

**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-011774**Date Inspected:** 04-Feb-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**CWI Name:** Xu Xian Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:****Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Daniel Barrentine 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:**

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel in accordance with Notification #005177. All welds inspected appear to conform to the contract documents. The members are identified as OBG U- Rib Strut Plate Assemblies. The weld designations reviewed are as follows:

1. USPL1- 284- 001
2. USPL1- 284- 002

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) of 21TR3-001; Weld 005. Welder is identified as 215397. ZPMC Quality Control (QC) is identified as Tian Lei. Weld Procedure Specification, (WPS), is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS.

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In- process Heat Straightening of Traveler Rail # 11TR3-013 was observed by this inspector at 10:10 AM. Heat Straightening Record, (HSR), was identified as HSR1(B)-8087, and ZPMC QC was identified as Zhong Dian Xing.

This QA Inspector performed Green Tagging activities in conformance with the approved green tag procedure on the OBG Traveler Rail Brackets listed below:

1. TR5B- PP47 Green Tag #011143
2. TR6C- PP38 Green Tag #011853
3. TR6C- PP40 Green Tag #011886
4. TR6C- PP44 Green Tag #011143
5. TR6B- PP42 Green Tag #011143
6. TR5D- PP39 Green Tag #011143
7. TR5D- PP45 Green Tag #011143
8. TR5C- PP37 Green Tag #011143
9. TR5C- PP41 Green Tag #011143
10. TR5C- PP43 Green Tag #011143
11. TR5C- PP45 Green Tag #011143



## Summary of Conversations:

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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>	Barrentine, Daniel	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon, Albert	QA Reviewer

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