

**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-004764**Date Inspected:** 18-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

<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	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG	

**Summary of Items Observed:**

OBG Bay 3 UT

This Caltrans QA Inspector arrived at ZPMC at Changxing Island for the continued observation of the SAS structure fabrication. This QA inspector received notification for inspection from ZPMC for T stiffeners and side plate CJP splices in bay 3. This QA Inspector performed UT verification for the CJP splice of the CJP splices 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 T stiffeners were performed by lot testing of 25% as outlined within the special provisions. The weldments tested were BP125-001-003~004, 019, 023 and 025, BP 071-001-003~006, 023, 025, 027 and 025, BP098-001-001~006, 019, 021, 023, 025, 027 and 029, BP152-001-001~006, 019, 021, 023, 025, 027 and 029, and BP179-001-001~006, 019, 021, 023, 025, 027 and 029. A TL-6027 will be generated for these locations.

OBG Bay 7 UT

This Caltrans QA Inspector arrived at ZPMC at Changxing Island for the continued observation of the SAS structure fabrication. This QA inspector received notification for inspection from ZPMC for Floor beams in bay 7. This QA Inspector performed UT verification for the CJP weld 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 weldment tested was FP012-013-045. This weld joint was for green tag processing by ABF. This QA inspector signed the yellow affixed tag for this area. A TL-6027 will be generated for these locations.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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**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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