

**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-015056**Date Inspected:** 16-Jun-2010**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:****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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Amit Juvekar 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:

Subassembly, Bay 09, Deck Panel 13AE-DP3075-001.

QA inspector performed conventional Ultrasonic Testing (UT) Inspection of approximately 10% for Lack of Penetration (LOP) on deck panel (U-rib to deck plate) Partial Penetration weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as Deck Panel. The weld designations reviewed are as follows

DP3075-001-001 to 010.

Subassembly, Bay 09, 13CE, Continuity Stiffener inside U-Rib.

FCAW welding of weld complete penetration joint DP3103-001-257, 258, 259, 260; located on subassembly, Bay 09, 13CE. Welder is identified as 059403; ZPMC Quality Control Inspector (QC) is identified as Chen Shigang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS- B-T-2233-TC-U4B-F.

Subassembly, Bay 09, 13CE, Continuity Stiffener inside U-Rib.

FCAW welding of Fillet weld Partial Penetration joint DP3103-001-161, 160, 128, 129; located on

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## WELDING INSPECTION REPORT

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subassembly, Bay 09, 13CE. Welder is identified as 059403; ZPMC Quality Control Inspector (QC) is identified as Chen Shigang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2133.

Subassembly, Bay 09, 13CE, Continuity Stiffener inside U-Rib.

During the Quality Assurance (QA) random in-process visual inspection, this QA inspector observed ZPMC Personnel performing Carbon-arc gouging (Back gouging) at 33mm Complete penetration joint (CJP) of continuity plates on U-rib on Deck Panel identified as DP3103-001-105, 104, 113, 112.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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, 1500.042.2372, who represents the Office of Structural Materials for your project.

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

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