

**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-000516**Date Inspected:** 21-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	114 Meter Mock-Up	

**Summary of Items Observed:**

This Quality Assurance Inspector observed ultrasonic testing of four complete joint penetration T-joints on 114 Meter Mock-Up, Face A Skin Plate Sub-Assembly detailed on drawing MUSC-MA106. There were four 75 millimeter thick longitudinal plates welded to plate MA-106 which was 90 millimeters thick. The ultrasonic technicians were E Shuiqin and Li Liming of ZPMC. Mr. Ming was observed using both a zero degree and 45° transducers while Miss Qin was using a 70° transducer. Both technicians were observed using adequate scanning patterns from both the A and B sides of the welds. A total of 2 out of the 4 welds were found unacceptable by ultrasonic testing. The unacceptable welds were welds 8 & 12.

**Summary of Conversations:**

There were no significant conversation held today.

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

**Inspected By:** Berger, Bruce

Quality Assurance Inspector

**Reviewed By:** Cochran, Jim

QA Reviewer