

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-004971**Date Inspected:** 10-Dec-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island, Shanghai**CWI Name:** Wen Jun**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:** OBG and tower components**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:

OBG bottom plate.

1. The QA Inspector performed a random Visual (VT) and Magnetic Particle Testing (MT) verifications on the completed welds made between assembly component members on the inspection part numbers identified as follows: BP071A-001, BP097A-001 and BP151A-001 (please note that multiple welds were verified on these inspection parts). Please refer to the ZPMC Non Destructive Examination (NDE) notification of witness inspection document number 001611 item numbers 5 to 7 for weld numbers and additional information. Please note that the VT and MT verifications were performed on these welds as a request for the tagging in process of the assemblies. The QA Inspector performed the verifications on these welds after ZPMC Quality Control Inspection personnel had completed the inspections and reported the welds to be acceptable and ready for verification. The QA Inspector did not observe any welding related discontinuities and did not observe any relevant indications during verifications. The QA Inspector notified QC Inspection personnel Wen Jun and Task Leader Albert Carreon of the observations during verifications. Please see the QA Inspector's Magnetic Particle Testing (TL 6028) report generated on this date for additional information.

Tower lift 2 skin D and C.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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2. The QA Inspector performed a random VT and MT verifications on the completed welds made between assembly component members on the inspection part numbers identified as follows: SSD1-SA208 D/D, SSD1-SA208 C/D, SSD1-SA171 C/D, and SSD1-SA171 A/D (please note that multiple welds were verified on these inspection parts). Please refer to the ZPMC Non Destructive Examination (NDE) notification of witness inspection document number 001603 item numbers 1 to 4 for weld numbers and additional information. Please note that the VT and MT verifications were performed on these welds as a request for the tagging in process of the assemblies. The QA Inspector performed the verifications on these welds after ZPMC Quality Control Inspection personnel had completed the inspections and reported the welds to be acceptable and ready for verification. The QA Inspector did not observe any welding related discontinuities and did not observe any relevant indications during verifications. The QA Inspector notified QC Inspection personnel and Task Leader Albert Carreon of the observations during verifications. Please see the QA Inspector's Magnetic Particle Testing (TL 6028) report generated on this date for additional information.

3. The QA Inspector was requested to perform Ultrasonic Testing verification on the completed welds on the inspection parts listed on the ZPMC Non Destructive Examination (NDE) notification of witness inspection document number 001547 item numbers 7 to 14. At the time the QA Inspector was ready to perform the testing the ZPMC QC Inspection personnel notified QA Inspector not to perform the testing on these welds and requested to perform verifications at another location in the facility for OBG components. The QA Inspector notified Task Leader Albert Carreon of the request and changed orders mentioned above.

### **Summary of Conversations:**

As noted in the body of the report 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 Peter Dautermann, (1500) 129-9593, 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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