

**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-003231**Date Inspected:** 17-Jul-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**CWI Name:** Chen Chih-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 side, bottom and deck panels**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall 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:

OBG new assembly bay 2

QA performed 10% verification Ultrasonic Testing (UT) on the following weld joints on OBG section 3BW: SSD13A-PP023-127, SSD13-PP023-131, SSD11A-PP021-003, 009 and 088, SSD11-PP021-007, 126, 130 and 105.

All of the welds that were scanned appeared to comply with AWS D1.5 2002 and the contract documents. QA noted that ZPMC QC UT technicians have rejected weld joint SSD11A-PP021-013.

QA observed ZPMC qualified welding personnel SAW SEG-018-006 DP-032-001 to DP-030-001 following the guide lines of WPS-B-T-2221-B-L2c-S-2. QC monitored the welding process continuously throughout the evening. The welder ID and welding parameters as measured with Quality Controls calibrated instruments appeared to be in conformance with the posted WPS's and were as follows:

Volts: 31 Amps: 575 Travel speed: 500mm/min

Welder ID: 048296

QA observed ZPMC qualified welding personnel FCAW SEG-014B-034 @ PP-021 section 3AE following the guide lines of WPS-B-T-2233-TC-U4b-F. QC monitored the welding process continuously throughout the evening.

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The welder ID and welding parameters as measured with Quality Controls calibrated instruments appeared to be in conformance with the posted WPS's and were as follows:

Volts: 25.5 Amps: 205 Travel speed: 118mm/min  
Welder ID: 058551

Other general observations include ZPMC personnel fitting and welding OBG east fixture, OBG temporary support columns, grinding and weld bevel prep on various OBG components.



### Summary of Conversations:

Only general conversations were 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 Patrick Lowry (858)-344-2712, who represents the Office of Structural Materials for your project.

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