

**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 #: 04-0120F4Cty: 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-001527**Date Inspected:** 26-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Yu Hong**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:** OBG**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

The QA inspector performed random fit-up verifications at the junction of the U-ribs to the deck panel DP-020-001. The QA inspector found that deck plate assembly and joint preparation appeared to be in accordance with the contract documents.

However, the QA inspector observed that the tack weld terminations were not ground with a smooth transition for accessing the continuation of the final weld. The QA inspector had a conversation with ZPMC QC representative Sun Wei. The QA inspector brought to ZPMC representative attention that a tack weld termination was ground with sharp and abrupt weld contour. The QA inspector had seen this condition in numerous occasions. Mr. Sun Wei agreed and ZPMC performed additional grinding.

The QA inspector in this date assisted Caltrans QA inspector Mike Hasler on the ultrasonic testing performed at the partial penetration weld joint (PJP) on the production monitoring test (PMT) welded on 02/25/08. See Mr. Mike Hasler's TL\_6031 generated on this date.

**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

---

---

## WELDING INSPECTION REPORT

*( Continued Page 2 of 2 )*

---

---

for your project.

---

**Inspected By:** Acuna,Alfredo

Quality Assurance Inspector

---

**Reviewed By:** Cuellar,Robert

QA Reviewer