

**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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017786**Date Inspected:** 14-Oct-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**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:** Trial Assembly, Tower Bay**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:

**CWR Verifications**

Bay 3 (UT – Excessive depth)

B-CWR 1994 Rev 0

This QA Inspector was notified via email for verification of B – CWR1994 R0 at 1020 hours the following was observed:

- The component for verification was identified as LD 3048-001
- Weld repair was to be performed on location where rejectable indication was observed during Ultrasonic Testing (UT)
- Repair required excavation of more than 65% of weld metal
- ZPMC QC Zhu Jun was present on site to direct and record all repair work.
- WPS to be used for repair was WPS-345-FCAW-1G(1F)-FCM-Repair-1

Bay 2 (UT – Excessive length)

B-CWR 2043 Rev 0

This QA Inspector was notified via email for verification of B – CWR2043 R0 at 1500 hours the following was

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# WELDING INSPECTION REPORT

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observed:

- The component for verification was identified as SA 3410-001-001
- Weld repair was to be performed on location where rejectable indication was observed during Ultrasonic Testing (UT)
- More than 65 % of weld length was rejected by ultrasonic testing
- ZPMC QC Zhu Jun was present on site to direct and record all repair work.
- WPS to be used for repair was WPS-345-FCAW-2G(2F)-FCM-Repair-1

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 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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