

**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-003647**Date Inspected:** 11-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** C.M. Chen**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**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

This Caltrans QA Inspector's is currently in the process of reviewing CT NDT of Side Panel and Bottom Panel located at Segment 5AE which include the following.

SP423A 5AE  
SP304A 5AE  
SP331A 5AE  
SP358A 5AE  
BP110A 5AE  
BP56A 5AE  
BP164A 5AE  
SP601A 5AE  
SP561A 5AE  
SP521A 5AE  
SP419A 5AE

Bay 1 Sub Assembly Shop - QA Observations:

1) OBG-Deck Panel Welding-

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# WELDING INSPECTION REPORT

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a) Gantry 1- This gantry is idle during this shift.

b) Gantry 2- Caltrans QA Inspector observed ZPMC in the process of welding root pass (GMAW) OBG Deck Panels DP471-001. Caltrans QA Inspector observed ZPMC performing MT inspection on DP282-001. ZPMC MT inspector revealed 38 crack like liner indications on this 3 rib deck panel. A total of 264 tack welds are incorporated in this deck panel. ZPMC recorded a total of 28 crack like liner indications on deck panel DP471-001 with a total of 394 tacks incorporated on this deck panel.

2) ZPMC Personnel- Caltrans QA observed ZPMC has approximately 30-45 workers performing various functions relative to the fabrication of the OBG Deck Panels. These functions include; closed rib press forming, drilling holes in connection areas, PJP bevel preparation, closed rib splice welding, closed rib diaphragm fit-up and FCAW welding of splices, closed rib to deck plate fit-up and tack welding and the PJP welding of closed ribs to deck plates.

### Summary of Conversations:

No relevant conversations spoken on this date.

### 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 13816942685, who represents the Office of Structural Materials for your project.

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

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