

**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-012091**Date Inspected:** 13-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**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:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

This QA inspector performed 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 member(s) is/are identified as 6AW Holdback welds at panel point 37 cross beam side and CB4. The weld designations reviewed are as follows:

OBG 6AW

1. EP21-001-16, 17
2. DP513-001-9, 10
3. SP513-001-11, 12, 21, 22
4. SP81-001-20, 21
5. SP473-001-36, 37, 48, 49
6. SP751-001-13, 14, 23, 24

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This QA Inspector performed MT of area previously tested and accepted by Quality Control on CB4 per Notice of Witness Inspection Number (NWIT) is No. 005209 OBG CWR 1213. MT was performed on horizontal stiffener to side plate. QA Inspector observed one Transverse linear indication, measuring approximately 9mm in length respectively. The QA Inspector generated a TL-6028 MT report on this date. Weld MT verified was identified as listed below

CB4

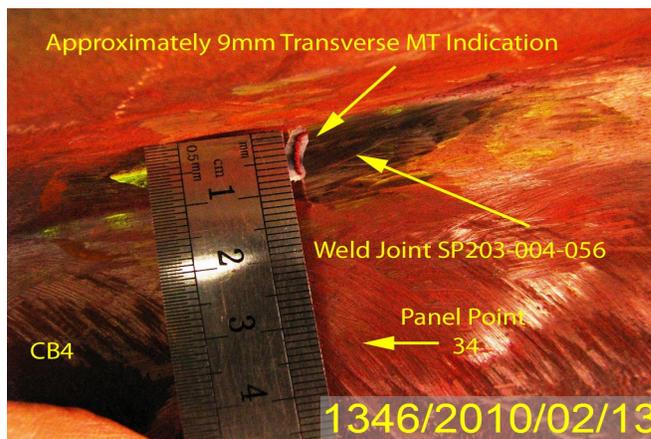
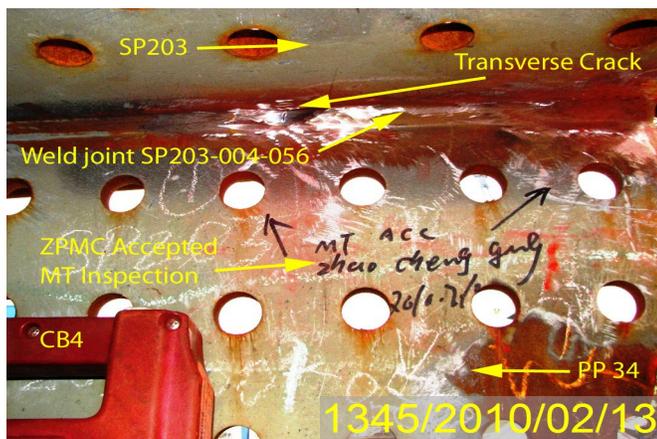
1. SP203-004-056.

This QA Inspector issued an incident report on the above noted MT rejections.

7BW+7CW

Submerged Arc Welding (SAW) welding was performed on weld joint 008 located at OBW7 on deck of segment. Welder is identified as Mr. Ma Ying (045270). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-223(2)1T-2.

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



## Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

## 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.

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**Inspected By:** Alaniz,Joe

Quality Assurance Inspector

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**Reviewed By:** Miller,Mark

QA Reviewer