

**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-004437**Date Inspected:** 22-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>	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 & Tower	

**Summary of Items Observed:**

The Caltrans (CT) 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 performed a 10% final MT verification on the cover pass of all the welds on 43M (W) Tower Diaphragm. There appeared to be no indications and the QA Inspector accepted the welds on 43M (W) Tower Diaphragm. Green Tag Documentation signed and dated by ZPMC Representative Li Xie Yang, ABF Representative Zhang Hui Long and CT QA Inspector (B75) Green Tag 000884.

**OBG Sub-Assembly Bay 7:**

The QA Inspector randomly observed ZPMC Non-Destructive Testing (NDT) Technician Bo Tin Rui, utilizing the Magnetic Particle Testing (MT) Method to perform a final MT Inspection on the cover pass of Floor Beam Sub-Assembly FB016-019 Weld Joint (WJ) Numbers 001, 003 - 009, 011, 012, 015 - 020, 024, 025, 033, 034, 041, 042, 046. There appeared to be no indications and ZPMC QC accepted the above listed welds on FB016-019.

The QA Inspector randomly observed ZPMC NDT Technician Bo Tin Rui, utilizing the MT Method to perform a final MT Inspection on the cover pass on Floor Beam Sub-Assembly FB012-007 WJ's 001, 003 - 009, 011, 012, 015 - 020, 024, 025, 031, 032, 039, 040, 042, 046. ZPMC QC and the QA Inspector observed transverse cracks at

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Y=227 mm and 330 mm in WJ 001 on the fillet weld attaching Flange X7G to FB012-001. Y=0 location is at the junction of flange X7G and X7M-3. ZPMC QC rejected FB012-001.

## 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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