

**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-001488**Date Inspected:** 14-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 800**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	NA	<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>	See Below	

**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M, 114M and U-Rib Trial Assembly, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item Description	WBS	Dwg No.	Status
1 PMT	NA	NA	Witness UT

OBG Bay 1: Caltrans QA Inspector witnessed ZPMC Quality Control (QC), ultrasonic test (UT) technician, Ms. Shui qin perform testing of the Production Monitoring Test (PMT) for deck plate. The three U-rib production samples were identified as GGC-MQ-248 and welds 1, 2, 3, 4, 5 and 6. The production samples measured 800mm in length. Ms. Shui Qin scanned six welds, coverage 100%. Ms. Shui qui completed the UT test stated that the test samples are in conformance with the project requirements. Caltrans QA Inspector observed that the testing performed by Ms. Shui qin, for depth of penetration was performed to ZPMC-UT-02. The following digital picture illustrates the identification marking of the 6 test specimens.

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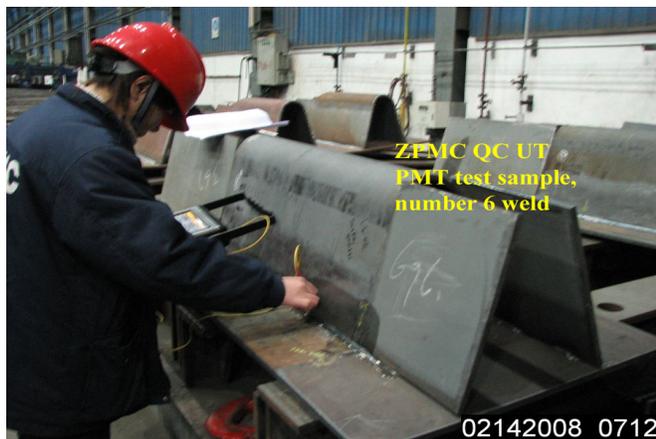
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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

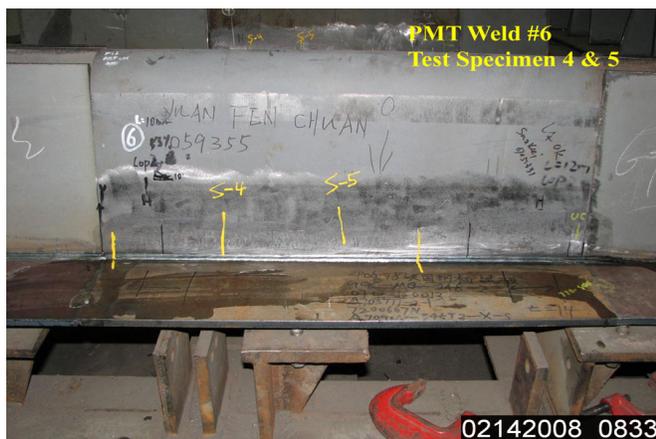
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2 PMT NA NA See Below

OBG Bay 1: Caltrans QA Inspector performed Visual Test (VT) examination of the production monitoring test (PMT) welds. The welds conformed to the Caltrans Special Provisions requirements. QA and ZPMC Quality Control (QC) Inspector, Mr. Xu Jun Shen identify locations for the removal of the macroetch specimen. QC selected the locations for #1, 2 and 3, in accordance with Caltrans Special Provisions requirements. QA selected locations 4 and 5 for macroetch specimen removal. The specimen locations were marked with a paint stick for future removal. The following digital illustrates marking of the specimens.



## Summary of Conversations:

Caltrans QA was notified that ZPMC would be performing ultrasonic testing on the PMT in Bay 1. QA witnessed ZPMC perform the UT testing of the PMT welds.

## 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:** Hasler, Mike

Quality Assurance Inspector

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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**Reviewed By:** Cuellar,Robert

QA Reviewer