

**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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025978**Date Inspected:** 27-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. AN QIANG XING**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) Lift-14West at Bay-14:

No significant work observed during the time of Inspection on Lift-14W located on Bay -14. See the attached picture.

Orthotropic Box Girder (OBG) Bay-14:

ZPMC welding personnel performing Shielded Metal Arc Welding of Fillet welds joining the Traveler rail bracket weld joint located on BAY-14. The weld is designated as SA8508-001-020. The welder is identified as 051359. ZPMC QC Mr. ZHU LIN was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2213-TC-U4c. See the attached picture.

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## 2. NDT:

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

UT carried out for the ABF submitted UT Report.

This QA Inspector not performed Ultrasonic testing (UT) due to not provide the safe access by ZPMC. The members are identified as butt joint between bottom plate to side plate hold back weld joint located on 14W at cross beam side. See the attached picture. The Weld Designation is as follows:

### 1. SEG3020AZ-002.

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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