

**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-004885**Date Inspected:** 04-Dec-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei**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:**

The Caltrans (CT) Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

**OBG Sub-Assembly Bay 1:**

The QA Inspector randomly observed ZPMC welder Jiang Mao Fang ID Number 067942, utilizing the Flux Cored Arc Welding (FCAW) Process in 3G Position with ZPMC Weld Procedure Specification (WPS) WPS-B-T-2233-B-U2-F, to weld the butt splice between Deck Plate DP236-001 U-Rib Sections U-118 (short length) and U-142 (long length) at Weld Joint (WJ) DP236-001-151. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements.

**OBG Sub-Assembly Bay 2:**

The QA Inspector randomly observed 2 Magnetic Drill Operators drilling bolt holes in Skin Plate Stiffeners A709 Gr 345T2 p708 (N).

**OBG Sub-Assembly Bay 3:**

The QA Inspector randomly observed ZPMC welder Wu Zhi Bin ID 049804, utilizing the Submerged Arc Welding (SAW) Process in 1G Position with ZPMC WPS WPS-B-T-2221-B-L2c-S-2, to weld a butt splice Deck

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# WELDING INSPECTION REPORT

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Plate DP643-001 at WJ DP643-001-038 between piece marks DP643A/PL1174A and DP643A/PL1175A. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements. The attached photograph provides additional detail.

OBG Sub-Assembly Bay 4:

The QA Inspector performed a 100% final Visual Testing (VT) and 10% MT verification on the cover pass of the fillet welds on Deck Plates DP638A Yellow Tag 002170/Green Tag 002189 (DP638-001) Location 7AW WJ's 001 through 006 and Deck Plate DP664A Yellow Tag 002171/Green Tag 002190 (DP664-001) Location 7CE WJ's 001 through 006. There appeared to be no indications and the QA Inspector accepted all the above listed welds. The attached photograph provides additional detail.



## Summary of Conversations:

As noted in the above body of this report.

## 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, 15002199593, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Franco,Charlie	Quality Assurance Inspector
<b>Reviewed By:</b>	Wright,Mark	QA Reviewer

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