

**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-004262**Date Inspected:** 21-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shangxing Island, Shanghai

<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	

**Bridge No:** 34-0006**Component:** Deck panel**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) representative was present for observations relative to fabrication performed by Zhenhua Port Machinery Company (ZPMC) for the fabrication of Orthotropic Box Girder (OBG) and SAS Tower at Changxing Island, in Shanghai, China.. While on site the QA Inspector noted the following:

Deck Panel DP487-001

The QA Inspector performed Ultrasonic Testing (UT) using the gate to gate technique on the partial joint penetration welds made on the U-ribs (three ribs, two welds per rib six welds total) on the deck panel identified as DP487-001. The ultrasonic testing was being performed on the tack weld areas only a total of 168 tack welds were made on the six welds. The QA Inspector performed the testing on the weld number one through six. The QA Inspector observed several linear indications on the welds at random locations and the indications were marked on the steel for the phased array ultrasonic testing investigation that will be performed at a later time. Please see the QA Inspector's log generated on this date for additional information regarding the amount of indications observed and locations, the QA Inspector's log is available for review per request. The QA Inspector notified the Task Leader Robert Cuellar of indications observed.

**Summary of Conversations:**

None of major significance.

**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

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## WELDING INSPECTION REPORT

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remedial efforts please contact Peter Dautermann, (1500) 219-9593, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Medina,Ricardo	Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer
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