

**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-009712**Date Inspected:** 07-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Bo**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:** Deck Panels**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Christopher D'souza was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

OBG Assembly Yard

Based on the UT (Ultrasonic Testing) information from Caltrans Transverse Indication Evaluation sheet for 2AW-2BW data pertaining to rejectable indication was marked on the splice by this QA Inspector. The data which was marked on the splice indicated the location, depth and indication rating for the discontinuity.

North Lay down

No Relevant work observed

Bay 9

This QA Inspector observed ZPMC welding personnel performing Gas Metal Arc Welding (GMAW) tack welds on closed rib Partial Joint Penetration (PJP) welds to deck plate designated as DP 3021-001. Welder is identified as 059440. ZPMC QC is identified as Chen Shi gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2342 – U5

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## WELDING INSPECTION REPORT

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This QA Inspector observed ZPMC welding personnel's performing Flux cored arc welding (FCAW) on Diaphragms to U-Rib designated as DP 3069-001 261~264. Welder is identified as 059443 and 059378. ZPMC QC is identified as Chen Shi gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133

This QA Inspector observed ZPMC welding personnel performing automated, in gantry, Gas Metal Arc Welding (GMAW) of closed rib Partial Joint Penetration (PJP) welds to deck plate designated as DP3058-001 and DP3014-001 on Gantry #2. In process GMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

This QA Inspector observed ZPMC welding personnel performing automated, in gantry, Submerged Arc Welding (SAW) of closed rib Partial Joint Penetration (PJP) welds to deck plate designated as DP3058-001 and DP3014-001 on Gantry #2. In process SAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

Welders are identified as 059416, 059421, 059418, 201840, 201780 and 059403. ZPMC QC is identified as Chen Shi gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2342 – U1

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

**Summary of Conversations:**

No relevant conversations.

**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 15000422372, who represents the Office of Structural Materials for your project.

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

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