

**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-012679**Date Inspected:** 08-Mar-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.

In- Process Inspections:

Layout for UT by ABF at 7CW EP to DP Counter weight side.

Weld repair of MT indications to the horizontal stiffeners on 6AW.

Base metal repairs on the bottom plate interior at the cross beam splice area on 6AW.

Base metal repairs to the horizontal stiffeners at PP46 on section 6CW.

Base metal repair at the corner joint of section 6CE at the 6CE to 7AE transverse splice, cross beam side.

Weld repair of MT indications to the horizontal stiffener welds on section 6CE.

Welding of "T" stiffener terminations on section 6CE, cross beam side.

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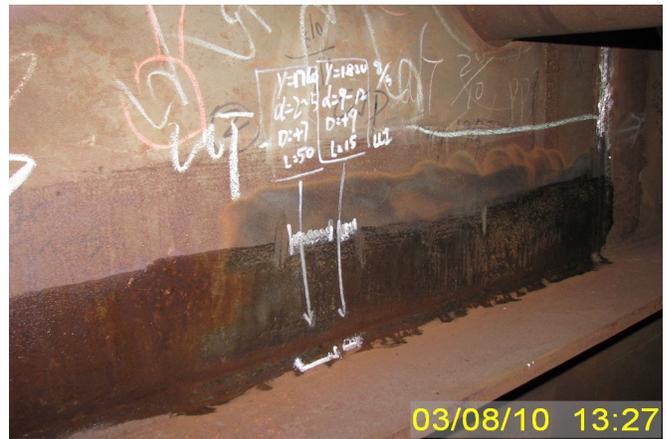
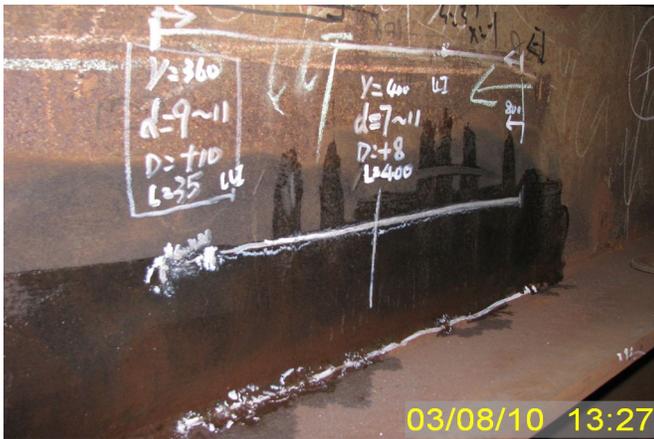
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Grinding of inside transverse splice weld on section 7CW at the 7BW to 7CW bottom plate.

Fit- up of horizontal stiffeners between PP52 and PP53 on the edge plate on section 7CW, counterweight side.

This inspector witnessed conventional ultrasonic inspection, UT, on the complete joint penetration, CJP, portions of the deck panel diaphragm to floor beam flange on section 9EE at panel points 83, 84, and 85. Indications were noted by ABF at the time of inspection, and will be reported on the ABF UT report. ABF UT operators were found to be S021 and S013.

Unless otherwise noted, all work observed on this date appeared to generally comply with 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

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your project.

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