

**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-001922**Date Inspected:** 19-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**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	

**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Erik Prue 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.

Bay 7- QA Inspector witnessed ZPMC QC UT inspector Mr. Ma Ji Long perform 100% Ultrasonic Inspection on floor beam sub assemblies Complete Joint Penetration (CJP) Butt splices on FB 003-015-103, 003-016-103, FB 003-017-103, FB 003-018-103, and FB 014-003-042. QA Inspector performed ultrasonic verification testing of 100% of QC UT acceptable floor Beam sub assembly welds. The weld and base metal were scanned utilizing a Krautkramer Branson USN 60 #01RN5T. QA Inspector performed a base metal lamination check using a 25mm diameter 2.25 MHz transducer and a shear wave scan using a 20mm x 15mm 2.25 MHz transducer on a 70 degree angle wedge from face A. QA Inspector found QC UT inspection and welds inspected to be in compliance with AWS D1.5- 2002 Table 6.3 and the contract documents. For details please see the ultrasonic testing report TL-6027 dated March 19, 2008.

Bay 1: QA Inspector witnessed ZPMC QC MT inspector Mr. Zhou Dong Yun perform Magnetic Particle (MT) inspection of 10% for total weld length of stiffener to rib welds for Deck Panels DP 326-001 and DP 488-001. QA Inspector performed 10% minimum visual and magnetic particle inspections of portions of stiffener to rib welds DP 326-001-081 thru 084, DP 326-001-023, 014, 032, and 041, and DP 488-001-030 and 064. QA Inspector found QC MT inspection and welds inspected to be in compliance with AWS D1.5- 2002 and the contract documents. For details please see Magnetic particle testing report TL-6028 dated March 19, 2008.

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## WELDING INSPECTION REPORT

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BAY 1: QA inspector performed ultrasonic testing (UT) verification after ZPMC Quality Control (QC) UT inspection on Complete Joint Penetration (CJP) butt splice on deck panel DP-002-001-009. QC UT inspector inspected 10% (250mm) of the total weld length (2400mm) of weld joint. ZPMC QC UT Inspectors accepted weld joints and stenciled acceptance on deck panel. QA UT inspector performed 100% UT inspection of QC 10% UT inspection. QA Inspector found QC UT inspected welds to be in compliance with AWS D1.5- 2002 Table 6.3 and the contract documents. For details please see Ultrasonic Testing report TL-6027 dated March 19, 2008.

### Summary of Conversations:

No significant conversations this day.

### 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 Patrick Lowry, (858) 344-2712, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prue,Erik	Quality Assurance Inspector
<b>Reviewed By:</b>	Hager,Craig	QA Reviewer

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