

**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-010843**Date Inspected:** 18-Nov-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

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>
<b>Inspected CWI report:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
		<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG Components	

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Yard, North of OBG Bay 14

ZPMC issued Inspection Notification Sheet number 4675 informing this QA Inspector that ZPMC had completed visual inspections (VT) and magnetic particle inspections (MT) of various OBG segment 7CE welds and they were ready to be green tag released. This QA Inspector performed random VT and MT of the following deck plate to deck plate diaphragm welds, deck plate diaphragm to U-rib welds, and various welds at corner assemblies: Tag #2: DP332-001-097, 098, 099, 100, 101, 102, 103, 104, 105, 106, 107, 108, 109, 110, 111, 112, 113, 114; DP332-002-097, 098, 099, 100, 101, 102, 103, 104, 105, 106, 107, 108, 109, 110, 111, 112, 113, 114; DP359-001-094, 095, 096, 097, 098, 099; DP305-001-094, 095, 096, 097, 098, 099; Tags #5 and #7: CA 039-043, 044, 045, 046, 047, 048, 049, 050, 051, 052, 053, 054; Tags #6 and #7: CA 040-043, 044, 045, 046, 047, 048, 049, 050, 051, 052, 053, 054; Tag #5: CSD6-PP054-065, 066, 071, 072, 095, 096, 099, 100; CSD2-PP054.5-133, 134, 135, 136, 137, 138, 139, 140, 143, 144; Tag #6: CSD7-PP054-029, 030, 031, 032, 033, 034, 035, 036, 037, 038. The welds listed above appear to comply with AWS D1.5 MT requirements. For additional information on these inspections see the TL6028 MT report.

Blast Shop #1

This QA Inspector, along with Caltrans QA Inspector Paul Dawson, performed random visual inspections of upper

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

interior surfaces of OBG Segment 7AW. ZPMC had just completed grit blasting of these interior surfaces and the steel surfaces were mostly free of rust oxide and other contaminants that had previously obscured portions of the welds. Various areas of the closed ribs did not appear to have been completely grit blasted and paint stick markings were visible in the primer gray coated surfaces. However, either ZPMC QC inspectors or ABF representatives had apparently marked these areas for re-blasting prior to this inspector's arrival. This QA Inspector visually observed approximately 40 locations that required grinding or welding to resolve visual weld spatter, arc strikes, shallow nicks and other surface rejections. All areas observed to require further work were marked with colored chalk and ZPMC had several workers using grinders to smooth the visually unacceptable areas requiring that work.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

**Summary of Conversations:**

No significant 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 Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Goulet,George	Quality Assurance Inspector
<b>Reviewed By:</b>	Dawson,Paul	QA Reviewer

---