

**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-001567**Date Inspected:** 02-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1800**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG Deck Plate	

**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Dan Hernandez was present to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Caltrans QA Inspector performed Visual Inspection on completed welds of Deck Panel DP018-002, welds 1&2 on U-Rib U-190, weld 3 on U-Rib U-274. DP061-001, weld 6 on U-Rib U-181, welds 7&8 on U-Rib U-206, welds 9&10 on U-Rib U-218. The welds are Partial Joint Penetration (PJP) welds, welded in the Horizontal 2G position. The weld includes a Gas Metal Arc Weld (GMAW) root pass with a Submerged Arc Weld (SAW) fill and cover pass. The above noted welds had the following discrepancies over lap, under fill, under cut and incomplete fusion. QA Inspector observed 17 deck panels being stored outside without being covered.

**Summary of Conversations:**

As identified within the contents of this 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.

**Inspected By:** Hernandez, Dan

Quality Assurance Inspector

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# WELDING INSPECTION REPORT

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**Reviewed By:** Cuellar,Robert

QA Reviewer