

**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-015441**Date Inspected:** 03-Jul-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 13CE-DP3104-001

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 13CE-DP3104-001, 12 ribs, 24 welds, 184 total tack welds inspected.

Weld 001 scanned 9 locations with 1 indications.

Weld 002 scanned 9 locations with 0 indications.

Weld 003 scanned 9 locations with 1 indications.

Weld 004 scanned 9 locations with 0 indications.

Weld 005 scanned 9 locations with 0 indication.

Weld 006 scanned 9 locations with 0 indications.

Weld 007 scanned 9 locations with 2 indications.

Weld 008 scanned 9 locations with 1 indications.

Weld 011 scanned 9 locations with 1 indication.

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Weld 012 scanned 9 locations with 1 indications.  
Weld 013 scanned 9 locations with 0 indications.  
Weld 014 scanned 9 locations with 1 indications.  
Weld 015 scanned 9 locations with 0 indication.  
Weld 016 scanned 9 locations with 0 indication.  
Weld 017 scanned 9 locations with 0 indication.  
Weld 018 scanned 9 locations with 0 indication.  
Weld 021 scanned 5 locations with 0 indication.  
Weld 022 scanned 5 locations with 0 indication.  
Weld 023 scanned 5 locations with 0 indication.  
Weld 024 scanned 5 locations with 0 indication.  
Weld 025 scanned 5 locations with 0 indication.  
Weld 026 scanned 5 locations with 0 indication.  
Weld 027 scanned 5 locations with 0 indication.  
Weld 028 scanned 5 locations with 0 indication.

OBG Bay 09, Deck Panel 13CE-DP3102-001

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 13CE-DP3102-001, 12 ribs, 24 welds, 184 total tack welds inspected.

Weld 001 scanned 9 locations with 0 indications.  
Weld 002 scanned 9 locations with 0 indications.  
Weld 003 scanned 9 locations with 0 indications.  
Weld 004 scanned 9 locations with 0 indications.  
Weld 005 scanned 9 locations with 0 indications.  
Weld 006 scanned 9 locations with 0 indications.  
Weld 007 scanned 9 locations with 0 indications.  
Weld 008 scanned 9 locations with 0 indications.  
Weld 011 scanned 9 locations with 0 indications.  
Weld 012 scanned 9 locations with 1 indication.  
Weld 013 scanned 9 locations with 0 indications.  
Weld 014 scanned 9 locations with 0 indications.  
Weld 015 scanned 9 locations with 0 indications.  
Weld 016 scanned 9 locations with 1 indication.  
Weld 017 scanned 9 locations with 1 indication.  
Weld 018 scanned 9 locations with 0 indications.  
Weld 021 scanned 5 locations with 0 indications.  
Weld 022 scanned 5 locations with 0 indications.  
Weld 023 scanned 5 locations with 0 indications.  
Weld 024 scanned 5 locations with 0 indications.  
Weld 025 scanned 5 locations with 0 indications.

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Weld 026 scanned 5 locations with 1 indication.

Weld 027 scanned 5 locations with 0 indications.

Weld 028 scanned 5 locations with 0 indications.

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

BAY 04

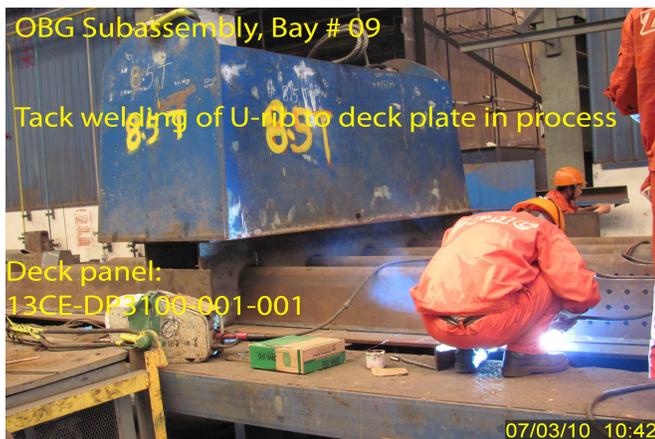
13CE-DP3099-001

Gas Metal Arc Welding (GMAW) tack welding of U-rib to deck plate of DP3099-001 were in process. The welder is identified as 059472. ZPMC Quality Control (QC) is identified as Mr. Chen Shi Gang. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U5(U-rib). Welding appears to conform to the requirements of the WPS used.

13CE-DP3100-001

Gas Metal Arc Welding (GMAW) tack welding of U-rib to deck plate of DP3100-001 were in process. The welder is identified as 062305. ZPMC Quality Control (QC) is identified as Mr. Chen Shi Gang. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U5(U-rib). Welding appears to conform to the requirements of the WPS used.

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