

**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-004427**Date Inspected:** 17-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Wu Ming Kai	<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:**

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

**OBG Sub-Assembly Bay 4:**

The QA Inspector randomly observed ZPMC NDT Technicians Xu Hai and Wang Wei, utilizing the Magnetic Particle Testing (MT) Method to perform a final MT Inspection on the cover pass of Side Plates SP437-001, SP438-001, SP439-001 Weld Joint (WJ) Numbers 001 through 010; SP438-001 and SP453-001 WJ's 011 through 020. There appeared to be no indications and ZPMC QC accepted all welds.

The QA Inspector performed a 10% MT verification of the cover pass of the fillet welds on Side Plates SP437-001, SP438-001, SP439-001 Weld Joint (WJ) Numbers 001 through 010; SP438-001 and SP453-001 WJ's 011 through 020. There appeared to be no indications and the QA Inspector accepted the above listed welds. The QA Inspector signed off on the ZPMC Green Tag Documentation after ZPMC Representative Wu Ming Kai and ABF Representative Hu Gui Hua signed. Green Tag Numbers 001105, 001103, 001104, and 001107 respectively were attached. The attached photograph provides additional detail.

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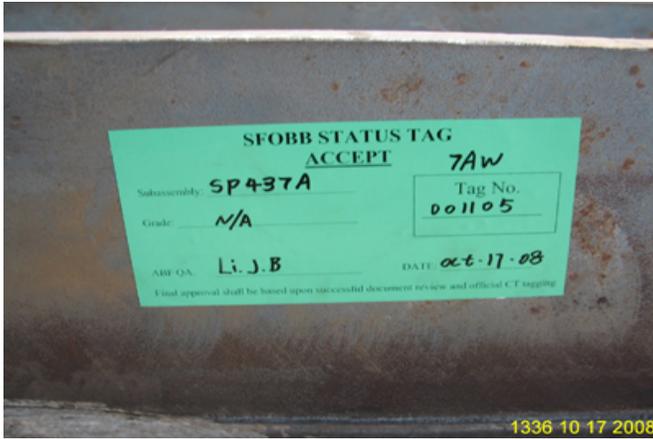
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# WELDING INSPECTION REPORT

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## Summary of Conversations:

There were no relevant conversations.

## 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 13764716411, who represents the Office of Structural Materials for your project.

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

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