

**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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004077**Date Inspected:** 27-Sep-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>	N/A	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG/ Tower	

**Summary of Items Observed:**

Tower shop bay 2

This QA inspector received notification from ZPMC for non destructive testing of stiffener to skin plate for the East skin E plate. This QA Inspector performed UT verification for weld numbers ESDF1-SA227 A/H-66, 67 A/B, ESD1-SA216 F/K-7 A/B after ZPMC had performed their testing and accepted these areas. At the time of the QA review the welds appeared to within compliance of the contract documents. Also noted is the conversation this QA inspector had with Ken Zhang in regards to the marking of the UT areas where ZPMC had performed their UT and the installation of this skin plate and the delay for Caltrans to do their QA review. Swing Shift received verbal notification from ABF representative that ZPMC would be installing skin plate E on the east tower section lift 1 tomorrow 9-28-08. Caltrans QA Inspectors received the NDT notification at 1330 for ZPMC to perform UT testing on the stiffener to skin plate weldments. Swing shift arrived in the shop to perform the QA verification and observed that none of the weldments had been marked by ZPMC for UT completion (either accept or reject) after lunch Caltrans QA met with Ken Zhang of ZPMC and was informed that ZPMC had completed the UT except for 4 welds but was not going to mark these locations until all welds were completed. Caltrans QA explained to ZPMC Ken Zhang that with ZPMC not marking each location after it was completed they were delaying Caltrans QA review (at the time of conversation it was a 2 hr delay due to no markings from ZPMC) from performing the QA verification. ZPMC Mr. Zhang understood this situation and said he would inform the UT technicians to mark the weldment as they complete them. Mr. Zhang was also informed that as ZPMC wants to install this component tomorrow morning and due to ZPMC finishing the UT late in the shift that Caltrans has 24 hrs to have access to these welds as outlined on their NDT request sheet note 4. He then replied that may not happen. ZPMC was also working on the skin plate E which with welding grinding and heating could prolong Caltrans availability to have access to the weldments for safety. See digital photo below for amount of personnel at this location.

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

Deck Panel repair area 2 (yard)

Caltrans QA Inspector received verbal notification from ZPMC QC personnel that out in deck repair panel area 2 (yard) ZPMC needed the 300mm areas chosen and marked by Caltrans for their Radiographic Testing (RT). This QA inspector marked seven (7) deck panel plates as follows; DP148-001-189, DP499-001-117, DP283-001-117, DP337-001-153, DP256-001-159, DP121-001-153 and DP364-001-189. These areas are now ready for ZPMC to grind and perform their RT.



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

---

<b>Inspected By:</b>	Riley, Ken	Quality Assurance Inspector
----------------------	------------	-----------------------------

---

<b>Reviewed By:</b>	Carreon, Albert	QA Reviewer
---------------------	-----------------	-------------