

**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-004138**Date Inspected:** 18-Oct-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:** various see below**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 assy bay 2

QA received Non-Destructive Testing (NDT) notification document no. 001231 and 001232 from ZPMC QC and performed 10% verification Ultrasonic Testing (UT) on the following weld joints:

Notification no. 001231

QA noted that the welds identified on this notification as SEG-13A-009, 010, 015, 016, 024 and 026 were all Ultrasonic Tested (UT,ed) by ZPMC on 7/28/08 and rejected. According to the markings on the material, at least some of the repairs have been re-UT'ed several different times and rejected by ZPMC over the last few months however it is not clear as to whether or not all the repairs have been accepted. It appeared that no UT had been performed on these welds today as stated on the NDT notification. QA did not perform 10% verification UT on these welds.

Notification no. 001232

SEG-021-003 and 004 appeared to conform to AWS D1.5 2002 and the contract documents.

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## WELDING INSPECTION REPORT

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SEG-019B-041, 031 and 005 appeared to conform to AWS D1.5 2002 and the contract documents. QA noted that welds 001, 011 and 040 have not yet been welded and welds 002, 003, 004, 006, 032, 042, 022, 023, 043, 044 and 045 appear to have been rejected by ZPMC.

SEG-019C-001, 016, 040, 034 and 044 appeared to conform to AWS D1.5 2002 and the contract documents. QA noted that welds 006, 035 and 045 have not been fit up yet and welds 002, 017, 041, 003, 025, 042, 004, 026, 043 and 005 appear to have been rejected by ZPMC.

QA noted that ZPMC has removed an external diaphragm plate from deck panel identified as DP-063-001 after this diaphragm had been welded completely. It is not clear whether ZPMC had engineering approval to do so. QA was unable to follow up on this issue tonight.

### Summary of Conversations:

Only general conversation was 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 Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

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

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