

**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-001776**Date Inspected:** 27-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng, Ye Yong Jun**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-ups and OBG**Summary of Items Observed:**

The Quality Assurance (QA) Inspector Gregory Bertlesman arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following.

**Bay 1**

The Quality Assurance Inspector was requested by the Quality Assurance Inspector's Task Leader to perform a Visual Inspection to Deck Plate DP-064-001 along side ABF and ZPMC. The process that took place was ZPMC Quality Control Inspector Sun Wei would perform visual inspections to approximately 2 meters. Second, ABF Representative Warren Buehler would inspect the same 2 meters. And Finally the Quality Assurance inspector would perform visual inspection to the same two meters. This process took place for welds 1 through 10 for the entire deck plate. In general, all were in agreement of the discontinuities marked. Typical discontinuities marked include but are not limited to, were overlap, undercut, under fill, and incomplete fusion. The Quality Assurance Inspector recorded all the indications lengths and y axis locations in an on site log and forwarded to Assistant Structures Material Representative Ady Valasco for review.

**Side Plate Storage**

The Quality Assurance Inspector observed Side Plates being stored outside adjacent to Bay 1 unprotected from the elements. The Quality Assurance Inspector observed water pooled on the plates from a recent light rain. Below is a digital photograph illustrating the pooled water.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

As stated in the contents of the above report.

## 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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<b>Inspected By:</b>	Bertlesman,Greg	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer

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