

**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-003191**Date Inspected:** 24-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China

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

**Summary of Items Observed:****Bay 7 Cracked weld**

This QA inspector observed ZPMC in bay 7 performing repairs on component number FB003-038-005 due to cracked weld under Critical Weld Repair (CWR) number B-CWR-118. Excavation had been performed with a depth of 6 mm and length of 350 mm ZPMC performed MT for this location to ensure base metal soundness and complete removal of the crack. This Caltrans QA inspector witnessed the procedure and found it to be within compliance. ZPMC's CWI Huang Wen-Pang was present during the welding repair operations in this bay monitoring parameters and procedure progression.

**Bay 3 Cracked tack weld**

This QA inspector observed ZPMC in bay 3 performing repairs on 7 cracked tack welds for component number EP034-001-074 (window) ZPMC had notified Caltrans QA inspector pertaining to the cracks for observations of excavation and MT prior to resuming welding. This QA inspector observed that ZPMC had excavated the tack areas and MT which appeared to be in compliance with the agreed process for cracked tack weld procedures. ZPMC's CWI Wu Ming Kai was present during the welding repair operations in this bay monitoring parameters and procedure progression.

**UT**

This QA inspector received Notification of Witness Inspection from ZPMC for Ultrasonic Testing (UT) of FB003-056-104 and 105, FB003-049-104 and 105, FB003-031-104 and 105, FB003-030-104 and 105, web plates were also verified by this QA inspector as follows; FB034-001 welds 079, 078, 081, 080, 101, 108, 117, and 122. This QA inspector performed the 10% verification on the noted weldments and determined by testing that the weldment appeared to be within compliance. Also noted for UT verification this date was in the OBG assembly for segment number SEG 3AE BP6A to BP5A and BP6A to BP4A. This QA inspector proceeded to perform 10%

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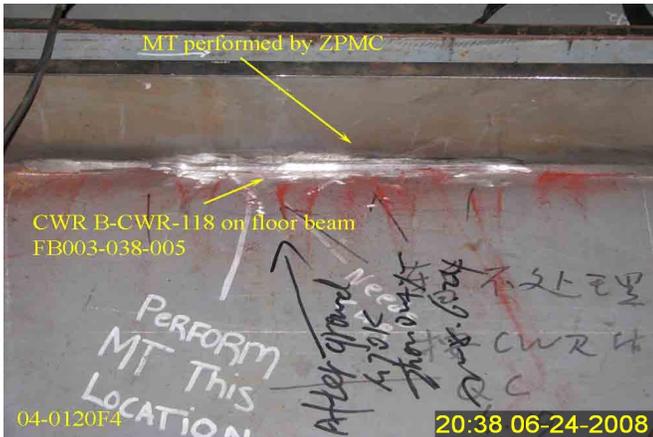
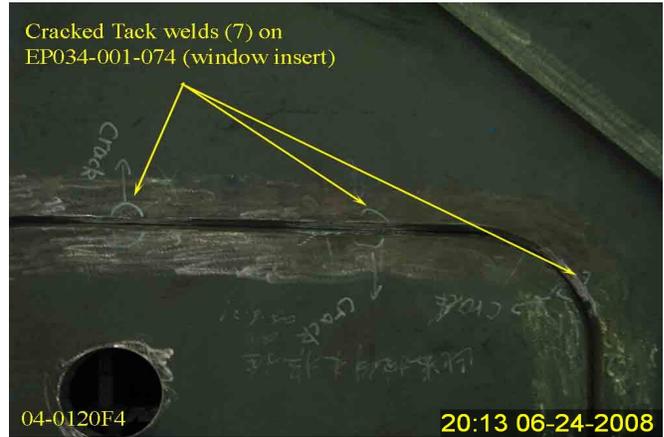
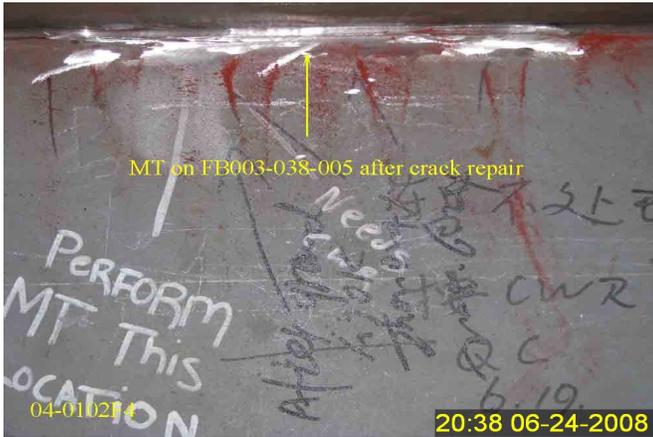
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verification on the noted weldments and determined by testing that the weldment appeared to be within compliance. A TL-6028 will be generated for these locations.



## Summary of Conversations:

As Noted Above.

## 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 Ady Velasco , China-1-381-694-2685, who represents the Office of Structural Materials for your project.

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**Inspected By:** Riley, Ken

Quality Assurance Inspector

**Reviewed By:** Carreon, Albert

QA Reviewer