

**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-012738**Date Inspected:** 12-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

<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>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>		

**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:**

Welding on section 6CW at PP44 LD diaphragm to FL3 horizontal stiffener.

SMAW of section 7AW to 7BW transverse side plate weld. The welder was identified as 045196. The welding procedure was identified as WPS- B-P-2214-B-U2-FCM-1. This weld is identified as CA032-002.

SMAW of section 7AW Side Plate to Edge Plate. This weld is identified as CA032-001. The welder was identified as 037996. The welding procedure was identified as WPS- B-P-2214-B-U2-FCM-1.

SMAW of section 7BW bottom plate. This weld is identified as SEG035A-021. The welding procedure was identified as WPS- B-P-2214-Tc-U4b-FCM-1.

Welding of section 7BW at deck plate number DP-639-001- 13, 14, 15, 16, 17, 18. The welder was identified as 067589. The welding procedure was identified as WPS-B-T-4114-1.

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# WELDING INSPECTION REPORT

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Welding of section 7BW at deck plate number DP-647-001- 13, 14, 15, 16, 17, 18. The welder was identified as 066326. The welding procedure was identified as WPS-B-T-4114-1.

ABF UT of section 7BE, edge plate to deck plate, cross beam side.

Excavation of UT indications on section 7CE, Bike Path side, by ZPMC personnel.

Weld Repair of UT indications on section 7BE, Bike Path side, by ZPMC personnel.

## Non- Destructive Testing

This inspector performed conventional ultrasonic testing, UT, on section 9BE, deck plate to edge plate, counterweight and bike path sides, in accordance with scanning pattern "D". This inspection was in conjunction with ABF, and in accordance with the approved "D" scan procedure. No additional indications were found during the inspection. For more information on indications, see the ABF Ultrasonic Testing report for this date.

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 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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