

**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-011452**Date Inspected:** 02-Jun-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>                   | Sun Bo     | <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 Deck Panels |    |

**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 performed conventional Ultrasonic Testing (UT) Inspection on repairs made to U-Rib Connection Plates. Connection plates are a built Channel member, making the weld configuration a T-joint Complete Joint Penetration (CJP) weld. U-rib connection plates inspected and results are as follows:

USPL1-029-Weld 001: USPL1-031-Weld 002:  
USPL1-028-Weld 001: USPL1-032-Weld 002:  
USPL1-025-Weld 001: USPL1-035-Weld 002:  
USPL1-025-Weld 002: USPL1-035-Weld 001:  
USPL1-023-Weld 002: USPL1-038-Weld 001:  
USPL1-021-Weld 002: USPL1-041-Weld 001:  
USPL1-019-Weld 001: USPL1-043-Weld 002:  
USPL1-019-Weld 002: USPL1-043-Weld 001:  
USPL1-018-Weld 002: USPL1-046-Weld 002:  
USPL1-017-Weld 001: USPL1-047-Weld 002:  
USPL1-009-Weld 002: USPL1-007-Weld 002:  
USPL1-005-Weld 001: USPL1-007-Weld 001:  
USPL1-036-Weld 002:

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USPL1-048-Weld 001:

USPL1-048-Weld 002:

QA inspector performed conventional Ultrasonic Testing (UT) Inspection on the Segment 2AE to Segment 2BE splice weld. QA Inspector performed 15% QA Verification UT of the following weld joints with no reject able indications noted:

Deck Panel; weld OBE2-002, OBE2-003, OBE2-004:

Edge Plate; weld OBE2-001, OBE2-005:

Side and Bottom; weld OBE2A-002, OBE2A-003, OBE2A-004, OBE2A-005, OBE2A-006:

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

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