

**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-004777**Date Inspected:** 05-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island, Shanghai

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>
<b>Inspected CWI report:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
		<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG and tower components	

**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) representative was present for observations relative to fabrication performed by Zhenhua Port Machinery Company (ZPMC) for the fabrication of Orthotropic Box Girder (OBG) and SAS Tower at Changxing Island, in Shanghai, China. While on site the QA Inspector noted the following:

9 miter diaphragm.

1. The QA Inspector performed a random Visual (VT) and Magnetic Particle Testing (MT) verification on the completed Partial Joint Penetration (PJP) and fillet welds made between the part assembly numbers: wsd1-sa78, wsd1-sa94, wsd1-sa 93, wsd1-sa92, wsd1-sa91, wsd1-sa90, wsd1-sa89, wsd1-sa88, wsd1-sa87, wsd1-sa60 and wsd1-sa57 on the 9 miter diaphragm. Multiple welds were verified on this diaphragm; please see the ZPMC Non Destructive Examination (NDE) notification document number 001297 for additional information. The QA Inspector performed the VT and MT verifications on these welds after ZPMC Quality Control Inspection personnel had completed the VT, MT inspections and reported the welds to be acceptable and ready for the QA Inspector verification. The QA Inspector did not observe any welding related discontinuities and did not observe any relevant indications during the verifications. The QA Inspector notified Task Leader Albert Carreon of the observations during verification. Please see the QA Inspector's Magnetic Particle Testing (TL 6028) report generated on this date for additional information.

Floor Beam FB011.

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## WELDING INSPECTION REPORT

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2. The QA Inspector performed a random Visual and Ultrasonic Testing (UT) verifications on the Complete Joint Penetration (CJP) tee joint welds made on the floor beam part members identified as weld number FB011-012-043 and FB011-021-043 on the floor beam number FB011. The QA Inspector performed the UT verification after the ZPMC QC Inspectors reported the welds to be acceptable and ready for verification. The QA Inspector did not observe any rejectable welding discontinuities on any of the tested welds mentioned above. The QA Inspector notified the ZPMC, ABF / QC, Inspection personnel of the QA Inspector's UT verification results. Please see the QA Inspector Ultrasonic Test report (TL 6027) when testing is completed for additional information.

### **Summary of Conversations:**

As noted in the report 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, (1500) 129-9593, who represents the Office of Structural Materials for your project.

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

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