

**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-001574**Date Inspected:** 28-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xianping, Sha Zhi**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:** Tower Mock-Up and OBG Components**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector, M. Paul Stovall, was present at Zhenhua Port Machinery Company, (Z. P. M. C.), on Changxing Island, Shanghai, China for the purpose of monitoring the fabrication of the SAS/San Francisco/Oakland Bay Bridge.

89 meter Mock-Up, Preheat weld number MUB-MA21-J/J-(29 & 30), on the inside diameter (id) of the Mock-Up, prior to welding. Weld root pass of each weld. The Welder is Liu Xie—066236.

Bay 2) Z. P. M. C. personnel are drilling bolt holes in a corner connection plate for the 114-meter Mock-Up.

Z. P. M. C. personnel are grinding various welds on the 77-meter Mock-Up.

Bay 3) Z. P. M. C. personnel were observed heat straightening Side Plates (SP) 033B and SP13. The heat and work was continuously monitored by Quality Control (QC) personnel.

Z. P. M. C. QC personnel were checking the flatness of Side Plates, after welding.

Personnel were observed grinding plates where stiffeners will be located, prior to placement of stiffeners.

Z. P. M. C. Welder Dai Lu—048659, is tack welding stiffeners on SP472-001. The work is being monitored adequately by QC personnel.

Z. P. M. C. personnel are grinding the ends of cut and coped W21 x 57's, that will be spliced together to make longer W21 x 57's. Cut W21 x 57's are to be used as WT stiffeners.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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Z. P. M. C. Welder Li Zhaoqian—048810, was observed welding Complete Joint Penetration (CJP) splices of W21 x 57's, that will be used for WT stiffeners.

CWR-018, weld repairs are being made after rejected welds were removed and had the ground out areas Magnetic Particle Tested (MT). The Welder making the weld repairs is Wang Zhonghua—053753.

Z. P. M. C. Welder Li Zhaoqian—048810, was observed making CJP weld splices of uncut W21 x 57's, that will be used to for long WT stiffeners, after they are cut.

Z. P. M. C. personnel are grinding the faying surfaces of cut WT's.

Welder He Yumei—048625 is welding repairing low areas on the faying surface of cut W21 x 57's. Other personnel are grinding these welds flush with the surrounding base metal.

SP524-001 is being welded at the gantry Welder in Bay 3, work is in progress.

The weld termination located on BP024-001, that was marked up for over lap, by other QA personnel, is now in compliance with the Contract Documents.



### Summary of Conversations:

The QA Inspector had no substantial conversations.

### 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:** Stovall,Paul

Quality Assurance Inspector

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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**Reviewed By:** Hager,Craig

QA Reviewer