

**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-004342**Date Inspected:** 05-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Tai**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:** Tower/OBG**Summary of Items Observed:**

On this date, Caltrans Office of Structure Materials (OSM) Quality Assurance Inspector (QA) Raymond Lara was present at jobsite in Zhenhua Port Machinery Company facility on Changxing island, China for the purpose of observing and monitoring the fabrication of the SAS Superstructure.

**Heavy Shop 1**

The Quality Assurance Inspector observed ZPMC utilizing a milling machine in the beveling process on longitudinal stiffener P483.

The Quality Assurance Inspector observed ZPMC thermal cutting longitudinal stiffener P312B.

The Quality Assurance Inspector observed ZPMC repairing visual indications by grinding on south tower skin plate assembly C.

**Heavy Shop 2**

The Quality Assurance Inspector observed ZPMC personnel in process of performing fit operations on longitudinal stiffener plates to skin plate E east tower assembly.

The Quality Assurance Inspector observed ZPMC utilizing a milling machine in the beveling process on longitudinal stiffener P1464.

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The Quality Assurance Inspector observed ZPMC repairing visual indications by grinding on east tower skin plate assembly C.

Bay 1

The Quality Assurance Inspector observed ZPMC Caltrans approved welder 059416 and 059378, utilizing the gas metal arc welding process on a partial joint penetration, joining u-ribs to DP256-001. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-2342-U.

The Quality Assurance Inspector observed ZPMC in process of performing tack weld operations on DP605-001 and fit up operations on u-ribs to DP497-001.

**Summary of Conversations:**

No relevant conversations 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 Joshua Ishibashi, (707) 649-5453, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Lara, Raymond	Quality Assurance Inspector
<b>Reviewed By:</b>	Wright, Mark	QA Reviewer

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