

**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-004939**Date Inspected:** 15-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 & Tower**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).

The QA Inspector was requested by CALTRANS Task Leader Robert Cuellar, to accompany CALTROP Inspectors Rodney Patterson and Hirarch Patel to the OBG Sub-Assembly Bays in order to familiarize them with the Final Visual (VT) and Magnetic Particle Testing Inspections for the Green Tagging Process. The QA Inspector and CALTRANS QA Inspector Joseph Lizardo, accompanied them to Bay 7 for Green Tagging of Floor Beams and to Bay 4 for Green Tagging of Deck Plates, Bottom Plates, Side Plates and Edge Plates.

**OBG Sub-Assembly Bay 4:**

The QA Inspector randomly observed ZPMC Non-Destructive Testing (NDT) Technician Xu Hai, utilizing the Magnetic Particle Testing (MT) Method to perform a final MT examination on the cover pass of the fillet welds on Deck Plate DP530A Yellow Tag 002347 (DP530-001) WJ's 001 through 012, 101, 102; Bottom Plate BP181A Yellow Tag 002349 (BP181-001) WJ's 007 through 018. There appeared to be no indications and ZPMC QC accepted all the welds on the above listed panels.

**ZPMC Plate Storage Yard:**

The QA Inspector verified material traceability of steel plate and marked up same for Check Samples to be cut,

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# WELDING INSPECTION REPORT

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prepared and sent to the testing lab in Shanghai.

**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
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<b>Reviewed By:</b>	Wright,Mark	QA Reviewer
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