

**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-001662**Date Inspected:** 25-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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 Deck Panel**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 fit-up verifications of the production monitoring test and the deck panel DP-019-001 before ZPMC started welding. The QA Inspector identified a tack weld that has a toe crack, terminations of the tack welds without smooth transition, tack welds with slag inclusions that was partially ground. The digital photographs below show Caltrans QA findings.

The QA inspector had a conversation with ZPMC QC representative Shen Xue Jun the QA inspector informed Mr. Shen Xue Jun that ZPMC overlooked these indications. ZPMC agreed. The QA inspector observed ZPMC performing tack weld repairs by removing by grinding two tacks completely and grinding the ends of the tacks. The QA inspector observed ZPMC QC inspector Cai Xi Xin performing magnetic particle testing (MT) after ZPMC removed the toe crack on the tack weld. The QA inspector observed that ZPMC verifications appeared to be in accordance with the contract documents. The QA inspector performed MT verification on the tack area. The QA inspector found that the tack welds after removal appeared to be in general compliance with the contract documents.

Note: There was no welding on the PMT or to deck panel DP-017-001 and DP-019-001 on the QA inspector shift.

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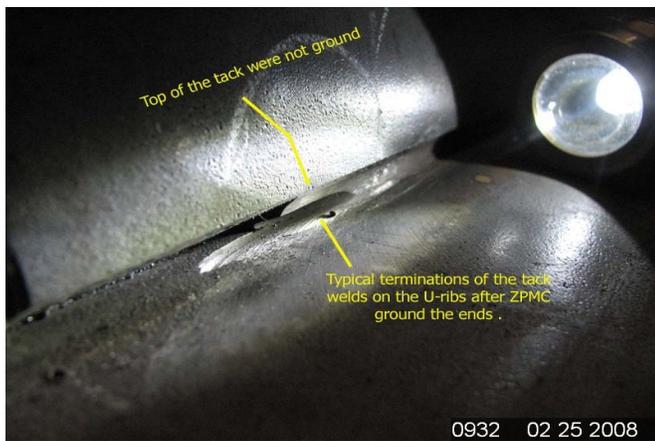
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# WELDING INSPECTION REPORT

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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.

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**Inspected By:** Acuna,Alfredo

Quality Assurance Inspector

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**Reviewed By:** Cuellar,Robert

QA Reviewer