

**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-001476**Date Inspected:** 14-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Xu Jun**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:** 89m Tower mock-up**Summary of Items Observed:**

This Quality Assurance (QA) Inspector arrived at ZPMC for observation of the 89m tower mock-up located in the new tower shop. This QA inspector was informed that cracking in the weldments had occurred at various locations within the 89m mock-up. Submittals for Critical Weld Repairs (CWR) were given to the QA inspector for review and mapping locations. This QA inspector spoke with ZPMC QC inspector Xu Jun and discussed when ZPMC would be performing the required it was relayed that the CWR's would not be taking place on this QA Inspector shifts and according to the QC Inspector, ZPMC would notify Caltrans METS prior to the beginning of excavation. ZPMC was observed grinding the splice connection welds for plates Sa194 and Sa184 to be located at skin plates B and C. Once grinding was completed ZPMC ultrasonic Technician Xue Hairong was observed performing a calibration check prior to performing 0° and 70° inspection of the plates for lamination and weld soundness. The UT Technician was witnessed performing his scan for soundness of both plates stated above. It was then relayed to this QA Inspector that Plate Sa194 no rejectable indications were noted and for plate Sa184 one rejectable indication was noted in the weldment. ZPMC informed this QA inspector that they would perform the weld repair the following day 2-15-08. The work noted above appeared to be within the general requirements on the contract documents.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

as noted in the contents above.

## 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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<b>Inspected By:</b>	Riley, Ken	Quality Assurance Inspector
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<b>Reviewed By:</b>	Cochran, Jim	QA Reviewer
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