

**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-006426**Date Inspected:** 20-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**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 segments and crossbeam	

**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall 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 observed and/or found the following:

## OBG sub assembly bay 1

This QA observed contractors personnel performing various tasks relative to the fabrication of cross beam identified as CB7 and OBG counter weight boxes including the following: fitting and welding sub assemblies, grinding, quality control inspection and weld monitoring.

## OBG sub assembly bay 2

This QA observed contractors personnel performing various tasks relative to the fabrication of floor beam subassemblies and OBG segments identified as 1AAW, 1AAE and 1AE, including the following: fitting and welding, grinding, quality control inspection and weld monitoring.

## OBG sub assembly bay 3

This QA observed contractors personnel performing various tasks relative to the fabrication of cross beam identified as CB5 and floor beam subassemblies including the following: fitting and welding, grinding, quality

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control inspection and weld monitoring. This QA noted that Caltrans QA inspectors were present and performing 10% verification Ultrasonic Testing (UT) of CJP welds on a number of floor beam web plates.

### OBG sub assembly bay 5

This QA observed contractors personnel performing various tasks relative to the fabrication of cross beam identified as CB4, including the following: fitting and welding, grinding, quality control inspection and weld monitoring. No other Caltrans work was observed in this bay.

### OBG sub assembly bay 6

This QA observed contractors personnel performing various tasks relative to the fabrication of sub assemblies for cross beams, OBG panels, Tower diaphragms and tower cross bracing including the following: fitting and welding, grinding, hole drilling and quality control inspection and weld monitoring.

### OBG sub assembly bay 7

This QA observed contractors personnel performing various tasks relative to the fabrication of OBG side and bottom panels including the following: fitting and welding, grinding, quality control inspection and weld monitoring. No other Caltrans work was observed in this bay.

### OBG sub assembly bay 9

This QA observed contractors personnel performing various tasks relative to the fabrication of the OBG deck panels, including the following: fitting u-ribs to deck panels, gantry welding, grinding, U-rib forming, quality control inspection and weld monitoring. No other Caltrans work was observed in this bay.

### OBG assembly bay 13

This QA observed contractors personnel performing various tasks relative to the fabrication of OBG deck super panels including the following: fitting and welding, grinding, quality control inspection and weld monitoring. No other Caltrans work was observed in this bay.

### OBG assembly bay 14

This QA observed contractors personnel performing various tasks relative to the fabrication of OBG segments for lifts 6 and 7 including the following: fitting and welding, grinding, quality control inspection and weld monitoring.

### OBG assembly bay 19

This QA observed contractors personnel performing various tasks relative to the fabrication of the bike path segments, including the following: welding, grinding and quality control inspection and weld monitoring. No other Caltrans work was observed in this bay.

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## OBG superstructure assembly

This QA observed contractors personnel performing various tasks relative to the fabrication of the OBG superstructure assembly, including the following: welding, bolting assemblies, hole drilling, grinding and quality control inspection and weld monitoring.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### 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.

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

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