

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-005710**Date Inspected:** 05-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**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:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Erik Prue was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA Inspector observed and/or found the following:

OBG Bay 2: QA Inspector performed ultrasonic (UT) verification testing of OBG segment complete joint penetration (CJP) butt joints on segment 1AE. Welds tested were Seg 004A-005 and Seg 004A-006. The Ultrasonic Testing (UT) was performed to verify that 10% of the weld meets the requirements of the contract documents and AWS D1.5-2002 after ZPMC QC UT acceptable inspection. The welds and base metal were scanned utilizing a Krautkramer Branson USN 58L #01WHB1. QA Inspector performed a base metal lamination check using a 25mm diameter 2.25 MHz transducer and a shear wave scan using a 20mm x 15mm 2.25 MHz transducer on a 70 degree angle wedge from face A. For details please see the ultrasonic testing report TL-6027 dated 05 March, 2009. QA Inspector found the welds inspected to be in compliance with AWS D1.5 2002 Table 6.3 and the contract documents.

Segment 4AW: QA Inspector observed ZPMC personnel prepping the edge of bottom plates on segment 4AW using the oxy-acetylene cutting process. ZPMC QC Inspector informed QA Inspector that the joint edge prep was cut to AWS D1.5 (02) single V groove butt joint requirements. QA Inspector discussed with QC Inspector that the bevel angle of the edge prep needed to be ground at various locations due to remaining slag from cutting process and gouges in bevel edge.

Unless otherwise noted, all work observed on this date appears to be in general compliance with the applicable

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

contract documents.

## Summary of Conversations:

No significant conversations this day.



## 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 Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

---

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

---