

**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-007273**Date Inspected:** 11-Jun-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**CWI Name:** Shi Lin**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 crossbeams and truss assembly**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 cross beam CB1 (in superstructure truss assembly)

This QA observed that the contractors personnel are installing the frame of the catwalk. No other significant work was observed during the time QA was present.

OBG cross beam CB2 (in superstructure truss assembly)

This QA observed that no significant work was being performed on this crossbeam during the time this QA was present.

OBG cross beam CB3

This QA observed that this crossbeam is still in the paint bay. No significant work was observed on this crossbeam during the time QA was present.

OBG cross beam CB4

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This QA observed that no significant work was being performed on this crossbeam during the time this QA was present.

### OBG cross beam CB5

This QA observed that ZPMC has not yet performed Magnetic particle Testing (MT) on weld CB202C-001-003. This weld was MT'ed by ZPMC on 06-08-09. This QA rejected the MT by the contractor due to the fact that the contractor did not clean the weld prior to testing. This QA issued an incident report for this issue. This QA spoke with ZPMC QA today identified as Mr. Shen Xuejun concerning the status of this weld. Mr. Shen instructed the contractors QC inspector identified as Mr. Guo Yuan Ting to have the workers clean the weld properly. He then told this QA that he would have ZPMC Non Destructive Testing (NDT) technicians MT the weld again and resubmit an NDT notification to Caltrans QA after ZPMC testing is complete.

This QA received ZPMC Non Destructive Testing (NDT) notification No. 003372 for the above mentioned weld (CB202C-001-003) and performed Magnetic particle Testing (MT) of approximately 15% of a weld previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated an MT report for this date.

### OBG cross beam CB6

This QA observed that no significant work was being performed on this crossbeam during the time this QA was present.

### OBG cross beam CB7

This QA observed that no significant work was being performed on this crossbeam during the time this QA was present.

### OBG cross beam CB8

This QA observed ZPMC personnel fitting floorbeam diaphragm sections for the bottom panel of this crossbeam. No other significant work was observed during the time this QA was present.

### OBG bay 5 bike path cantilever brackets

This QA observed ZPMC personnel flame beveling various components for the cantilever brackets. No other significant work was observed during the time QA was present.

### OBG cross beam CB10

This QA observed that no significant work was being performed on this crossbeam during the time this QA was present.

### OBG segment 4AE and 4BE

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This QA received verbal notification from ZPMC QA identified as Mr. Wang Lu for QA verification concerning the clean out of the floorbeam diagonal braces prior to ZPMC personnel installing the access hole cover plates on each of the braces inside the above mentioned segments. This QA concurred that the internal areas of the braces appeared to be sufficiently cleared of debris.

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

**Summary of Conversations:**

As mentioned 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 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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