

**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-011393**Date Inspected:** 12-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	NA	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG.	

**Summary of Items Observed:**

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

Outside Yard – 8CW.

Notification No: 005037.

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

SSD21-PP67.5 – 049 to 054.

SSD10-PP68 – 047 to 052 &amp; 106 to 111.

SSD22-PP68.5 – 049 to 054.

SSD11-PP69 - 049 to 054, 106 to 109, 111, 097, 099, 101, 039, 041 &amp; 043.

SSD22-PP69.5 – 039 to 044, 049 to 054.

SSD12-PP70 – 040 to 045, 099 to 104, 048 to 053 &amp; 109 to 114.

SSD21-PP70.5 – 039 to 044 &amp; 049 to 054.

SSD9-PP71 – 098, 100, 102, 040, 042, 044, 107, 109, 111, 048, 050 &amp; 052.

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# WELDING INSPECTION REPORT

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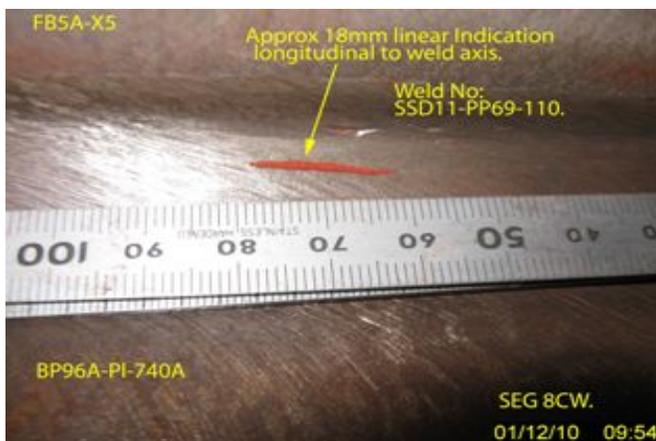
The following weld did not appear to comply with the applicable contract documents:

SSD-11-PP69 – 110.

One (1) longitudinal linear indication was discovered measuring approximately 18mm in length. The member is identified as the Floor Beam FB5A-X5, fillet weld to Bottom Panel BP96A-PL-740A. This indication is located outside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA informed ZPMC Quality Control (QC) identified as Mr. Zhong Wei and American Bridge Fluor (ABF) QA identified as Mr. Peter Shaw of this issue and that an incident report would be generated.

For further information, please see the attached photos.

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

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<b>Inspected By:</b>	Wadkar,Sailesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Hall,Steven	QA Reviewer

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