

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-002351**Date Inspected:** 27-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Yu Hong**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:** OBG**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna 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.

The QA inspector performed 5 % UT on the partial penetration weld (PJP) after ZPMC representative verifications were completed on the deck panel DP-328-002 weld joints 1 and 8. The QA inspector found similar results with ZPMC on the overall location and sizing of the areas identified with incomplete penetration. Several locations were identified with depth of penetration less than 80 % and a location with less than 70 % of depth of penetration.

See UT report TL\_6027 generated on this date.

The QA inspector witnessed ZPMC performing weld repairs at the junction of the U-ribs to the deck panels DP-061-001, DP-019-001, DP-060-001, DP-062-001, DP-013-001 and DP-064-001 at the Bay # 3, New Tower Shop. ZPMC was following the approved weld repair procedure for close ribs welds approved on the submittal ABF634 R01, letter 05.03.01-001773.

The QA inspector had a conversation with Warren Buehler. The QA inspector asked if it was any deck panels ready for Caltrans final examination. After asking to ZPMC QC representative Sun Wei, Mr. Buehler relayed that ZPMC completed deck panels DP-013-001 and DP-017-001. The QA inspector recommended ZPMC to mark the parts completed by QC ZPMC with the paint marker after ZPMC accept them. ZPMC agreed and marked the parts; when the QA inspector started his visual verifications, ABF and ZPMC representatives re-inspected the areas and found that the parts above mentioned needed more repairs. ZPMC informed the QA

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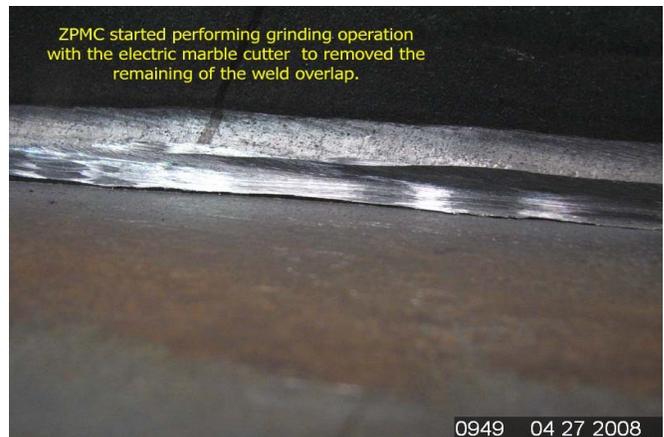
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inspectors that the deck panels were not ready for Caltrans.

On this date the QA inspector observed that ZPMC was performing grinding with the electric marble cutter to remove the remaining notch from the weld overlap. The overlap weld repairs were still in process at the end of the shift. See photograph below.



## Summary of Conversations:

As noted above.

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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>	Acuna,Alfredo	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer

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