

**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-004723**Date Inspected:** 04-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	

**Bridge No:** 34-0006**Component:** diaphragm plate and double diaphragm assem**Summary of Items Observed:**

Heavy Shop- Bay 2

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) performed final 100% VT and MT on outer end 450mm of weld NSD1-SA322B/B-5 on 33M double diaphragm. The area had previously been rejected for an indication and repaired by grinding. No apparent indications were observed. QA Inspector signed green tag document with the notation "per ABF documentation".

Sub-assembly Shop- Bay 4

QA Inspector performed final 100% VT and 10% MT verification of the total linear distance of the 10% final MT performed by ZPMC on weld WSD1 SA315-16, diaphragm plate to flange plate weld only- one side only.

**Summary of Conversations:**

ZPMC QC Ken Zhang informed QA Inspector that the above noted components were ready for Caltrans final VT and MT and subsequent green tagging.

**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 Joshua Ishibashi, 136-6471-0411, who represents the Office of Structural Materials for your project.

**Inspected By:** Goulet, George

Quality Assurance Inspector

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# WELDING INSPECTION REPORT

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**Reviewed By:** Carreon,Albert

QA Reviewer