

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-005742**Date Inspected:** 08-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

|                                    |                           |           |            |                                  |                     |           |            |
|------------------------------------|---------------------------|-----------|------------|----------------------------------|---------------------|-----------|------------|
| <b>CWI Name:</b>                   | Shen Fu You and Qiquo You |           |            | <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>Bridge No:</b>                  | 34-0006                   |           |            | <b>Delayed / Cancelled:</b>      | <b>Yes</b>          | <b>No</b> | <b>N/A</b> |
|                                    |                           |           |            | <b>Component:</b>                | OBG Assembly, Tower |           |            |

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Joe Alaniz was present during the times noted above for observations relative to the work being performed.

## Bay 14

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 25% of the area previously tested by ZPMC MT personnel. This QA Inspector generated a TL-6028 MT report on this date. The weld designation numbers is as follows:

585-001:

011, 013, 015, 017, 071, 082, 093 and 104

This QA Inspector performed Ultrasonic Testing (UT) on approximately 15% of CJP on the OBG and OBG Deck Plate welds previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QA Inspector observed no rejectable indications at the time of testing. The QA Inspector generated a TL-6027 UT report on this date. Welds UT verified were identified as listed below.

585-001:

011, 013, 015, 017, 071, 082, 093 and 104

## Bay 11

This QA Inspector observed the following work in progress:

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# WELDING INSPECTION REPORT

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ZPMC welding personnel Mrs. Yang Meizhen (042195) performing groove welding of weld joint ES01-FASA 3-2 A/E-2A cover passes. The personnel were observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process. ZPMC QC identified Mr. Li Le and was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-U3C-2.

Bay 13

ZPMC qualified welding personnel's identified as Mr. Hong Yongli (044801) and Li Zujun (05269) performed FCAW welding on weld joint identified as SEG008\*-011,012. ZPMC QC identified Mr. Shen Fu You and was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-U2.

ZPMC welding personnel Mrs. Wang Xiuhua (207288) performing groove welding of weld joint SEG008\*-006 cover passes. The personnel were observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process. ZPMC QC identified Mr. Shen Fu You and was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-L2CS-2

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### 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 Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

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| <b>Inspected By:</b> | Alaniz,Joe     | Quality Assurance Inspector |
| <b>Reviewed By:</b>  | Carreon,Albert | QA Reviewer                 |

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