

**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-000923**Date Inspected:** 28-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**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>	77, 89 & 114 Meter Mock-Up & OBG	

**Summary of Items Observed:**

This Quality Assurance Inspector oversaw Quality Assurance Inspectors Ken Jobes, Scott Croff, and Roscoe Dixon performing fabrication inspection out on the shop floor today. Mr. Jobes observed the 89 Meter Mock-Up MUSB-MA22 skin plate D, MUSB-MA38A/B and MUSB-MA21 all being welded. Mr. Dixon witnessed welding on both MUSB-MA38A/B and MUSB-MA21 and went to witness the bending of plate for the OBG, however the bending machine was inoperable so the bending was canceled. Mr. Croff performed visual inspection on the roots of welds 7 & 8 of the 89 Meter Mock-Up MUSB-MA22 skin plate D after quality control liaisons had informed him that the magnetic particle testing by ZMPC had been completed and was acceptable. Mr. Croff also observed the use up plastic buckets being used to transport flux for fracture critical welds in violation of ZPMC's WQCP paragraph 12.4.7.4.

All observations/verifications by Quality Assurance staff appeared to be in compliance with the project specifications with exception of that noted above.

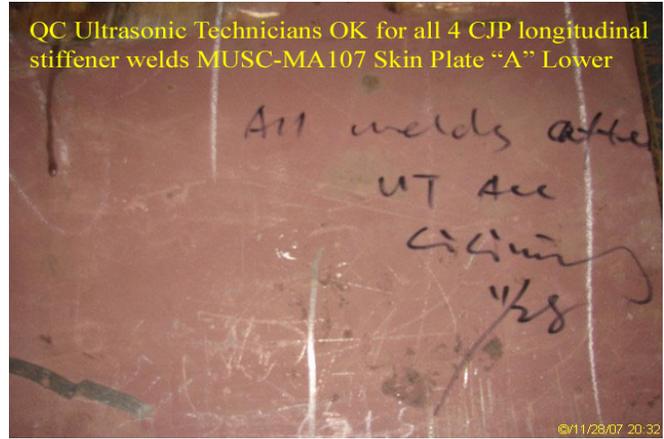
This Quality Assurance Inspector performed ultrasonic testing on MUSC MA107 Lower skin plate A longitudinal stiffeners to skin plate welds. For details of non-destructive testing carried out see ultrasonic report TL-6027 dated November 28, 2007.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

No conversations 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.

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**Inspected By:** Berger, Bruce

Quality Assurance Inspector

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**Reviewed By:** Cochran, Jim

QA Reviewer