

**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-002265**Date Inspected:** 05-May-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**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 Deck panels**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 15 % ultrasonic verifications (UT) on the partial penetration weld (PJP) after ZPMC representative verifications were completed on the deck panel DP-301-001 weld joints 1 and 6, DP-064-001 weld joint 1 and 8 and deck panel DP-054-001 weld joint #6 (partial examinations). Mr. Eric Prue continued the UT verification on this deck panel (see Eric Prue UT report generated on this date for more information). The QA inspector concurred with ZPMC on the overall location and sizing of the areas identified with incomplete penetration. Numerous locations with depth of penetration had less than 80% depth of penetration. See UT report TL\_6027 generated on this date.

**Summary of Conversations:**

The QA inspector had a conversation with ABF representative Warren Buelher. The QA inspector asked Mr. Warren Buelher about the resolution on the weld overlap and the weld undersize found on 05/04/08 on the deck panel DP-059-001. The QA inspector added that the panel DP-059-001 have already been accepted by ZPMC and sent to the Yard. Mr. Warren Buelher said that ABF would write an incident report because ZPMC proceed moving the panel without informing ABF or Caltrans after the completion of the weld repairs.

**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

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## WELDING INSPECTION REPORT

*( Continued Page 2 of 2 )*

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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
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<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer
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