

**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-004763**Date Inspected:** 15-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** li yun hua**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**Summary of Items Observed:**

Tower Shop Bay 3 Deck Panel repairs

This Caltrans QA Inspector arrived at ZPMC at Changxing Island for the continued observation of the SAS structure fabrication. During this QA inspectors observations in tower shop bay 3 it was noted that ZPMC was performing deck panel repairs on 3 panels by grinding and welding. There are 20 deck panels currently inside this location with 8 ZPMC personnel and 3 QC personnel. This Caltrans QA Inspector performed initial VT along with ZPMC and ABF on 3 deck panels listed as DP414-001, DP360-001 and DP333-002, these panels are ready for ZPMC to perform the weld repairs at the locations identified by all 3 parties. This QA Inspector also received notification from ZPMC QC personnel for final VT of deck panels DP171-001, DP333-001 and DP198-001. These panels were visually inspected by all 3 parties and found the repaired areas appeared to be within compliance at the time of the inspection. All 3 parties signed the ABF yellow tracking tag affixed to each deck panel as completed per each inspection process. This QA Inspector noted that ZPMC had CWI Li Yan Hua within the shop at periodic intervals to monitor and perform VT inspection as required. ABF personnel observed with bay 3 for repairs and inspection were Kevin Chen and Wong Wei.

OBG Bay 3 UT

This QA inspector received notification for inspection from ZPMC for T stiffeners in bay 3. This QA Inspector performed UT verification for the CJP splice of the T stiffeners after ZPMC had completed and accepted the welds by UT. This QA Inspector's verification consisted of 10% of the weld lengths tested by ZPMC and found that the welds appeared to be within compliance at the time of review. The weldments tested were BP125-001-005,027,

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006 and 029, BP 071-001-001,002,019 and 021, and BP044-001-001~006,019,021,023,025,027 and 029. A TL-6027 will be generated for these locations.

**Summary of Conversations:**

As noted above.

**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 Peter Dautermann , 1-500-219-9593, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Riley, Ken	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon, Albert	QA Reviewer

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