

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-002024**Date Inspected:** 14-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**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:** 114-meter Mock-Up**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QA), 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.

114-meter Mock-Up, Z. P. M. C. personnel drilled bolt holes in bolted splice connection plates.

Z. P. M. C. personnel rotated and relocated the Mock-Up.

At Skin B, Z. P. M. C. personnel, started fitting up the welded splice plate to Skin B. It is then bolted down, with the bolts "snugged up". Z. P. M. C. personnel then placed the bolted splice plates in position, and used hydraulic jacks to hold them in place, while pilot holes were started to align the templates with. Note: When the template is placed on the bolted splice connection plates to drill the second set of bolt holes (approximately one half of the plate), the template is out of alignment with the first set of drilled holes by as much as eight (8) Milli-meters (mm).

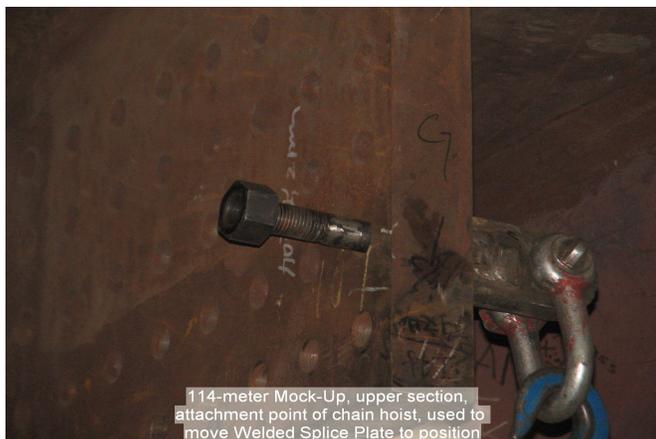
114-meter Mock-Up, upper section, Z. P. M. C. personnel started air arcing a UT reject, at weld number MUC-MA106-B/C-4A. The cut out area is 200 mm long, 41mm wide, and 25 mm deep. Z. P. M. C. Welder Chang Chuacang—053870, did the work. Heaters were placed on the cut out section of the weld to preheat the weld prior to welding. Welding was done on another shift.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

The QA Inspector spoke to Mike Williams, the ABF, QA Supervisor in regards to the bolted splice plates and the use of hydraulic jacks to hold them in place.

## 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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**Reviewed By:** Cochran,Jim

QA Reviewer