

**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-011193**Date Inspected:** 17-Dec-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 Sub-Assembly	

**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.

This QA Inspector performed training and monitoring of new hire for performing in progress inspection, Magnetic Particle Testing (MT), and Ultrasonic Inspection (UT) of fabricated assemblies pursuant to Caltrans and Code inspection procedure requirements.

Training included introduction to ZPMC Quality Control (QC) personnel, American Bridge/Flour QC personnel, over view of duties and work area as well as acceptance criteria.

This QA Inspector performed Green Tagging activities pursuant to the approved Green Tag procedure and NDT Inspection Notification Sheet (Document #004881 and #004874). Items green tagged are as follows:

FB3056-001; Tag #11343  
FB3089-001; Tag #11226  
FB3091-001; Tag #11228  
FB3039-001; Tag #11342  
DP3026-001; Tag #11816  
DP3020-001; Tag #11815

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Non-Destructive Testing pursuant to Non-Destructive Testing Inspection Notification Sheet (Document No. 004883):

**Magnetic Particle Testing:**

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

1. FB3081-001-093, 106, 107, 086~088, 77, 129, 071, 072, 111, 120, 121
2. FB3056-001-071, 072, 077, 150, 088, 086, 087, 106, 107, 093, 147, 114, 130~133, 136, 137, 111, 120, 121, 123, 124, 138, 139, 163.

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.

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<b>Inspected By:</b>	Holmes,Stefan	Quality Assurance Inspector
<b>Reviewed By:</b>	Hall,Steven	QA Reviewer

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