

**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-001814**Date Inspected:** 22-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1800**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Sun Wei and Hu Wei Ging**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 deck panels and side panels**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall 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 Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG bay 1

QA visually inspected completed welds on deck panel DP-110-002. All welds that were inspected appeared to exhibit some degree of lack of fusion, overlap and/or under fill. QA completed the visual inspection of this deck panel and completed a Caltrans QA visual weld inspection report for the OBG deck panel mentioned above. The report is filed in the QA office.

QA observed ZPMC qualified welding personnel perform a single head / single welder PMT for deck panels DP-137-001 weld W3 and DP-002-001 weld W8. Apparently these specific welds were not completed the day before, necessitating a PMT re-qualification for the welding head and the welder in order to finish the welds mentioned above per the contract documents. QA verified and documented the welding parameters for this PMT. A U-Ribs PMT inspection sheet was completed and filed in the QA office. The parameters appeared to comply with the posted WPS's. The results are as follows:

GMAW

Volts: 30.4 Amps: 375 Travel speed: 530

SAW

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# WELDING INSPECTION REPORT

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Volts: 25.4 Amps: 680 Travel speed: 520

OBG new assembly bay

QA observed ZPMC personnel beveling OBG side panel plates in preparation for fit-up and welding. On this day there was no welding being performed in this area. QA took a random inventory of the OBG side panel segments that have the CJP splice joints completely welded. It is as follows:

- SEG-015A-001
- SEG-015A-003
- SEG-015A-005
- SEG-013A-012
- SEG-019A-020
- SEG-013A-017
- SEG-016A-004
- SEG-016A-006
- SEG-016A-002
- SEG-014A-012
- SEG-014A-017
- SEG-014A-006



## Summary of Conversations:

No significant conversations took place on this day 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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hall,Steven	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer

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