

**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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024700**Date Inspected:** 14-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) Chanxing Island **Location:** Shanghai, China**CWI Name:** Mr. SHI LIE**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 Segment**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Santhosh Ramakrishna Pillai was present during the times noted above for observations relative to fabrication work of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China.

This QA inspector randomly observed the following work:

## 1. INPROCESS:

Orthotropic Box Girder (OBG) at Trial Assembly Area:

ZPMC welding personnel performing Shielded Metal Arc Welding of Fillet welds joining the splice plate connection plate weld joint located on 13W. The weld is designated as SA3137B-001-003. The welder is identified as 067947. ZPMC QC Mr. HU MEI GANG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2112-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding of Fillet welds joining the splice plate connection plate weld joint located on 13W. The weld is designated as SA3129A-006-001. The welder is identified as 069841. ZPMC QC Mr. HU MEI GANG was onsite monitoring the welding variables. The inprocess

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Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2112-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding of Fillet welds joining the splice plate connection plate weld joint located on 13W. The weld is designated as SA3137C-002-005. The welder is identified as 069896. ZPMC QC Mr. HU MEI GANG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2112-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding of Fillet welds joining the splice plate connection plate weld joint located on 13W. The weld is designated as SA3192B-006-003. The welder is identified as 061765. ZPMC QC Mr. HU MEI GANG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2112-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding of Fillet welds joining the splice plate connection plate weld joint located on 13W. The weld is designated as SA3173A-001-001. The welder is identified as 066156. ZPMC QC Mr. HU MEI GANG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2112-FCM-1.

During the random visual inspection of welds located on Segment 14W at panel point 126.5 east side, this Quality Assurance Inspector (QA) observed that ZMPC MT technician personnel performed MT on Floor beam to side plate weld joint identified as SEG3020P-256, during visual inspection of the weld this Quality Assurance Inspector (QA) found base metal damage near the weld. The ZPMC QC is identified as Mr. AN QING XING. QA inform to ZPMC that prior to the repair welding, to prepare report as per the contract and ensure with VT and MT all defect have been removed. See the attached picture.

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



## Summary of Conversations:

No relevant conversations were reported on this date.

## Comments

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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>	Pillai,Santosh	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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