

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-009490**Date Inspected:** 14-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

<b>CWI Name:</b>	Xu Xian Ping	<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/Tower Subassemblies	

**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Stefan Holmes was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

QA Inspector responded to a Notification of Inspection for MT of DP3071-001, but this inspector found that MT by ZPMC was not yet complete. This inspector notified ABF QA and ZPMC QC that QA MT could not be performed.

QA Inspector performed Quality Assurance final MT verification on Tower double diaphragms following the guidelines of Caltrop MT Procedure CTMT-08-00 Rev. 2.1. Thia QA Inspector generated an MT report for this date. Assemblies inspected and results are as follows:

West Tower 143m Diaphragm step plate; wsd1-dpsa4-12b/b-3

West Tower 143m Diaphragm step plate; wsd1-dpsa4-12b/b-20-25, 4-7, 12, 13, 16, 17

West Tower 135m Diaphragm step plate; wsd1-dpsa4-6b/b-3

West Tower 143m Diaphragm step plate; wsd1-dpsa4-6b/b-20-25, 4, 5, 8, 9, 12, 13, 16, 17

QA inspector performed conventional Ultrasonic (UT) Inspection on deck panel tack weld areas. The inspection is

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

preliminary prior to using the phased array (PAUT) testing system to verify indications found with conventional Ultrasonic testing. QA inspector performed UT on deck panel DP402-001, 5 ribs, 10 welds, 280 total tack welds inspected.

- Weld 1 scanned 28 locations with 2 indications.
- Weld 2 scanned 28 locations with 1 indications.
- Weld 3 scanned 28 locations with 0 indications.
- Weld 4 scanned 28 locations with 1 indications.
- Weld 5 scanned 28 locations with 0 indications.
- Weld 6 scanned 28 locations with 0 indications.
- Weld 7 scanned 28 locations with 1 indications.
- Weld 8 scanned 28 locations with 0 indications.
- Weld 9 scanned 28 locations with 1 indications.
- Weld 10 scanned 28 locations with 0 indications.

All indications for further inspection by PAUT are marked on top of u-ribs. Please see U-rib Deck Panel Tack Weld Assessment sheet dated today for specific locations of indications.

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

**Summary of Conversations:**

No relevant conversations.

**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 , who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Holmes,Stefan	Quality Assurance Inspector
----------------------	---------------	-----------------------------

---

<b>Reviewed By:</b>	Hall,Steven	QA Reviewer
---------------------	-------------	-------------