

**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-013782**Date Inspected:** 06-May-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:** 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:** Trial Assembly**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Christopher D'souza 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 observed and/or found the following:

Trial Assembly

8BE – 8CE Deck Plate – Repair

This QA Inspector observed ZPMC welding personals identified as 053753 performing repair welding by Shielded Metal Arc welding process (SMAW) on DP 660-001 – 019, 020 and 021, ZPMC QC is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 3G (3F) – FCM – Repair 1 and WR 12848, 12849 and 12850

8AW – 8BW Edge Plate CW side

This QA Inspector observed ZPMC welding personals identified as 067588 welding utilizing Shielded Metal Arc welding process (SMAW) on OBW8 – 001, ZPMC QC is identified as Zhang Hai Tao. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2213 – B – U2 – FCM – 1

8AW – 8BW Bottom Plate

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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This QA Inspector observed ZPMC welding personals identified as 045196 welding utilizing Shielded Metal Arc welding process (SMAW) on OBW8B – 003, ZPMC QC is identified as Zhang Hai Tao. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2214 – B – U2 – FCM – 1

7EW DP – EP Holdback CW side

This QA Inspector observed ZPMC welding personals identified as 066002 welding utilizing Shielded Metal Arc welding process (SMAW) on CA043 - 002, ZPMC QC is identified as Zhang Hai Tao. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2212 – Tc – U4b – FCM – 1

NDT Observations

8BE – 8CE Deck plate

QA Inspector witnessed ABF Inspectors performing Magnetic particle Testing (MT) on 8BE – 8CE transverse splice weld on areas where temporary attachments were removed and base metal was grinded flush.

7CW – 7DW Transverse splice

QA Inspector witnessed ABF Inspectors performing initial UT utilizing Detection of Transverse Planar Discontinuities with Significant Flaw Height Dimension Procedure, on the following welds

7CW – 7DW Deck plate

7CW – 7DW Side plate (CB side and CW side)

7CW – 7DW Bottom plate

This QA Inspector was involved in PAUT (Phased Array Ultrasonic Testing) training for detection of cracked tacks in Deck Panels as per the following procedure “UT 04-0120F4 PJP Rib Weld Phased Array Ultrasonic Testing for the Detection and Sizing of Suspected Planar Discontinuities (Cracks) in PJP Welds”

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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**Inspected By:** Dsouza,Christopher

Quality Assurance Inspector

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# WELDING INSPECTION REPORT

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**Reviewed By:** Carreon,Albert

QA Reviewer