

**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-008902**Date Inspected:** 13-Sep-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:** Chen Xi**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**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**

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

**OBG CROSS BEAM CB2**

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

**OBG CROSS BEAM CB3**

This crossbeam has been loaded on the ship.

**OBG CROSS BEAM CB4**

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

OBG CROSS BEAM CB5

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

OBG CROSS BEAM CB6

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

OBG CROSS BEAM CB7

This QA observed that ZPMC QC Magnetic particle Testing (MT) technicians have discovered numerous fillet welds that exhibit crack like linear indications where the side and bottom panel stiffeners pass through the floor beam diaphragms. ZPMC CWI identified as Mr. Chen Xi informed this QA that due to the number of indications discovered, ZPMC intends to perform 100% MT on all of the floor beam diaphragm welds as specified in the contract documents.

OBG CROSS BEAM CB8

This QA observed ZPMC qualified welding personnel identified as 222396 perform FCAW welding on weld joint identified as CB202G-020-041. ZPMC QC identified as Mr. Liu Chuan Gang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-Tc-U4b-F.

OBG CROSS BEAM CB9

This QA observed ZPMC qualified welding personnel identified as 220688 perform FCAW welding on weld joint identified as CB202G-023-160. ZPMC QC identified as Mr. Meng Lin Nan was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2132.

This QA observed ZPMC qualified welding personnel identified as 220688 perform FCAW welding on weld joint identified as FB204-022-088. ZPMC QC identified as Mr. Meng Lin Nan was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-B-U2-F.

OBG CROSS BEAM CB10

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

OBG CROSS BEAM CB11

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

## OBG CROSS BEAM CB12

This QA observed this cross beam has been removed from this bay and is being stored behind bay 16. No significant work was observed on this crossbeam during the time QA was present.

## OBG CROSS BEAM CB13

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

## OBG CROSS BEAM CB14

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

## OBG CROSS BEAM CB15

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

## OBG CROSS BEAM CB16

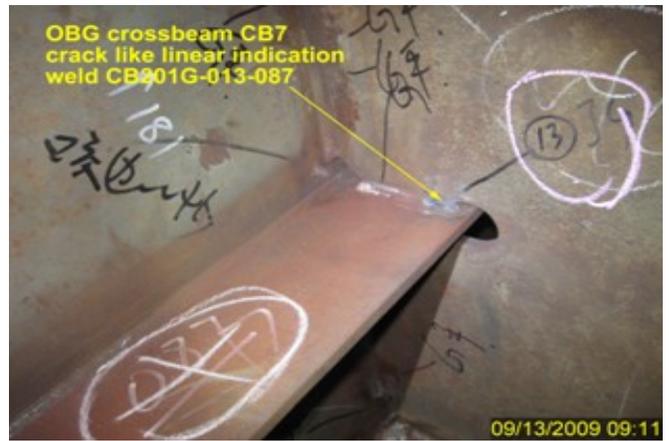
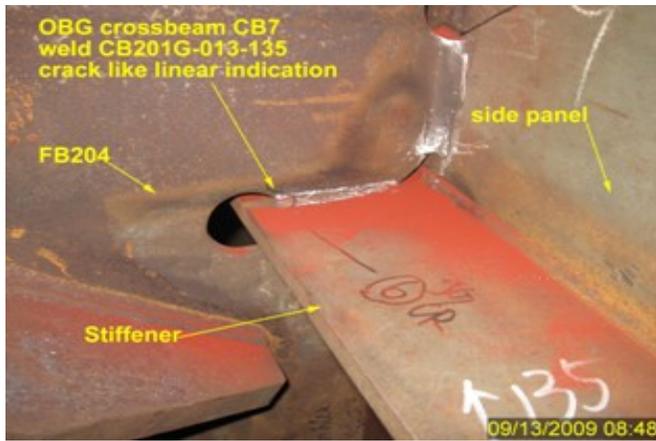
This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

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



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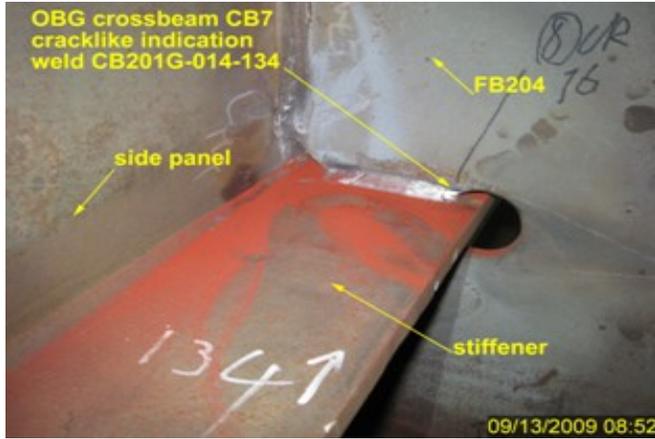
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## Summary of Conversations:

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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