DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-001481
Date Inspected: 04-Feb-2008

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1700
Location: Shanghai, China

CWI Name: Chen Shigang

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ 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:

This Quality Assurance (QA) Inspector observed various fabrication and welding practices at Zhenhua Port Machinery Company (ZPMC) on Changxing Island in Shanghai, China today for the Self Anchored Suspension Bridge for San Francisco, California.

Orthotropic Box Girder (OBG)

In Bay 1 this QA Inspector observed the milling of plate edges, beveling of partial joint penetration (PJP) preparations, machining of 2 millimeter radius on edges of plates and drilling of bolt holes using hardened washer guides of un-bent closed u-rib plates. This QA Inspector also witnessed the simultaneous bending of the close u-rib panels in compliance with the special provisions. The deck plate DP058 PL94B which had the closed u-ribs tacked in place had 50 millimeter wide plastic tape place over the PJP weld joints. Also observed ZPMC welder Yang Tian Bing, welder identification 066439 was tack welding on deck plate DP049-001-011. When the welder was asked for his welding card a blue one was produced instead of the approved green card. In a conversation with the ZPMC Certified Welding Inspector (CWI) Chen Shigang and Translator Fu Yu Hong it was found that the welder was certified and simply did not have his card with him today.

WELDING INSPECTION REPORT

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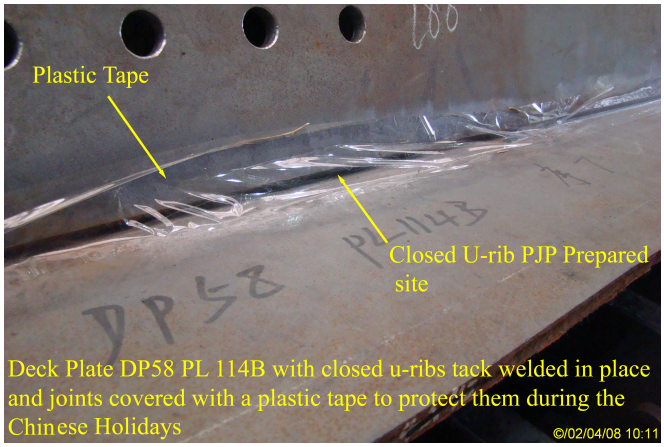

Summary of Conversations:

As noted 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.

Inspected By:	Berger,Bruce	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer