

**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-013921**Date Inspected:** 07-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**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

ABF Inspection Request number 05062010-1

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBG components previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3 and Detection of Transverse Planar Discontinuities with Significant Flaw Height Dimension Procedure. The QA Inspector observed no rejectable indications at the time of testing. Weld identification numbers were

CA035 – 002, 006 (7BW DP to EP – W2 Holdback CW side)

OBE8 – 001 (8AE to 8BE Edge plate CB side)

This QA Inspector performed conventional UT (Ultrasonic Testing) in conjunction with ABF UT department for detection of planar transverse indication

See Caltrans Ultrasonic Transverse Indication Evaluation sheet dated May 7th, 2010 for further information on

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

inspection.

### 8AW – 8BW Side Plate Counter Weight side

This QA Inspector observed ZPMC welding personals identified as 045196, 045243 and 045280 performing welding by Shielded Metal Arc welding process (SMAW) on OBE8B – 001, 002, ZPMC QC is identified as Zhang Xiao Ming. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2214 – B – U2 – FCM - 1

### 8BW – 8BW Deck Plate

This QA Inspector observed ZPMC welding personals identified as 045270, 045265 performing welding by Submerged Arc welding process (SAW) on OBE8 – 003, ZPMC QC is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with the WPS – B – T – 223(2)/T - 2

### 8BW CW Bracket

This QA Inspector observed ZPMC welding personals identified as 066734 performing welding by Flux Cored Arc welding process (FCAW) on OBW8A – 023; ZPMC QC is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231T – 1

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.

---

|                      |                    |                             |
|----------------------|--------------------|-----------------------------|
| <b>Inspected By:</b> | Dsouza,Christopher | Quality Assurance Inspector |
| <b>Reviewed By:</b>  | Carreon,Albert     | QA Reviewer                 |

---