

**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-007912**Date Inspected:** 16-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Zhi Cheng**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:** Segment 1AAE and CB5**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 segment 1AAE**

This QA observed ZPMC personnel removing parts identified as cable anchorage blocks from this segment. According to American Bridge Fluor (ABF) representative Mr. Peter Shaw, ZPMC is removing these blocks because the specifications require them to mill to bear. ZPMC QC along with ABF QA inspectors determined that fit up of these parts did not meet the mill to bear acceptance criteria. Mr. Shaw also informed this QA that the grout around the cable anchorage holes in this segment appears to have shrunk during the curing process and that ZPMC would have to add some more grout in order to bring it up flush with the top of the diaphragms around the cable anchorage holes.

**OBG Crossbeam CB5**

ZPMC QA identified as Mr. Shen Xuejun informed this QA that ABF inspectors have performed final Visual Testing (VT) of the welds in this crossbeam after ZPMC and Caltrans QA performed the required Non Destructive Testing (NDT). ABF inspectors have rejected some of the welds and are requiring ZPMC to do the necessary weld repairs. This QA informed Mr. Shen that both ZPMC and Caltrans QA would have to perform additional NDT on the repaired areas after the repairs have been completed. Mr. Shen concurred and informed this QA that ZPMC

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# WELDING INSPECTION REPORT

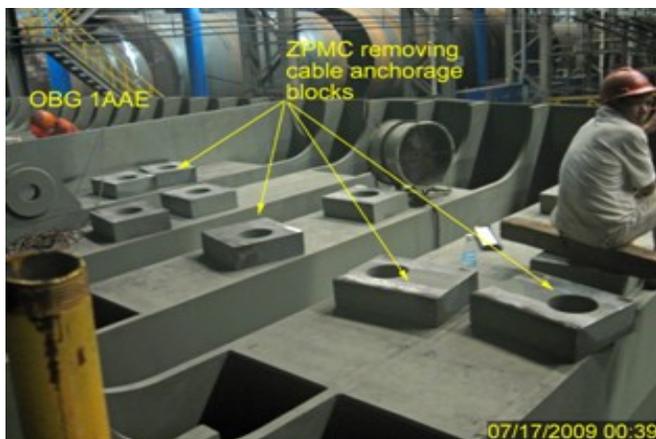
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would submit an NDT notification to Caltrans QA after the repairs have been accepted by ZPMC QC and ABF QA inspectors.

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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