

**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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000863**Date Inspected:** 15-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Lefeng**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:** Tower Mock Up**Summary of Items Observed:**

Tower Mock Up:

Bay 2:

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower Mock Up.

The QA Inspector performed a minimum 10% random Magnetic Particle Inspection (MT) of 89M Diaphragm Assembly MUSB-SA13/p213 at Weld Joint (WJ) numbers MUSB-SA13B/C-1, -2, -5, -6, -13, 14, -17 and -18 attaching web plates to Upper Diaphragm MUSB-SA13. The QA Inspector observed no apparent indications. The QA Inspector randomly observed that ZPMC MT Technicians Cai Xin Xin and Zhou Dongyun, had performed 100% MT Inspection of the above WJ's, accepted the welds and placed the information adjacent to the above welds. The attached photographs provide additional detail.

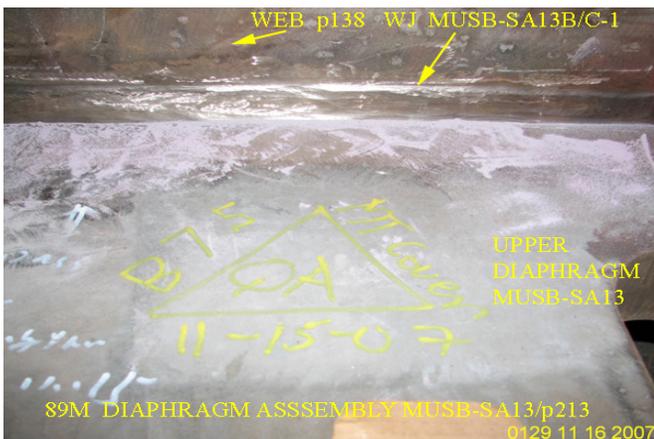
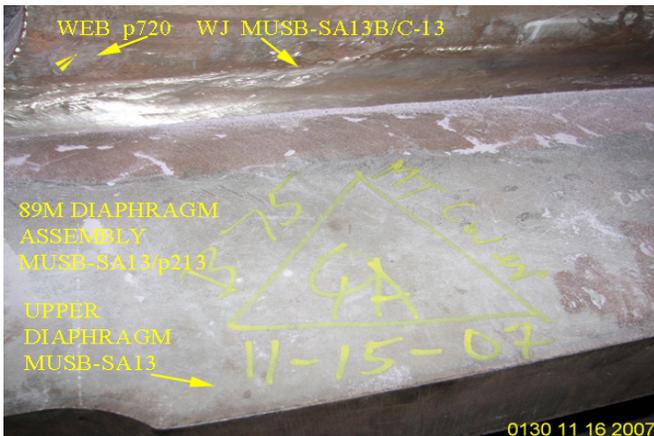
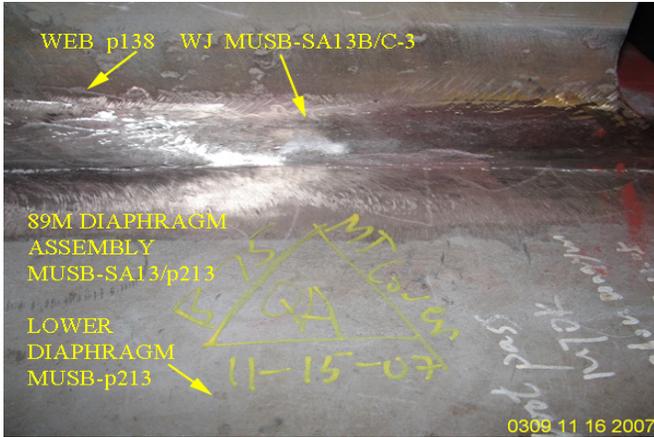
The QA Inspector randomly observed ZPMC personnel rigging and lifting 89M Diaphragm Assembly MUSB-SA13/p213, to flip over in order to allow for the QA Inspector to perform a minimum 10% MT Inspection of the welds attaching the webs to the Lower Diaphragm MUSB-p213. The attached photograph provides additional detail.

The QA Inspector performed a minimum 10% random Magnetic Particle Inspection (MT) of 89M Diaphragm Assembly MUSB-SA13/p213 at WJ numbers MUSB-SA13B/C-3, -4, -7, -8, -15, 16, -19 and -20 attaching web

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plates to Lower Diaphragm MUSB-p213. The QA Inspector observed no apparent indications. The QA Inspector randomly observed that ZPMC MT Technicians Cai Xin Xin and Zhou Dongyun, had performed 100% MT Inspection of the above WJ's, accepted the welds and placed the information adjacent to the above welds. The attached photographs provide additional detail.



## Summary of Conversations:

There were no relevant conversations.

## 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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Franco,Charlie	Quality Assurance Inspector
<b>Reviewed By:</b>	Cochran,Jim	QA Reviewer

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