

**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-002007**Date Inspected:** 15-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****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**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M, 114M, Orthotropic Box Girders (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item Description	WBS	Dwg No.	Status
1 Tower Skin Plate	NA	NA	Welding

New Tower Shop Bay 2: ZPMC performed submerged arc welding (SAW), tower skin plate splice weld. Caltrans QA Inspector observed SAW in progress at skin plate A, splice weld, P456-1 (E) to P375 (E), weld identification ESD1-SA107 A/J-18B. The welder is identified as Mr. Xu Yian utilizing welding procedure WPS-B-T-2221-B-U3c-S. Caltrans QA Inspector observed ABF Inspectors, Mr. Li Han jie and Mr. Dai Qing Wen monitoring welding activities at the work station.

2 Tower Plate	NA	NA	ZPMC Heat Straightening
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New Tower Shop Bay 2: ZPMC performing flame heat straightening operations on tower skin plate for mill induced distortion. The tower skin plate and heat straightening procedure are identified as skin plate P879, procedure HSR1 (T)-691, revision (0). Caltrans QA observed ZPMC heating the plate manually with a rose-bud torch. Caltrans QA observed ZPMC Quality Control Inspector, Mr. Lui Dao feng monitoring the heat straightening of the plate using a calibrated infra-red temperature indicating device to monitor the heat.

**Summary of Conversations:**

As identified within the contents of this report.

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# WELDING INSPECTION REPORT

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## 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>	Hasler, Mike	Quality Assurance Inspector
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<b>Reviewed By:</b>	Cuellar, Robert	QA Reviewer
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