

**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-014591**Date Inspected:** 27-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:** Chen Shi Gang**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 (QA) Inspector Umesh Gaikwad 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 Bay 09, Deck Panel 13AE-DP3076-001

This QA inspector performed conventional Ultrasonic Testing (UT) Inspection on deck panel tack weld areas. The inspection is preliminary prior to using the phased array (PAUT) testing system to verify indications found with conventional Ultrasonic testing. QA inspector performed UT on deck panel 13AE-DP3076-001, 2 ribs, 4 welds, 100 total tack welds inspected.

Weld 5 scanned 25 locations with 1 indication.

Weld 6 scanned 25 locations with 2 indications.

Weld 7 scanned 25 locations with 1 indication.

Weld 8 scanned 25 locations with 1 indication.

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 12

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This QA inspector observed repair welding on the tack weld location of deck panel which were rejected by PAUT. Repair welding was being performed on deck panel DP3121-001. The weld procedure was found to be WPS-345-FCAW-2G(2F)-FCM-REPAIR. The welding operator was identified as 062259. The Y locations (in mm) were identified as follows:

Weld 1- 9250, 10450, 12850, 13450, 13850

Weld 2- 9850, 13450

Weld 3- 11050

Weld 4- 13450

Weld 5- 10450

Weld 6- 10450, 12850

Weld 7- 12250

Weld 8- 11050, 11650

Weld 9- 11650, 12850

Weld 10- 13450, 13850

ZPMC and ABF QC were present during the welding process and identified as Mr. Zhang Qian and Mr. Cao Hai Zhou respectively.

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 : 15000422372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Gaikwad,Umesh

Quality Assurance Inspector

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**Reviewed By:** Clifford,William

QA Reviewer