email for verification of B-CWR3013R0 at 1400 hours the following was

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observed:

- The components for verification were identified as SEG3013AA-108,CA3015A-004(13AW to 13BW SP to EP corner joints)
  - Weld repair was to be performed on location where rejectable indication was observed during Ultrasonic Testing (UT).
  - ZPMC QC Zhou Zhong Hai was present on site to direct and record all repair work.
- WPS to be used for repair was WPS-345-SMAW-2G (2F)-FCM-Repair-1 .

CWR verifications (CWR3014R0)

Type – (D-Scan)

This QA Inspector was notified via email for verification of B-CWR3014R0 at 1400 hours the following was observed:

- The components for verification were identified as SEG3013AA-120,CA3015A-001(13AW to 13BW DP to EP corner joints)
  - Weld repair was to be performed on location where rejectable indication was observed during Ultrasonic Testing (UT).
  - ZPMC QC Zhou Zhong Hai was present on site to direct and record all repair work.
- WPS to be used for repair were WPS-345-SMAW-2G (2F)-FCM-Repair-1 and WPS-345-SMAW-4G (4F)-FCM-Repair-1.

CWR verifications (CWR3015R0)

Type – (D-Scan)

This QA Inspector was notified via email for verification of B-CWR3015R0 at 1400 hours the following was observed:

- The components for verification was identified as OBW13-002(13AW to 13BW EP to EP splice joint)
  - Weld repair was to be performed on location where rejectable indication was observed during Ultrasonic Testing (UT).
  - ZPMC QC Zhou Zhong Hai was present on site to direct and record all repair work.
- WPS to be used for repair were WPS-345-SMAW-3G (3F)-FCM-Repair-1 and WPS-345-SMAW-4G (4F)-FCM-Repair-1.

CWR verifications (CWR3008R1)

Type – (D-Scan)

This QA Inspector was notified via email for verification of B-CWR3008R1 at 1600 hours the following was observed:

- The components for verification were identified as OBW13B-001,003,005(13AW to 13BW BP splice joint)
  - Weld repair was to be performed on location where rejectable indication was observed during Ultrasonic Testing (UT).
  - ZPMC QC Zhou Zhong Hai was present on site to direct and record all repair work.
- WPS to be used for repair were WPS-345-SMAW-1G (1F)-FCM-Repair-1 and WPS-345-SMAW-4G (4F)-FCM-Repair-1.

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

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documents.

**Summary of Conversations:**

No relevant conversations

**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 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Bera,Subhasis	Quality Assurance Inspector
<b>Reviewed By:</b>	Dsouza,Christopher	QA Reviewer

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