

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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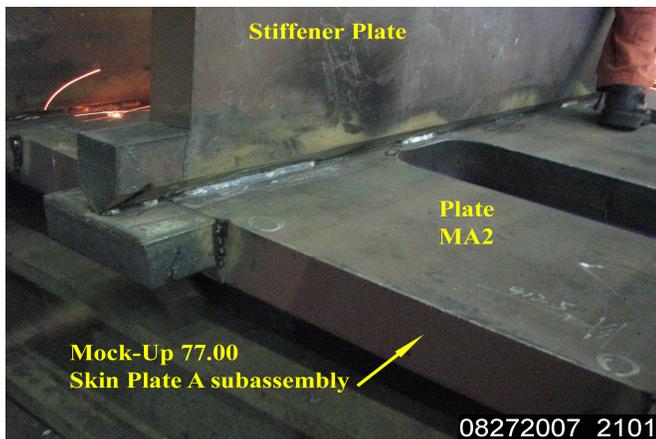
Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000396**Date Inspected:** 27-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng**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:** Caltrans Mock-Up 77.00**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup and welding of the Caltrans Mock-up #77.00, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Caltrans QA Inspector observed ZPMC shop personnel performing shielded metal arc welding (SMAW) tack welding at skin plate A, piecemark MA2, longitudinal stiffener plates to the skin plate. ZPMC QA inspector Mr. Fu Yuhong stated, tack welding is being performed in accordance with welding procedure WPS-B-P-2212-T-U5b and welders performing the welding are Mr. Li Dong and Mr. Gu Dengyun. After the completion of the tack welding, the subassembly was then moved to a fixture table and the secured by the use of hold down devices (dogs), that were tack welded to the fixture table, to minimize distortion during the welding of the stiffener plates to the skin plate. Following digital picture illustrates attachment of hold down device being attached to the fixture table, to secure the subassembly for the welding.

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Item	Description	WBS	Dwg No.	Status
1	Skin Plate E	NA	NA	Work in progress

Caltrans QA Inspector observed ZPMC QC nondestructive technician, Mr. Cai Xin Xin perform magnetic particle testing (MT) and Visual Testing (VT). The testing was performed at the plate splice welds and plate attachment removal locations. The subassemblies tested and locations are identified as, skin plate E, inside side, splice weld, two attachment removal locations, and outside side, splice weld; skin plate B, four attachment removal locations, inside side. The testing appeared to be in general conformance with AWS D1.5 2002 requirements. At the conclusion of each inspection, ZPMC QC inspector, Mr. Xu Le Feng reported that welds and attachment locations were found acceptable. Following digital pictures illustrates MT in progress.



2	Skin Plate E and B	NA	NA	QA MT
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The Caltrans QA Inspector performed visual test (VT) and MT examinations of the plate splice welds and plate attachment removal locations at skin plate E and B. Caltrans QA Inspector observed that the welds and plate attachment removal locations appeared to be in general conformance with AWS D1.5 2002 requirements. See MT report TL6028, generated on this date for further information.

## Summary of Conversations:

As identified within the contents of this report.

## 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

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remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
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<b>Reviewed By:</b>	Cuellar, Robert	QA Reviewer
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