

**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-004271**Date Inspected:** 19-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

<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	

**Summary of Items Observed:**

## Confined Space / Hot Work

ZPMC is currently working on tower shaft ESD1-Lift 1 (east tower shaft) which has been determined as a confined space area. ZPMC does not have the required Confined space permit posted at the entry of the confined space. Caltrans QA Inspector observed 4 ZPMC employee badges posted as working inside the area of the 4, two employees are welders performing welding operations which also require a Hot Work permit which also is not posted. With continued work being performed and no Confined Space permit this limits Caltrans QA Inspectors from monitoring the in progress work being performed inside the tower section. Digital Photo below depicts the entry into the confined space area.

## OBG Bay 4 Ultrasonic Verification (UT)

Caltrans QA Inspector performed 10% UT verification after ZPMC had accepted the weldments with UT testing for the "T" stiffener splices on Bottom Plate BP120-001-001~006 and 043~048. At the time of the QA review the weldments appeared to be within compliance. The QA inspector signed the documentation for this purpose only on this date.

## OBG Bay 7 Ultrasonic (UT) Verification

Caltrans QA Inspector performed 10% UT verification after ZPMC had performed and accepted their UT testing for floor beam weld numbers FB011-014-045, FB011-016-045, FB016-024-045, FB015-022-045 and FB015-018-045; at the time of the QA review the weldments appeared to be within compliance.

## Tower Shop Bay 2 Ultrasonic (UT) Verification

Caltrans QA Inspectors performed random 10% QA verification for tower components after ZPMC had completed and accepted the CJP weldments. Weld numbers WSD1-SA294 A/G-1a/b, WSD1-SA279 A/F-2a/b, WSD1-SA225 A/H-60 a/b and WSD1-SA77A/E-43 a/b were completed for the QA verification. At the time of the

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QA review the weldments appeared to be within compliance according to the contract documents.

### OBG Bay 1 Ultrasonic (UT) Verification

Caltrans QA Inspector performed 10% UT verification after ZPMC had accepted the weldments on the closed rib CJP splice number DP391-001-190~194; at the time of review the weldments appeared to be within compliance.



### 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 Josh Ishibashi, 1-376-471-0411, who represents the Office of Structural Materials for your project.

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

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