

**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-010218**Date Inspected:** 16-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Ming**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:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC INSPECTION

OBG SEGMENT 1EAST

This Quality Assurance (QA) Inspector performed conventional UT (Ultrasonic Testing) after ABF Ultrasonic inspection for detection of planar transverse indication.

Ultrasonic Inspection (UT) performed on repair areas of corner weld between deck panel and edge panel of OBG segment 1E (cross beam side) utilizing scanning pattern A, B, C and D (Fig 6.7). During the inspection this Quality Assurance (QA) Inspector found six transverse indications that had not identified by ABF ultrasonic inspector. The weld designation as below

CA107-001, 004, 006

CA097-002, 004, 006

The inspection was performed in between Y location 8000 to 18000

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See Caltrans Ultrasonic Transverse Indication Evaluation sheet dated November 16th, 2009 for further information on inspections.

BAY # 10

This QA Inspector randomly observed the following work in progress.

## SOUTH TOWER LIFT # 4

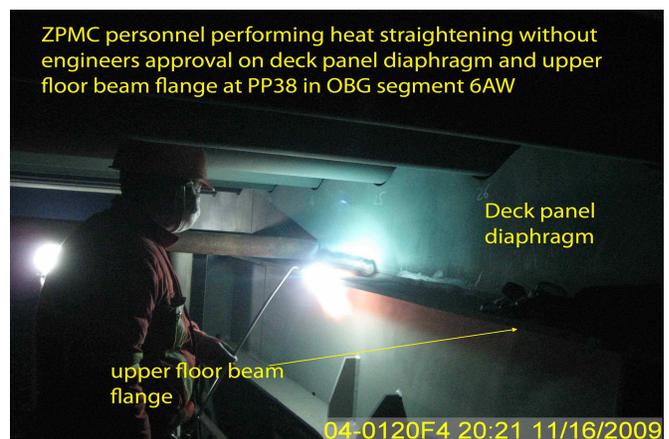
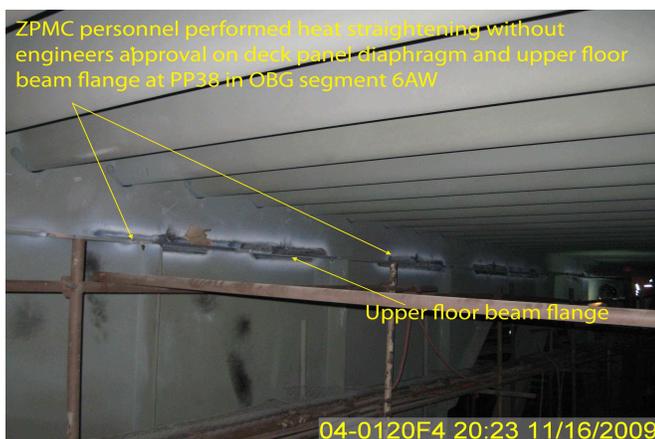
This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054069 performing Flux Core Arc Welding process for the weld joint SSTL-1B/L-3A located on PCMK south tower lift 4. ZPMC QC Mr. Li Peng Fei monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-C-U2-F.

## TRIAL ASSEMBLY YARD

### OBG SEGMENT 6AW

During random visual inspection this Caltrans Quality Assurance (QA) Inspector observed that contractor personnel was performing Heat Straightening on various location on deck panel diaphragm and the upper floor beam flange in OBG segment 6AW at panel point 38 without the approval of the Engineer. ZPMC QC or CWI was not present during the time of heat straightening. For additional information see attached photos. Incident report was send to the task leader and other supervisor.

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



### Summary of Conversations:

No relevant conversations.

### Comments

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## WELDING INSPECTION REPORT

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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 +(86) 150.0042.2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Utekar,Shrikant	Quality Assurance Inspector
<b>Reviewed By:</b>	Dawson,Paul	QA Reviewer

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