

**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-011443**Date Inspected:** 05-Jan-2010**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>Bridge No:</b>	34-0006	<b>Delayed / Cancelled:</b>	Yes No N/A	
		<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.

**Non-Destructive Testing:**

Ultrasonic Testing (UT) pursuant to NDT Inspection Notification Sheet (Document No. 004996):

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

- |                         |                          |
|-------------------------|--------------------------|
| 1. 19TB2 WELD 001, 002  | 2. 19TB3 WELD 001, 002   |
| 3. 14TB6 WELD 001, 002  | 4. 14TB2 WELD 001, 002   |
| 5. 14TB9 WELD 002       | 6. 14TB10 WELD 001       |
| 7. 15TB5 WELD 001, 002  | 8. 15TB12 WELD 001, 002  |
| 9. 16TB6 WELD 001, 002  | 10. 16TB10 WELD 001, 002 |
| 11. 17TB9 WELD 001, 002 | 12. 17TB11 WELD 001, 002 |

Magnetic Particle Testing (MT) pursuant to NDT Inspection Notification Sheet (Document No. 004992):

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# WELDING INSPECTION REPORT

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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. DP3004-001-011~020

This QA Inspector performed Green Tagging activities in conformance with the Green Tagging procedure. Items Green Tagged and Green Tag numbers are as follows:

1. DP3004-001; Green Tag No. 11836
2. FB3073-004; Green Tag No. 11283
3. FB3069-003; Green Tag No. 11277
4. FB3069-001; Green Tag No. 11275
5. LD3013-001; Green Tag No. 12063
6. LD3014-001; Green Tag No. 12065
7. LD3013A-001; Green Tag No. 12064
8. LD015-040; Green Tag No. 11970
9. LD016-040; Green Tag No. 11971
10. LD018-026; Green Tag No. 11973
11. LD017-026; Green Tag No. 11972
12. LD3015-001; Green Tag No. 12067
13. LD3017-001; Green Tag No. 12069
14. LD3016-001; Green Tag No. 12068
15. LD3018-001; Green Tag No. 12070
16. LD3014A-001; Green Tag No. 12066

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 Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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