

**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-005774**Date Inspected:** 27-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**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 Components	

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

**Bay 2**

This QA inspector proceeded to Bay 2 in response to a ZPMC NDT Inspection Notification to perform final MT inspection on member SEG2E, welds 98~106, 179~190, 389~400, 430~441; and member SEG2C, welds 45, 48, 51, 54, 57, 60, 132, 135, 138, 141, 142, 144, 145, 147, 148, 151. Prior to performing MT, this QA Inspector began performing VT of 100% of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as SEG2E. The weld designations reviewed are as follows: 106, 187, 397, 438. This inspector observed rough weld metal to base metal transition contributing to improper weld profile, arc strikes on weld metal and base metal, and incomplete fusion of weld metal to base metal on each of the four welds reviewed. This QA inspector declined to accept the VT observed. This QA inspector also did not observe MT acceptance by ZPMC Quality Control personnel.

**Bay 12**

This QA inspector proceeded to Bay 12 in response to a ZPMC NDT Inspection Notification to perform MT inspection as follows:

This QA Inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The member is identified as DP610. The weld designations reviewed are as follows: 1~10. QA Inspector also notated QA MT review on the

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## WELDING INSPECTION REPORT

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member.

This QA Inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The member is identified as DP615. The weld designations reviewed are as follows: 1~10. QA Inspector also notated QA MT review on the member.

This QA Inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The member is identified as DP560. The weld designations reviewed are as follows: 1~10. QA Inspector also notated QA MT review on the member.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

This inspector informed ZPMC QA Lai Tao (ZPMC QA) and ABF Representative Zeng Jian Ping (ABF) of the above noted observances by this QA inspector. Both ZPMC QA and ABF looked at the welds. ZPMC QA informed this QA inspector that ZPMC QA would have a ZPMC QC inspector perform VT on all the welds before submitting another ZPMC NDT Inspection Notification.

### 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, 134-8257-0045, who represents the Office of Structural Materials for your project.

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

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